



LT20D SERIES

OWNER'S & OPERATOR'S MANUAL

JUNE 1989

This manual is to replace or be used in conjunction with all previous information received on the Wood-Mizer®. All future mailings will be an addition to or a revision to individual sections of this manual as we obtain new information.

We sincerely hope this manual will take care of any questions, and help increase productivity with your lumbermill.

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.

My Customer Number is:

My Serial Number is:

If You Need To Order Parts...

From the continental U.S. and Canada, call our toll free service hotline at **1-(800) 525-8100**. In Indiana call (317) 271-1542. Please have your customer number and any other pertinent information (such as sawmill serial or model number) ready when you call. Because maintaining open accounts has only slowed our service to customers, Wood-Mizer® will accept only these three methods of payment:

Visa or Mastercard
COD (add \$4.00 COD charge)
Pre-payment

You should also be aware that there will be shipping charges on all orders not picked up. Shipping 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 is available if requested.

If You Need Service...

From the continental U.S. and Canada, call us toll free at **1-(800) 525-8100**. In Indiana call (317) 271-1542. Ask to speak with a service representative concerning your Wood-Mizer® sawmill. Please have your customer number and other pertinent information (such as sawmill serial or model number) ready when you call. The service representative can assist you with questions concerning alignment of your mill, blade sharpening, cutting a particular species of wood, or to schedule you for a service loop or seminar in your area.

Office Hours: *(All times Eastern Standard Time)*

Monday	8:00 a.m. to 9:00 p.m.
Tuesday	8:00 a.m. to 9:00 p.m.
Wednesday	8:00 a.m. to 9:00 p.m.
Thursday	8:00 a.m. to 9:00 p.m.
Friday	8:00 a.m. to 9:00 p.m.
Saturday	8:00 a.m. to 4:00 p.m.

WOOD-MIZER MANUAL INDEX.....LT20D SERIES

SECTION 1 - GENERAL INFORMATION

- 1.1 Warranty
- 1.2 Safety
- 1.3 Custom Sawing Guidelines
- 1.4 Sample Contract
- 1.5 Log, Tree, and Lumber Scales
- 1.6 Sawing Methods
- 1.7 Lumber Drying
- 1.8 Grading Lumber
- 1.9 Definitions

SECTION 2 - BLADES

- 2.1 Theory & Terminology
- 2.2 Coiling the Blade
- 2.3 Tooth Setter/Gauge
- 2.4 Sharpener
- 2.5 Automatic Sharpener Attachment
- 2.6 Maintenance and Care
- 2.7 Changing the Blade

SECTION 3 - OPERATING INSTRUCTIONS

- 3.1 Setup and Operation
- 3.2 Power Feed
- 3.3 Transporting Mill

SECTION 4 - MAINTENANCE

- 4.1 Schedule
- 4.2 Blade Guides
- 4.3 Chain Tensions
- 4.4 Throttle Adjustment
- 4.5 Brake Pad Adjustment

SECTION 5 - ALIGNMENT

- 5.1 Blade Alignment on Wheels
- 5.2 Blade Parallel with Bed Rails
- 5.3 Blade Guides
- 5.4 Side Supports
- 5.5 Auxiliary Bed Supports

SECTION 6 - SCHEMATICS & PARTS

- 6.1 Running Lights
- 6.2 Parts Illustrations and Lists

SECTION 7 - OPTIONS & ACCESSORIES

- 7.1 Water Lube
- 7.2 Log Turner
- 7.3 Shingle/Lap Siding Option
- 7.4 Toe Boards
- 7.5 Blade Guide Alignment Tool
- 7.6 Resaw Attachment

SECTION 8 - TROUBLE SHOOTING



General Information

Section 1-1	Warranty Information
Section 1-2	Safety
Section 1-3	Custom Sawing Guidelines
Section 1-4	Sample Contract
Section 1-5	Log, Tree, and Lumber Scales
Section 1-6	Sawing Methods
Section 1-7	Lumber Drying
Section 1-8	Grading Lumber
Section 1-9	Definitions

SECTION 1-1: WARRANTY INFORMATION

WOOD-MIZER® PRODUCTS, INC., (Seller), an Indiana Corporation, with principal place of business at 8180 West 10th Street, Indianapolis, Indiana 46214-2430, phone (317) 271-1542, hereby warrants the WOOD-MIZER® sawmill to the original Buyer only.

15-DAY SALE OR RETURN MONEY-BACK GUARANTEE

Within fifteen (15) days after delivery if Buyer is not completely satisfied with the WOOD-MIZER® Sawmill, Buyer may notify Seller for a full refund of the purchase price (used saw blades and damaged parts excepted) and re-transfer ownership to Seller upon return of the WOOD-MIZER®, shipping pre-paid by Buyer. Buyer retains risk of loss during such period and until re-delivered to Seller.

LIMITED WARRANTY

The warranty period commences with the date of delivery of the WOOD-MIZER® Sawmill to the original Buyer and expires ninety (90) days from that date for electrical and moving parts and one (1) year from that date for non-moving, except for main drive motor/engine, winch, tires, axle, battery, and battery charger (which exceptions are warranted by their respective manufacturers). **SELLER DISCLAIMS ANY WARRANTY WHATSOEVER, WHETHER EXPRESS OR IMPLIED, FOR BELTS AND SAW BLADES, AND BUYER PURCHASES ALL SAW BLADES "AS IS" AND "WITH ALL FAULTS", AND NO WARRANTIES OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE TO BE IMPLIED.**

During such warranty period Seller warrants to the original Buyer that the WOOD-MIZER® Sawmill is manufactured and delivered in accordance with Seller's published specifications for the equipment at the time of sale and that the WOOD-MIZER® shall be free of defects in material and workmanship. The sole liability and responsibility of Seller shall be to replace or repair, at Seller's principal place of business in Indianapolis, Indiana, (or at such other location approved by Seller and at Seller's sole discretion) free of charge including related labor, any defective part, and repair of defective workmanship. Buyer shall pay shipping costs. Correction of any non-conforming part, in the manner and for the period of time provided above, shall constitute fulfillment of all liabilities of Seller to Buyer, whether based on contract, negligence, or otherwise with respect to, or arising out of such equipment.

To obtain return shipping information or information on warranty performance, call Customer Service at 1-800/553-0182 from the continental U.S., Hawaii, and Canada; call 317/271-1542 from other locations.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ANY OTHER EXPRESS OR IMPLIED WARRANTIES INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, EXCEPT AS TO TITLE. Any description, photograph, sample or model of the equipment used as a sales aid shall not extend to create any warranty, the Seller's warranties being specifically restricted to the published specifications for the WOOD-MIZER® at any time of purchase. No Dealer or Agent has the authority to bind Seller other than to the published specifications for the WOOD-MIZER® at any time of purchase. No verbal statement or promise made by a Dealer or agent or by the Seller shall constitute grounds for special, indirect, or consequential damages. The remedies set forth herein are exclusive, and the liability of Seller with respect to any contract or sale or anything done in connection therewith, whether in contract of the equipment or part on which such liability is based. **SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS OR THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATIONS OR EXCLUSIONS MAY NOT APPLY TO YOU.**

(Cont'd)

SECTION 1-1: WARRANTY INFORMATION - cont'd

Seller shall have no obligation under this warranty in the event the WOOD-MIZER® is damaged in transit by common carrier, is overloaded, is abused, is not used in conformity with the directions accompanying the equipment or if the equipment is modified.

SELLER SPECIFICALLY DOES NOT WARRANT THAT THE EQUIPMENT SHALL MEET OR COMPLY WITH THE REQUIREMENTS OF ANY PARTICULAR SAFETY CODE OR REGULATIONS OF ANY STATE, MUNICIPALITY, OR OTHER JURISDICTION. This warranty gives the Buyer specific legal rights, and the Buyer may also have other rights which vary from state to state.

ACCEPTANCE: _____

SELLER: _____

WOOD-MIZER® EXTENDED WARRANTY FOR PURCHASE OF TRADE-IN REPLACEMENT PARTS

Upon expiration of the stated Warranty periods for the Wood-Mizer® Lumbermill, owners thereof shall have the right to trade in worn or damaged parts and purchase replacement parts at 50% of the published retail price for such parts, on the following conditions:

1. Trade-in replacement parts shall be for Wood-Mizer® owner use only and shall not be re-sold or supplied to non-Wood-Mizer® owners.
2. The 50% replacement cost is based upon a trade-in value of worn or damaged parts. Upon request of Wood-Mizer® Products, Inc., the worn or damaged parts shall be returned to the company. The company shall have the right to request trade-in parts to be returned to its plant in Indianapolis, Indiana prior to shipping out of new replacement parts. In the event the company does not request trade-in parts to be returned prior to shipping, such worn or damaged parts shall be retained for ninety (90) days by the owner prior to disposal. The company shall not be responsible for any storage charges for the storage of trade-in parts retained by the owner.
3. Shipping costs for return of trade-in parts shall be at the owner's sole expense.
4. The Company shall have the right to change the published retail price at any time without notice. It is understood that the granting of this extended Warranty for purchase of replacement parts is not and does not extend or modify any other existing Warranty whatsoever, whether expressed or implied, for the Wood-Mizer® or any accessory products or replacement parts therefore.

Wood-Mizer® Products, Inc.

By: _____

SECTION 1-2: SAFETY

THE SAFETY TIPS AND WARNINGS LISTED BELOW SHOULD BE OBSERVED AT ALL TIMES. READ AND UNDERSTAND ALL SAFETY INSTRUCTIONS BEFORE YOU OPERATE THE MILL!

TURN ENGINE OFF AND LET WHEELS COME TO A STOP:

- 1) Before removing any covers or guards.
- 2) Before adjusting the blade guides.
- 3) Before changing the blade.
- 4) Before refilling gas tank.
- 5) Before making any type of carriage adjustments.
- 6) Before rotating a log.

DISENGAGE CLUTCH MECHANISM:

- 1) After each cut.
- 2) Before adjusting throat width.
- 3) Before returning the bandsaw carriage.

ALWAYS:

Wear eye protection and avoid wearing loose clothing while operating mill.

Raise side support braces when rolling log onto bed.

Position mill on flat, level surface. Level mill before operating.

Disengage clutch after each cut is completed.

Adjust outer blade guide to a 1" clearance or less between the guide and log.

When rolling a log onto bed, keep the area behind the log clear of people.

Change the blade with one person only.

Clamp log firmly in place before cutting.

Keep all observers a safe distance from work areas.

Do not operate gasoline engines in confined spaces.

Store gasoline away from sawdust and other flammable materials.



SECTION 1-3: CUSTOM SAWING GUIDELINES

The most common question asked by new Wood-Mizer owners concerns what you charge when sawing for someone. Although there is no single answer to this question, there are some guidelines to follow that may help. Each region is going to vary as to the going price to have wood sawn, size and species of available timber, and amount of sawing business available. The following guidelines aren't intended to cover all situations, but are offered to help in understanding some different pricing approaches.

PRICING BY THE HOUR OR DAY

Many owners use this method to charge for their sawing. The obvious advantage of this approach is that your income doesn't change with each type of cutting job. If you are cutting difficult wood or set up at a location that doesn't allow efficient handling of logs and finished lumber, the risk of low production rates is passed on to the customer. Your hourly rate remains fixed so the lower production won't affect your income. Many of the owners using this hourly method require their customer to supply the manpower to handle all logs and lumber. If the customer wants higher production, he simply supplies more manpower or equipment to increase output. The owner is simply there to operate the mill. This places most of the burden on the person having the wood cut. Rates vary in different areas from \$15.00 to \$30.00 per hour. Some charge a delivery fee based on miles to the site for mill set-up.

MILL RENTAL OR LEASE

Some Wood-Mizer owners rent or lease their mill for people to do their own cutting. The advantage in this case, is that the mill can generate income without requiring any of the owner's time. Things to be cautious about are the competency of the person using the mill, possible legal liability if someone is injured using the mill, and possible damage to the mill when being used by inexperienced operators. Rental rates vary from \$10.00 to \$20.00 per hour. Blades can be sold in addition. We do not recommend this method.

PRICING BY THE BOARD FOOT OR VOLUME

This is the most common pricing approach in the logging industry. It's main advantage goes to the person wanting the lumber cut. His price is fixed no matter what the production rates are. Rates can vary from under \$.10 per foot to over \$.25 per foot. The equation for how much you earn is simple--the more you cut, the more you make. The actual amount you make can be affected by many factors which make that equation much more difficult. The type or species of the logs, the length of time they have been down, the condition of the logs, the cutting location, and the size of the logs and thickness of lumber the customer requests will affect your production rate. Each of these factors is important enough to consider individually.

The length of time the logs have been down will also affect the rate at which you can produce. Generally, the longer wood has been down, the harder it is to cut. Because of this, it is good to find out how long the timber has been down as well as the species before quoting. The condition of the logs can also affect the production rate. Logs that have been dragged over rocks and mud will require additional time to debark or clean. If you cut through the mud, your blade will dull in just a few minutes. A premium per board foot or an hourly rate should be charged to clean the logs. You could also refuse to cut mud-laden logs.

The cutting location is important. Your price should be based on a set-up where you can simply roll or load logs onto the mill without moving the mill. If you are required to move the mill several times in a day, you should be able to charge a fixed amount per move. Some operators charge \$5.00 per move.

The amount of wood to be cut should be considered when pricing. If a customer had only two logs, a premium should be expected. Some operators charge a premium of a few cents per foot for any job less than 1000 board feet. A minimum fee can be established on small jobs.

The size of the logs you plan to cut should be a factor in pricing. Large diameter logs can take extra time to handle by hand. Having to stop to trim side limbs or large flares at the butt can greatly reduce total output. Too small a log can involve too much handling for the total yield it produces.

SECTION 1-3: CUSTOM SAWING GUIDELINES - cont'd

PRICING BY THE BOARD FOOT OR VOLUME - cont'd

The size of lumber the customer requests can cause you to more than triple the number of cuts you would need to make to get the same volume of wood. This is true with cutting 1x4s vs. 2x12s. Some mill owners charge a certain price for 1" or 2" boards. Very wide boards require much more time to cut than narrower widths. The feed rate for a cut of 24" is less than 5' per minute and takes more time and runs more risk of wavy cuts than cutting thru boards that are 8" wide at a feed rate of 20' or more per minute.

The Wood-Mizer has several advantages over circular mills and when pricing your sawing you should take advantage of them. Many Wood-Mizer owners get premiums over the going rates in the area by selling these advantages. Recognize that a \$4,000-13,000 mill can't compete in the area of output per day with a \$100,000 mill operation. Where you can compete (and beat) the big mills is in portability, lumber quality, versatility, and total yield of usable lumber per log.

PORTABILITY

The money your customer can save in not having to haul his lumber to the mill can let you charge a few cents more per board foot than the large mills. Be sure that this savings is used to your advantage, either to secure a cutting job or to get a premium for saving the customer a hauling bill. In Indiana, average hauling costs within 30-40 miles of the mill is \$40.00/MBF (\$.04 per board foot).

LUMBER QUALITY AND ACCURACY

The surface texture of a board cut on a Wood-Mizer is far smoother than on a circular mill. A good sawyer can get finished framing lumber directly off the mill. The more accurately any mill cuts, the less you need to oversize your cuts to assure a given finished dimension.

LUMBER SIZE CAPABILITIES

The Wood-Mizer lets you cut 1/2" lumber for paneling with less overall log waste than most mills cutting 2" lumber. The LTSLR option lets you cut shingles and lap siding (weatherboard). The Wood-Mizer can also resaw large timbers into accurately-sized dimensional lumber. These capabilities are very significant advantages.

YIELD PER LOG

The Wood-Mizer's high yield of usable lumber per log is one of its most important and sometimes most overlooked advantages. This higher yield has an easy-to-calculate real cost savings for every log cut. A 14" to 18" diameter log measured by Doyle Scale when cutting with the Wood-Mizer will consistently produce as much as 50% over scale. This can allow you to charge a much higher rate than a large mill and still have the same net cost as the larger mill per finished board foot. It is actually possible to charge twice the rate as some mills and still save a customer money. An equation to calculate the cutting rate you can charge so the net cost per board foot is the same as the different mills is:

$$\left(\frac{VL \times 1}{1 + ERC} \right) + CR + HF - \left(\frac{VL \times 1}{1 + ER} \right) = WR$$

Where:

VL = Value of the lumber in log form

ERC = Efficiency Rate of Competitor (Amount of usable lumber over scale the competitor's mill will cut)

CR = Competitor's Rate (Rate that the competitor's mill charges)

HF = Hauling Fee to the mill

ERW = Efficiency Rate of Wood-Mizer (Amount of usable lumber over scale the Wood-Mizer will cut)

WR = Wood-Mizer Rate (Rate that you can charge to have the same net cost per board foot as the competitor's mill)

This equation looks quite involved but can be easily calculated when you fill in actual values.

SECTION 1-3: CUSTOM SAWING GUIDELINES - cont'd

YIELD PER LOG -cont'd

For example: A customer has some prime poplar logs valued at \$0.25 per board foot (\$250.00 per thousand). He can have lumber sawed at circular mill at \$0.10 per board foot that cuts approximately 10 to 15% over scale (i.e., for every 1000 board foot by Doyle scale, the mill cuts 1100 to 1150 usable board foot of lumber). The hauling fee within 30 miles of the mill is \$0.04 per board foot. Most Wood-Mizer operations cut 50% over Doyle scale on logs under 20" in diameter. Given these figures, the equation will tell you what you could charge for cutting so the net cost per board foot is the same as the circular mills.

$$\begin{aligned} (.25 \times .87) + .10 + .04 - (.25 \times .67) &= \text{rate} \\ .218 + .10 + .04 - .190 &= \text{rate} \\ .168 \text{ rate} &= \$0.168 \end{aligned}$$

This means that you can charge 16.8 cents per board foot for the lumber you cut and the customer's cost is no more than if he had it hauled into a circular mill and cut at 10 cents per board foot. The reason for this is that you can cut half again as much usable lumber as the scale volume compared to the 25% of the circular mill.

For example: If he pays \$250.00 for 1,000 scaled board foot in log form, you can give him 1,500 board foot of usable lumber from those logs. This essentially cuts the price he is paying for his lumber by 30-40%! Because of this difference in efficiency, you should easily be able to get a higher cutting rate than the larger mills.

It isn't our intention in this example to advise you to charge the 16.8 cents board foot fee for cutting. In this example you could possibly charge a rate of 15 cents and essentially pass on the difference of 1.8 cents per board foot to the customer. Even when cutting pine worth 10 cents a board foot, you can compete at over 15 cents per board foot versus 10 cents of a large mill, when you calculate the savings in efficiency and hauling costs. Anything less than the 15 cents board foot is money you are putting in the customer's pocket.

One thing to consider when looking at the efficiency of the Wood-Mizer is that your advantages increase as the value of the logs increase. If you have poplar worth 20 cents per board foot, you cut the net cost of the lumber 30-40% by giving him 50% of the scaled volume in usable lumber when cut. This is essentially an 8 cent board foot savings. If the wood were oak valued at 50 cents per board foot, you could cut his cost by 20 cents a board foot; walnut valued at \$1.00 per board foot would reduce cost by 40 cents, and so on. When cutting by volume or board foot, **always charge for the amount of usable wood produced, rather than scale volume.** If you charge by scale volume, every board foot you cut past scale you are cutting for free. If you determine your volume by output, reduce risks of low-volume days by knowing what and when you cut, and always charge something for the additional factors that reduce your production, cutting by volume can be a profitable venture.

SAWING FOR A PERCENTAGE OF THE WOOD YOU CUT

This can be a good way to charge for your sawing, but it will not bring in money unless you have a ready market for the wood you cut. Cutting this way essentially makes you a small-scale lumber yard. If you can sell your lumber at a good price, this can be a very profitable arrangement. Percentage you keep as a sawyer can range from 25-50% depending on species and region.

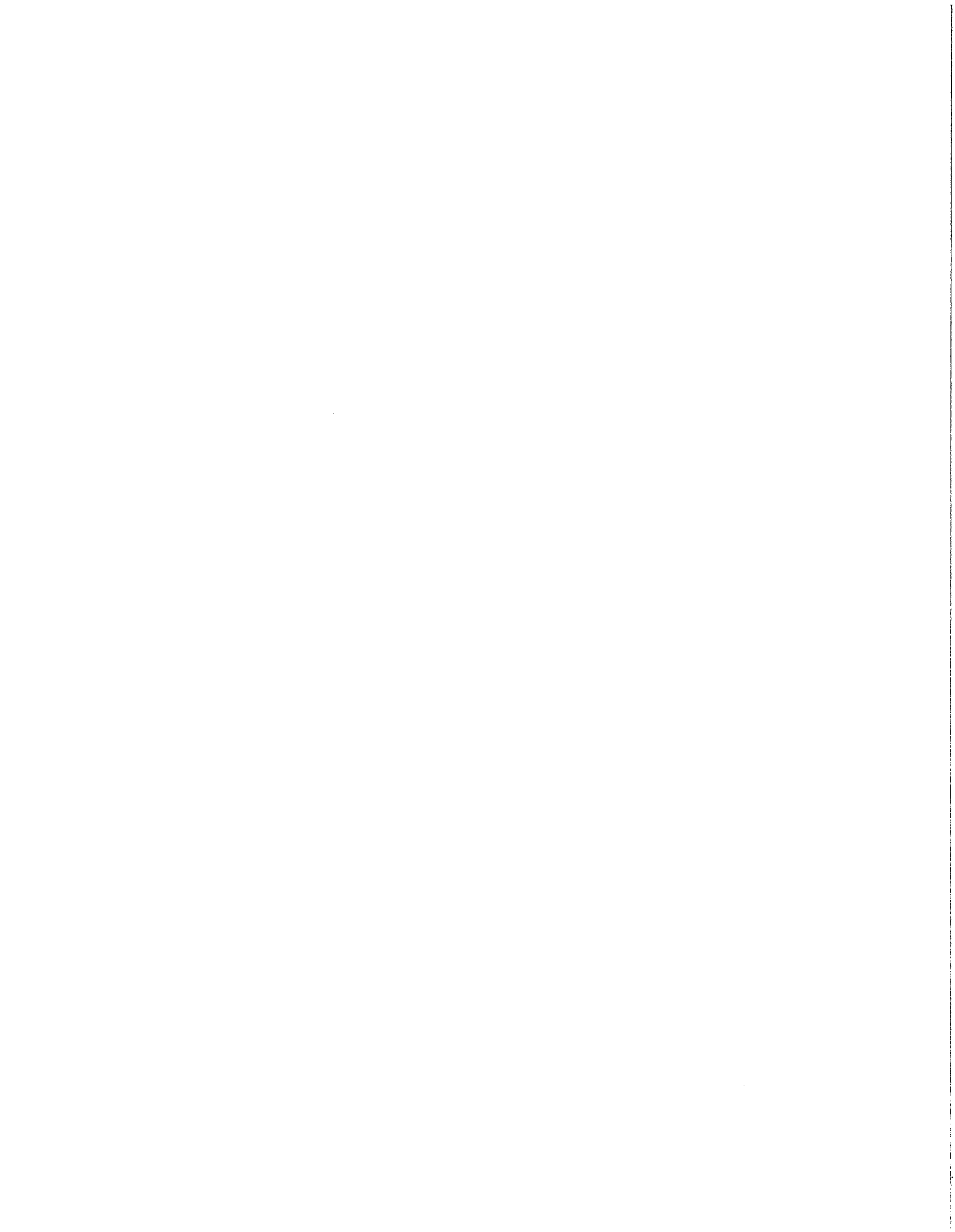
COMBINATION PRICING

One key to securing more cutting jobs is to be flexible in your pricing. A customer who owns a substantial amount of standing timber may not be concerned about the higher yields from the Wood-Mizer. In this instance, he may be willing to let you cut at the current large mill rate and keep some of the over-run lumber.

There may be certain jobs or wood types that you may want to cut on an hourly rate instead of a board foot rate. You may also charge more or less per foot depending on how much labor the customer supplies. A combination of several pricing approaches may be what will work best in your operation.

A few points to remember:

- If you price by the day, establish a rate that will leave you the income you want after expenses.*
- If you rent your mill, know the people who use it and be sure they are properly trained.*
- If you price by the board foot, use the high yield, portability, cutting versatility, and surface texture to get the highest rate possible for your region. Be conscious of all factors that can reduce output and charge accordingly.*



SECTION 1-4: SAMPLE CONTRACT

THIS AGREEMENT, by and between _____ (Sawyer),
and _____ (Customer),
with the Wood-Mizer® one-man sawmill as follows:

1. Sawyer agrees to cut customers log at: Customer's site _____ or Sawyer's property _____; for \$ _____ per hundred board foot of lumber cut. Charges are based on actual lumber cut rather than scaled volume. (Note: net usable lumber will be greater than scale when cut with the Wood-Mizer®.) A board foot of lumber is defined as 12"x12"x1".
2. In addition to above, Customer shall pay Sawyer \$ _____ for delivery and location setup of Wood-Mizer®. Also, if Sawyer is required to relocate Wood-Mizer® on site, there shall be an additional charge of \$ _____ per move. In the event a saw blade is broken or damaged by foreign matter (nail, rock, metal, etc.) in Customer's log, there is a charge of \$ _____ per damaged blade.
3. Sawyer will arrive at Customer's location at _____ o'clock _____ .M., on _____, 19____ to start operation. Customer agrees to provide _____ men to assist in loading and unloading logs and lumber. All logs shall be stacked in location of mill so that there can be continuous loading of mill by rolling logs up the mill ramp without moving mill. Lumber shall be stacked at mill location to allow continuous cutting operation.
4. Other Charges: _____
5. Payment in full shall be made as follows: _____
6. It is understood by the Customer that log handling and cutting may be hazardous. Customer shall be responsible for conduct of helpers and observers and agrees to hold Sawyer and the Wood-Mizer® Lumbermill manufacturer harmless for any injury or damage whatsoever to helpers or observers arising out of operation of the mill and the handling of logs and lumber. It shall be Customer's duty and obligation to keep all children and observers out of the work area. Customer represents that he is the owner of the logs and/or has the authority to enter into this Agreement on behalf of all interested parties.

Dated this _____ day of _____, 19_____.

Sawyer:

Customer:



SECTION 1-5: LOG SCALES

Log scales are measurements that indicate the amount of lumber in a log. The measurement is indicated in board feet, with one board foot being a piece of lumber 1" thick, 12" wide, and 1' long (a 12" square of wood that is 1" thick). All board-foot log rules give the estimated volume of the log in board feet for a specified diameter and length. A log that is 12" in diameter by 7' long has less lumber in it than a log that is 12" in diameter by 13' long. A board-foot log rule tells you how many board feet of lumber is in each log.

The three most well-known rules are International, Scribner Decimal C, and Doyle Log Rules. There is also a Spaulding or Columbia Log Rule that approximates the value of the Scribner Decimal C Log Rule. Each of these scales uses a different formula to calculate the same thing -- the amount of lumber in a log. The scales amount varies from one scale to another because of the different formulas used to calculate the volumes.

LUMBER SCALE

THICKNESS AND WIDTH	LENGTH OF BOARD IN FEET					
	6	8	10	12	14	16
1 x 3	1.5	2	2.5	3	3.5	4
1 x 4	2	2.6	3.3	4	4.6	5.3
1 x 5	2.5	3.3	4	5	6	6.6
1 x 6	3	4	5	6	7	8
1 x 7	3.5	4.6	6	7	8	9.3
1 x 8	4	5.3	6.6	8	9.3	10.6
1 x 10	5	6.6	8.3	10	11.6	13.3
1 x 12	6	8	10	12	14	16
2 x 4	4	5.3	6.6	8	9.3	10.6
2 x 6	6	8	10	12	14	16
2 x 8	8	10.6	13.3	16	18.6	21.3
2 x 10	10	13.3	16.6	20	23.3	26.6
2 x 12	12	16	20	24	28	32
2 x 14	14	18.6	23.3	28	32.6	37.3
3 x 6	9	12	15	18	21	24
3 x 8	12	16	20	24	28	32
3 x 10	15	20	25	30	35	40
3 x 12	18	24	30	36	42	48
4 x 4	8	10.6	13.3	16	18.6	21.3
6 x 6	18	24	30	36	42	48

LOG & LUMBER SCALE

INTERNATIONAL 1/4 INCH LOG RULE

DIB* (small end)	BOARD FEET PER LENGTH BELOW					
	6'	8'	10'	12'	14'	16'
6	5	10	10	15	15	20
7	10	10	15	20	25	30
8	10	15	20	25	35	40
9	15	20	30	35	45	50
10	20	30	35	45	55	65
11	25	35	45	55	70	80
12	30	45	55	70	85	95
13	40	55	70	85	100	115
14	45	65	80	100	115	135
15	55	75	95	115	135	160
16	60	85	110	130	155	180
17	70	95	125	150	180	205
18	80	110	140	170	200	230
19	90	125	155	190	225	260
20	100	135	175	210	250	290
21	115	155	195	235	280	320
22	125	170	215	260	305	355
23	140	185	235	285	335	390
24	150	205	255	310	370	425
25	165	220	280	340	400	460
26	180	240	305	370	435	500
27	195	260	330	400	470	540
28	210	280	355	430	510	585
29	225	305	385	465	545	630
30	245	325	410	495	585	67

*DIAMETER INSIDE BARK

The Doyle Rule is generally used on commercial operations in the Eastern and Southern States. The Scribner Rule, or the Scribner Decimal C Rule, is used by the U.S. Forestry Service and other federal agencies, numerous scaling bureaus, and many private operators. The International Rule is used to some extent by the U.S. Forestry Service and some private operators. It is important to note that all rules give the approximate volume of lumber in a log and that there are also a series of specific rules for deducting volume for defects like crooks, sweeps, and knots. Remember, the Wood-Mizer will get significantly more lumber (sometimes up to 30% more) than a scale will indicate because most scales are based on the 1/4" saw kerf of larger circular mills.

All log rules use two measurements to determine volume. The first is overall length. The second measurement is the "DIB", the Diameter Inside the Bark on the small end of the log. On a round log this is the width of the small end just inside the bark. On an oval log you measure the widest and the narrowest directions and take their average (i.e., if the small end of a log is oval-shaped and measures 18" at the widest point and 12" at the narrowest point, the scale DIB is $(18 + 12) / 2 = 15"$).

SECTION 1-5: Log, Tree, & Lumber Scales - cont'd

LOG & LUMBER SCALE

DOYLE SCALE

Once you have the two measurements, you can use the scale to determine volume. You locate the DIB in the left-hand scale and that line of numbers indicates the amount of lumber for different length logs. Each column is marked underneath with a log length. You match the DIB line with the column for the log length and that number is the volume in board feet.

EXAMPLE: If a log is 12' long and the DIB (diameter measured inside the bark on the small end) is 14", the Doyle Scale volume is 75 bd ft (board feet); the International Scale volume is 100 bd ft; the Scribner Decimal C Scale volume is 90 bd ft*.

*The value on the Scribner Decimal C Scale needs to be multiplied by 10 to give you volume in board feet.

DIB* (small end)	BOARD FEET PER LENGTH BELOW					
	6'	8'	10'	12'	14'	16'
6	2	2	3	3	4	4
7	3	5	6	7	8	9
8	6	8	10	12	14	16
9	9	13	16	19	22	25
10	14	18	23	27	32	36
11	18	25	31	37	43	49
12	24	32	40	48	56	64
13	30	41	51	61	71	81
14	38	50	63	75	88	100
15	45	61	76	91	106	121
16	54	72	90	108	126	144
17	63	85	106	127	148	169
18	74	98	123	147	172	196
19	84	113	141	169	197	225
20	96	128	160	192	224	256
21	108	145	181	217	253	289
22	122	162	203	243	284	324
23	135	181	226	271	316	361
24	150	200	250	300	350	400
25	165	221	276	331	386	441
26	182	242	303	363	424	484
27	198	265	331	397	463	529
28	216	288	360	432	504	576
29	234	313	391	469	547	625
30	254	338	423	507	592	676

TREE SCALE

DOYLE LOG RULE

DAG*	%	NUMBER OF 16 FOOT LOGS IN TREE							
		1	1½	2	2½	3	3½	4	
12	20	30	40	50	60	-	-	-	
14	30	50	70	80	90	100	-	-	
16	40	70	100	120	140	160	180	190	
18	60	100	130	160	200	220	240	260	
20	80	130	180	220	260	300	320	360	
22	100	170	230	280	340	380	420	460	
24	130	220	290	360	430	490	540	600	
26	160	260	360	440	520	590	660	740	
28	190	320	430	520	620	710	800	880	
30	230	380	510	630	740	840	940	1040	
32	270	440	590	730	860	990	1120	1220	
34	300	510	680	850	1000	1140	1300	1440	
36	350	580	780	970	1140	1310	1480	1640	
38	390	660	880	1100	1290	1480	1680	1860	
40	430	740	990	1230	1450	1660	1880	2080	
42	470	830	1100	1370	1620	1860	2100	2320	

* DIAMETER 4'-6" ABOVE GROUND

TO ESTIMATE TREE VOLUME

1. Determine tree diameter in inches at 4½ ft. above ground.
2. Determine usable length in feet from stump height to large branches.

TREE SCALE

INTERNATIONAL ¼ INCH LOG RULE

DAG*	%	NUMBER OF 16 FOOT LOGS IN TREE							
		1	1½	2	2½	3	3½	4	
12	30	60	80	100	120	-	-	-	
14	40	80	110	140	160	180	-	-	
16	60	100	150	180	210	250	280	310	
18	70	140	190	240	280	320	360	400	
20	90	170	240	300	350	400	450	500	
22	110	210	290	360	430	490	560	610	
24	130	250	350	430	510	590	660	740	
26	160	300	410	510	600	700	790	880	
28	190	350	480	600	700	810	920	1020	
30	220	410	550	690	810	930	1060	1160	
32	260	470	640	790	940	1080	1220	1360	
34	290	530	730	900	1060	1220	1380	1540	
36	330	600	820	1010	1200	1380	1560	1740	
38	370	670	910	1130	1340	1560	1840	1940	
40	420	740	1010	1250	1480	1700	1920	2160	
42	460	820	1100	1360	1610	1870	2120	2360	

* DIAMETER 4'-6" ABOVE GROUND

TO ESTIMATE TREE VOLUME

1. Determine tree diameter in inches at 4½ ft. above ground.
2. Determine usable length in feet from stump height to large branches.

SECTION 1-6: LOG SAWING AND DRYING TIPS

QUARTERSAWING

Although most people know of the term quartersawing, many do not know what it means. This section will define what quartersawing is, why and when quartersawing should be done, and how to quartersaw on a Wood-Mizer.

The Society of American Foresters defines quartersawed as "timber converted so that the growth layers meet the face of any part at an angle not less than 45 degrees. When the angle is not less than 80 degrees, the timber is termed fully quartersawn". This technical definition is one reason that the term is confusing to many people new to sawing. In simpler terms, this means that a fully quartersawn board has growth rings that are approximately perpendicular to the face of the board (See Figure 1-1). The board is still considered quartersawn as long as the growth rings aren't less than 45 degrees to the face of the board (See Figure 1-2).

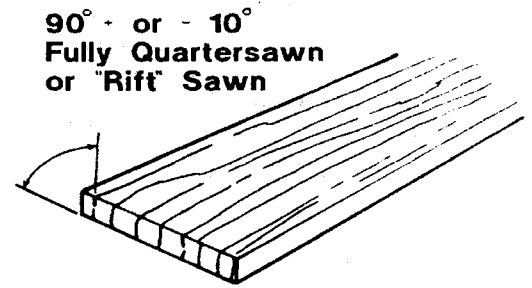


FIG 1-1

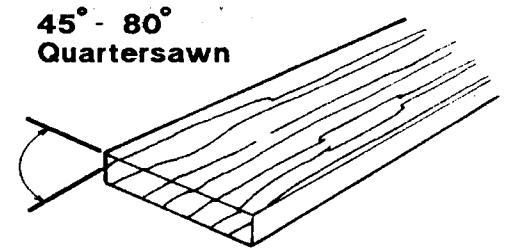


FIG 1-2

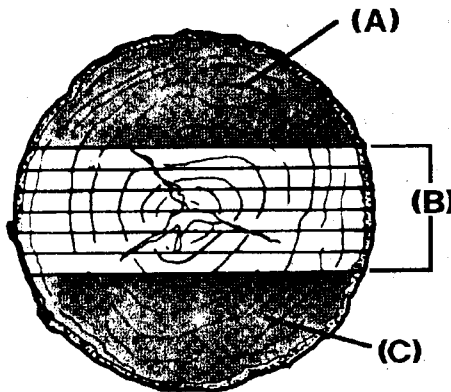


FIG 1-3

There are several reasons to consider quartersawing your lumber. In certain hardwoods, the grain patterns found are in high demand. Quartersawn oak has a very distinct grain pattern and is more valuable than plainsawn oak. Quartersawn wood is also more dimensionally sound and will not cup or dish while drying, and will shrink less than plainsawn boards. For these reasons most cabinet makers, quality furniture shops, and craftsmen prefer quartersawn boards.

Not all lumber will increase in value when quartersawn. Because of this, the added handling and time involved should be weighed against the added value of the quartersawn lumber. Quartersawing framing lumber isn't normally suggested. Quartersawing furniture grade hardwoods is suggested.

We have found commercial quartersawing of logs to be simple and fast on the Wood-Mizer. Judgement as to where the first cut

should be made depends on the shape of the log (oval, square, or round) and, as such, is arbitrary. The following example is our recommended approach to quartersawing on the Wood-Mizer.

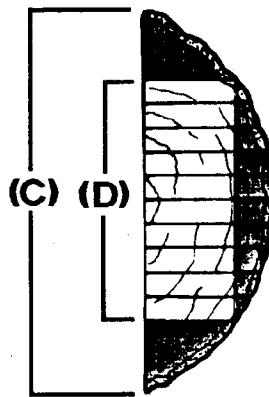


FIG 1-4

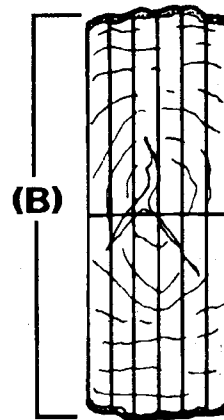


FIG 1-5

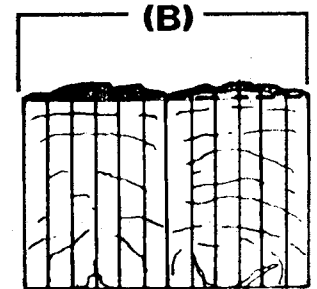


FIG 1-6

Figure 1-3 shows an end view of a log we will say is 17 inches in diameter. The first cut is made 11 1/2 inches above the bed. The top cant (A) is laid to the side and six cuts of one inch (B) are made and those boards are laid aside. The remaining cant (C) is rotated 90 degrees (See Figure 1-4) and boards are cut starting 13 inches above the bed down to 3 inches (boards D). These boards are acceptable as commercial grade quartersawn lumber. The two boards above and below are plain sawed. The boards (D) are then placed vertical and edged. Cant (A) is processed in like manner. Boards (B) are then mounted vertically, sliced through the center (Figure 1-5), and edged (Figure 1-6). Using this approach, 60 to 70 percent of a good log can be converted into the most valuable of lumber, rapidly and effectively.

SECTION 1-6: LOG SAWING AND DRYING TIPS - cont'd

LUMBER VOLUME AND SIZING

An important step in cutting lumber is to determine the correct size. Lumber is normally sold according to its *nominal* size, which indicates the dimensions of the rough lumber in inches (1x2, 2x4, etc.). The first dimension is the thickness of the board and the second, its width. After a board has been surfaced with a planer on all sides and dried, it will then be the *actual* size. For instance, the actual size of a 2x4 is 1 1/2 x 3 1/2 inches.

When you are cutting framing lumber you should be able to cut its actual size (1 1/2 x 3 1/2 for a 2x4) directly on the mill to avoid any planing to size. You may want to allow an over cut of approximately 10% for shrinkage when dried.

The chart below compares nominal and actual size of most common sizes.

NOMINAL AND ACTUAL SIZES OF LUMBER (IN INCHES)	
NOMINAL SIZE	ACTUAL SIZE
1 X 2	25/32 X 1 5/8
2 X 2	1 5/8 X 1 5/8
1 X 3	25/32 X 2 5/8
2 X 3	1 5/8 X 2 5/8
1 X 4	25/32 X 3 5/8
2 X 4	1 5/8 X 3 5/8
1 X 5	25/32 X 4 5/8
1 X 6	25/32 X 5 5/8
2 X 6	1 5/8 X 5 5/8
1 X 8	25/32 X 7 1/2
1 X 10	25/32 X 9 1/2
2 X 10	1 5/8 X 9 1/2
1 X 12	25/32 X 11 1/2
2 X 12	1 5/8 X 11 1/2

Circular mills cut 1" hardwoods to be planed to 3/4". You can cut 15/16" lumber by dropping the carriage a full inch for each board (15/16" board and 1/16" saw kerf = 1" drop) and you should easily be able to get a planed 3/4" board. This is because the surface texture and accuracy are better with the Wood-Mizer.

VOLUME

Lumber is commonly sold by the board foot. This unit is actually a calculation of volume. To find the number of board feet in a board, multiply the nominal thickness times the nominal width times the actual length in feet. This product is then divided by 12. Thus, a one-foot-long 1x12 and a two-foot-long 1x6 would both be sold as one board foot.

SECTION 1-7: LUMBER DRYING

GENERAL WOOD CHARACTERISTICS

As with any sawmill, the ultimate value of your lumber depends greatly on what happens to the boards after they are cut. The amount of damage or "de-grade" the lumber will have is affected by many factors. By far the most important of these is drying.

The two most common methods of drying wood are *kiln-drying* and *air-drying*. The kiln-drying process involves drying lumber in a closed chamber. Wood is dried to a given level by a carefully controlled combination of heat, relative humidity and air circulation. Wood-Mizer produces several sizes of solar type kilns and a 2,000 bd. ft. capacity vacuum type kiln that allows the small business to dry wood quickly and practically through a unique method of drying wood.

VACUUM KILN DRYING

Kiln-drying wood with the Model 2000 Vacu-Kiln is a new method that creates whole new approaches and options for the wood supplier. The following is a brief explanation of how the Model 2000 works, stated as simply as possible.

First, picture yourself as a small, single molecule of water in vaporous (steam) form. Now picture yourself inside a cell of wood. You would find yourself in what appears to be a tremendous cavern with huge tunnels interconnecting to other caverns. The wall of these caverns (which are walls of the wood cells) appear as a sieve with large openings...large enough that you can crawl through them into the adjoining caverns.

This gives you an idea of the size of a single molecule of water in relationship to wood. This is important, as the principle for drying in the Model 2000 Vacu-Kiln is centered primarily around drying of moisture through vaporous form. Water is one of the few elements which will exist in this very tiny form when heated above its boiling point. Below its boiling point, it has an affinity (tremendous attraction) to other molecules of water (cohesion) and to other substances such as wood fibers, etc. (adhesion).

Once one recognizes that the cellular structure of wood is not a significant barrier to the flow of water in its vaporous (steam) form, the principle of this type of drying is simple to understand. This also explains why vacuum-drying is so much faster than air and conventional kiln drying (approximately 10 times faster than conventional means).

There is only one reason for using vacuum in our process -- reducing the boiling point of water. At sea level, water boils at 212 degrees F. Denver, Colorado is a mile high (reduced atmosphere) and water boils there at about 180 degrees F. As the atmospheric conditions get rarer and rarer and come closer and closer to a complete vacuum, the boiling point of water drops to lower and lower temperatures. In the Model 2000 Vacu-Kiln, the vacuum is capable of reducing atmosphere to a point that water will boil at about 90 degrees F.

We believe it is desirable in wood-drying to keep the wood fibers at temperatures similar to those in which they grow. By reducing the boiling point of water to the rang of 90 degrees F, the Model 2000 allows the rapid drying process in vaporous form to occur with minimal damage to the wood fibers.

The drying process is accomplished by adding heat through layers of thin heating blankets between which layers of wood are stacked, bringing the temperature of the wood to a point higher than boiling, and then allowing the boiling vapors to escape from the wood. These vapors then condense back into liquid form on the interior of the kiln walls. The rate at which heat is added to the wood and the rate at which steam is boiled out of the wood are controlled by microprocessing circuitry. The microprocessor is completely field-programmable and allows the operator to rapidly schedule the drying rate required for the specific species and thickness of wood being dried.

This all adds up to a self-contained, 2000 board foot capacity, vacuum dry kiln designed to rapidly dry thick stock with low degrade levels. The drying time of the Model 2000 is 1/10th that of most conventional kilns. The unit dries 4/4 red oak from green to 7% moisture content in approximately 3 days, 8/4 in 6 days. This fast turnaround gives users the ability to handle specialty drying needs without tying up a high-volume conventional kiln for extended periods. It is also practical for the small user drying the more common 4/4 stock, especially when fast turnaround is critical.

SECTION 1-7: LUMBER DRYING - cont'd

SOLAR KILN DRYING

Wood-Mizer also offers a line of SolarDry Kilns ranging in sizes appropriate for small, personal operations to larger, commercial size units. Drying times range from five to eight weeks for 4/4 cherry and walnut and six to ten weeks for red and white oak. The natural conditioning cycle of the SolarDry allows these short drying times with less than 1% degrade. Drying times may also be reduced or maintained during colder, cloudy seasons with back-up heating systems using wood, gas, or electricity.

The SolarDry Kiln system centers around a patented solar dehumidification process. The system incorporates a double-walled solar collector that allows a flow of air and moisture within the kiln to remove moisture from the wood. Heat up to 150 degrees is circulated inside the chamber where a fan directs air to the cooler outside collector chamber. Moisture condenses and rolls down the surface of the outer panel of this chamber where it exits.

SolarDry kits are available in 750 to 7200 board foot capacities and are shipped complete other than the foundation and wood chamber walls. Contact the factory for more information regarding the Vacu-Dry or SolarDry Kiln systems.

AIR-DRYING

Air-drying is the most common method of drying lumber for most small mill operators. The following paragraphs are quotes from the "How to Dry Small Quantities of Lumber" pamphlet prepared by the North Central Forest Experiment Station Forest Service, United States Department of Agriculture:

Before using freshly sawn hardwood lumber in your woodworking projects, you must dry it. These paragraphs will outline how you can dry short lengths of green boards inexpensively at home. Green lumber up to 2 inches thick can be dried for indoor use in 1 to 4 months, depending on the species and wood thickness. Moisture contents of the dried lumber range from 6 to 11 percent, depending on the conditions in the indoor room. However, when using this method of drying, you should expect a significant amount of defects to occur.

Freshly cut lumber contains up to 1 pound of water for each pound of dry wood. If used in the green condition, the lumber will dry while in use, leading to shrinkage, decay, paint failure, and loosening of joints. The lumber must be dried first to avoid these problems.

When warm dry air is moved over the surfaces of green wood, the wood absorbs heat from the air and this heat evaporates the water held in the wood. Stack the wood in rows or tiers separated from each other by a few crosslaid pieces of dry lumber about 3/4 inch square (called stickers) and support it well above the ground. Place heavy weights on top of the stack to keep the boards flat. Align the stickers vertically to prevent sagging.

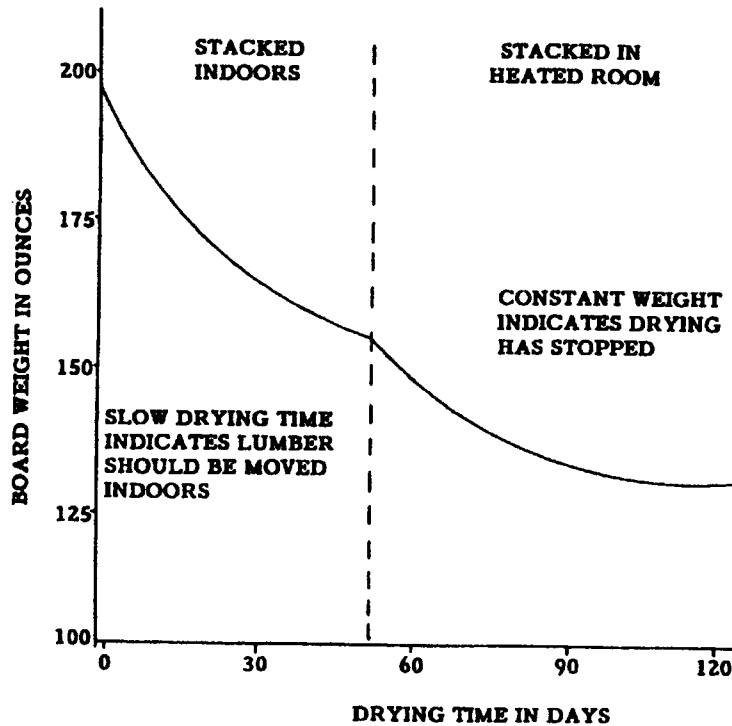
Build the stack where warm, dry air can move through the tiers. Heated or dehumidified indoor space or an attic above heated space are good locations. However, unheated sheds can be used to accomplish most of the drying. If no shed or indoor space is available to handle all of the lumber, you can build the stack outdoors, but it must be protected with a slightly sloping roof of plywood or other panel-type material. Stacks built outdoors or in unheated sheds will dry well in the warm months, but much more slowly in cold winter months.

Outdoor conditions are not dry enough to remove enough moisture from the wood to reach the 6-10 percent moisture contents required for indoor use. Therefore, you will have to move the material in the stack into a heated or dehumidified interior space to complete the drying. The lumber should be stacked indoors in same manner as described earlier.

SECTION 1-7: LUMBER DRYING - cont'd

HOW WILL I KNOW WHEN THE WOOD IS DRIED?

Weigh a few boards from the stack at least once a week. When their weight stops dropping, the boards have stopped drying. One easy way to keep track of the wood's progress is by graphing the board weight, such as in the graph below. The graph shows the weight loss of white oak, originally weighing 200 ounces, which was dried outdoors until the rate of weight loss was very low and then moved to heated indoor space and dried until no further weight loss occurred. Although a hard-to-dry species such as white oak took 4 months to dry, easier drying species like yellow poplar and silver maple can be dried in less than 1 month.



A FEW POINTERS

1. End coat your green logs and lumber with beeswax or a commercial sealer to prevent excessive end checking.
2. Use light-colored wood for stickers.
3. Keep dried lumber indoors in a dry location until you're ready to make the final product.
4. Stickers should be located approximately 16" apart and at both ends of the boards.

SECTION 1-7: LUMBER DRYING - cont'd

APPROXIMATE TIME IN DAYS TO AIR-DRY GREEN 1-INCH LUMBER TO 20% MOISTURE CONTENT			
SOFTWOODS		HARDWOODS	
SPECIES	DAYS	SPECIES	DAYS
Baldcypress	100-300	Alder, Red	20-180
Douglas Fir:		Ash:	
Coast	20-200	Black	60-200
Interior North	20-180	Green	60-200
Interior South	10-100	White	60-200
Interior West	20-120	Aspen:	
Hemlock:		Bigtooth	50-150
Eastern	90-200	Quaking	50-150
Western	60-200	Basswood	40-150
Western Larch	60-120	Beech, American	70-200
Pine:		Birch:	
Eastern White	60-200	Paper	40-200
Jack	40-200	Sweet	70-200
Lodgepole	15-150	Yellow	70-200
Ponderosa	15-150	Butternut	60-200
Red	40-200	Cherry, Black	70-200
Southern Pine:		Cottonwood:	
Loblolly	30-150	Black	60-150
Longleaf	30-150	Eastern	60-150
Shortleaf	30-150	Elm:	
Slash	30-150	American	50-150
Sugar Pine:		Rock	80-180
Light	15-90	Hackberry	30-150
Sinker	45-200	Hickory	60-200
Western White	15-150	Magnolia	40-150
Redwood:		Maple:	
Light	60-185	Bigleaf	60-180
Sinker	200-365	Red	30-120
Spruce:		Silver	30-120
Engelmann	20-120	Sugar	50-200
Red	30-120	Oak:	
Sitka	40-150	Northern Red	70-200
White	30-120	Northern White	80-250
		Southern Red	100-300
		Southern White	120-320
		(Chestnut)	
		Pecan	60-200
		Poplar, Yellow	40-150
		Sweetgum:	
		Heartwood	70-300
		Sapwood	60-200
		Sycamore, American	30-150
		Tanoak	180-365
		Tupelo:	
		Black	70-200
		Water	70-200
		Walnut, Black	70-200
		Willow, Black	30-150

SECTION 1-8: GRADING LUMBER

STANDARD HARDWOOD GRADES

FIRSTS & SECONDS (FAS) GRADE

Use: For long, generally wide cuttings. As required for fixtures and interior trim.

Board Size: 6" and wider, 8' and longer.

Number of Clear Face Cuttings: Determined by Surface Measure (S.M.) of piece.

Size of Clear Face Cuttings: 4" or wider by 5' or longer and 3" or wider by 7' or longer.

Yield in Board of Clear Face Cuttings: 83 1/3% or more.

SELECT GRADES

Use: For long, medium to narrow width cuttings, where only one good face is required. As required for molding and wall paneling.

Board Size: 4" and wider, 6' and longer.

Clear Face Cuttings and Yield: Same as Firsts & Seconds (FAS) on better face. Poorer face to grade not below No. 1 Common.

NO. 1 COMMON

Use: For medium length, narrow to wide cuttings. As required for furniture manufacture.

Board Size: 3" and wider, 4' and longer.

Number of Clear Face Cuttings: Determined by Surface Measure (S.M.) of piece.

Size of Clear Face Cuttings: 4" or wider by 2' or longer and 3" or wider by 3' or longer.

Yield in Board of Clear Face Cuttings: 66 2/3% or more.

IMPORTANT EXCEPTIONS

1. Walnut, butternut and all quarter-sawn woods are 5" and wider in Firsts & Seconds (FAS) grade.
2. Minimum size of clear face cuttings in walnut and butternut are:
 - a. FAS: 4" or wider by 3' or longer and 3" or wider by 6' or longer.
 - b. No. 1 Common: A clear face cutting shall not contain less than 144 sq. inches; minimum width 3", minimum length 2'. There is no limit to number of cuttings.
3. FAS Poplar 8" and wider must contain not less than 66 2/3% heartwood on one side and not less than 50% on the reverse side. Pieces 7" wide allow 1" aggregate sapwood on either or both faces; pieces 6" wide must be all heartwood. Clear stock with excessive sapwood is usually sold as "SAPS", or sometimes FAS (SND), meaning "sap-no-defect".

SECTION 1-8: GRADING LUMBER - cont'd

GRADING OF WESTERN PINE

SELECT GRADES

B & BETTER SELECT (1 & 2 Clear). B & Better is the highest recognized grade of Pine... a practically perfect grade. Although graded from the better side, even the backs of pieces in B & Better are of extremely high quality. To all practical purposes, the grade is clear.

B & Better Ponderosa Pine is used for finishing work of the very highest order, including interior trim, siding, paneling and cabinet work. It is also used for special industrial purposes where practically clear lumber in fairly large pieces is desired.

C SELECT. C Select is the second grade of Pine finish lumber and is designed to provide a top grade paint finish wood. Many pieces have a B & Better face with backs of a slightly lower quality than are permitted in the higher grade. Other pieces have a clear appearance but contain small parts of slightly torn grain, fine checks or possibly light pitch.

C Select is suitable for the very highest uses where entirely clear lumber is not required.

D SELECT. D Select includes pieces showing a finished appearance on one side only, the back of the board at times containing knots, pitch, wane or a combination thereof. In such cases, the face is correspondingly high. A type often used is a high line piece requiring a cut to eliminate a defect too serious to go into finished work.

It is especially useful grade for the small planing mill and works up into various articles of woodwork with little waste.

MOLDING GRADE. This is a special grade exhibiting characteristics of both Select and Factory grades. As the name suggests, a high yield in long, clear but narrow cuttings suitable for producing moldings is the basis of the grade.

Price of molding Grade is intermediate between D Select and Third Clear, and the board will normally be found to be too good for Third Clear and not good enough for D Select. It is a sound value for the custom woodworker, because he can produce almost anything he needs from it at a relatively reasonable cost.

COMMON GRADES

NUMBER 1 COMMON. Number 1 Common is the highest of five grades into which Pine Common is classified and contains pieces of the small knot variety. Knots are always sound, red or intergrown, smooth and are limited in size to slightly more than 2" in diameter, depending upon the size of the piece. As a rule, the knots average very much smaller and are well distributed along the board.

Only pieces that show smooth dressing around knots are allowed in No. 1 Common. Knots in No. 1 Common are usually round or oval in shape and seldom occur on the edges of the board.

NUMBER 2 COMMON. Number 2 Common, a very popular grade, represents a large percentage of the total production of Ponderosa Pine lumber. An all-around utility grade, it is suitable for all uses where a good grade of Common is required. It contains the same type of defects as No. 1, but in greater degree.

Generally similar to No. 1 in appearance, No. 2 allows larger and more pronounced characteristics. In narrow widths, knots are usually limited to 2 1/2" in diameter, and in wider widths to 3 1/2", but the average is considerably less than the maximum.

NUMBER 3 COMMON. Number 3 Common comprises pieces of less uniform appearance than those in the two higher Common grades, varying from a piece of, otherwise No. 1 or No. 2 quality with a single characteristic which causes it to be Grade No. 3, down to pieces showing numerous coarse knots, or boards with loose knots or an occasional knot hole. A piece containing a knot hole is generally of otherwise high quality.

A limited amount of heart shake and pitch may be found in low line pieces of No. 3, provided they do not occur in serious combination with other defects. A type frequently found is a piece with a No. 2 face, but showing several skips in dressing.

SECTION 1-9: DEFINITIONS

At one time or another, every Wood-Mizer customer finds himself involved in conversation dealing with woodlot management or forestry concepts. Unfortunately, many aspects of woodlot management and professional forestry can only be explained or described in technical terms. Therefore, it is important for sawyers to become familiar with basic forestry concepts and terms if they are to communicate successfully with other professional foresters. The following is a selected list of definitions used when discussing forestry management concepts and practices.

Acre - An area of land which contains 43,560 square feet (about 208.7 feet square).

Afforestation - Establishing a forest on an area which has not previously had trees growing on it.

All-Aged Forest - A forest stand in which trees of all ages and usually all sizes are present. Seldom exists in nature.

Allowable Cut - The volume of wood or the amount of product which can be cut, under a particular management plan, during a given period of time.

Annual Ring (or Growth Ring) - The growth layer of one year as viewed on the cross section of a stem, branch, or root; composed of early and late wood.

Board Foot - A unit for measuring wood volumes, equalling 144 cubic inches, which is commonly used to measure and express the amount of wood in a tree, sawlog, veneer log, or individual piece of lumber. For example, a piece of wood 1 foot x 1 foot x 1 inch or one measuring 1 foot x 3 inches x 4 inches both contain 1 board foot of wood.

Bole - The main trunk of a tree.

Bolt - A short log or a squared timber cut from a log.

Buck - To saw felled trees into shorter lengths.

Butt - The base of a tree or the lower end of a log.

Catface - A well-defined healing or healed wound usually near the base of a tree bole.

Check - A lengthwise separation of the wood, which usually extends across the rings of annual growth, commonly due to mechanical stresses which occur during drying. It is not considered to be cull unless excessive.

Commercial Cutting - A cutting which yields a net income (receipts for the sale of products exceed the cost of the cutting).

Conifer - A tree belonging to the order Coniferales, which is usually evergreen; cone-bearing; and with needles, awl, or scalelike leaves, such as pine, spruces, firs, and cedars; often referred to as "softwoods" which does not necessarily refer to the hardness of the wood.

Conservation - The protection, improvement, and wise use of natural resources to assure the attainment of their highest economic and social values.

Cord - A standard cord is a stack of cut wood 4 feet high, 4 feet wide, and 8 feet long. The dimensions of a face cord are 4 feet by 8 feet but composed of sticks under 4 feet long (commonly 12, 18, or 24 inches).

Crop Tree - A tree identified to be grown to maturity and which is not removed from the forest before the final harvest cut. Usually selected on the basis of its value (quality and species) and its location with respect to other trees.

Crown - The leaves and branches of a tree.

Cubic Foot - A wood volume measurement containing 1,728 cubic inches, such as a piece of wood measuring 1 foot on a side. A cubic foot of wood contains approximately 5 to 7 usable board feet of wood.

SECTION 1-9: DEFINITIONS - cont'd

Cull - (a) A tree or log of merchantable size but having no market value. (b) A tree or log which is unusable for the intended product and, therefore, not measured. Cull includes such things as rot, crookedness, cavities, and excessive limbiness.

Cutting Cycle - The planned time interval between major harvesting operations in the same stand. The term is usually applied to uneven-aged stands. For example, a cutting cycle of 10 years in a northern hardwood stand means that every 10 years a harvest would be carried out.

Deciduous Tree - A tree which loses all of its leaves at some time during the year (during the winter season in New York). May include some conifers, such as larch.

Defect - The portion of a tree or log which is unusable for the intended product and, therefore, not measured. Defects include such things as rot, crookedness, cavities, and excessive limbiness.

Dendrology - The study of the identification, habits, and distribution of trees.

Diameter Breast Height (DBH) - Tree diameter measured 4 1/2 feet above ground level (the established standard place to measure tree diameter).

Environment - The prevailing conditions which reflect the combined influence of climatic, soil, topographic, and biological (plants and animals) factors present in an area. Environmental factors are extremely important in determining how well a particular species will grow in a given area.

Even-Aged Forest - A forest in which all of the trees present are essentially the same age (within 20 years). This is in contrast to an all-aged (uneven-aged) forest.

Forest (or Woodland or Woodlot) - A plant community in which the dominant vegetation is trees and other woody plants.

Forestry - The science, art, and practice of managing trees, forests, and their associated resources for human benefit.

Girdling (or Frilling) - Completely encircling the trunk of a tree with a cut that severs the bark and cambium (active growing layer of cells) and usually penetrates into the sapwood to kill the tree by preventing the movement of food materials. It is sometimes necessary to add oil, such as kerosene, or a chemical to deaden trees, especially beech trees.

Grading - Evaluating and sorting trees, logs, or lumber according to quality and value.

Harvesting - (a) In general use, removing all or portions of the trees on an area. (b) Technical definition: A harvest cut is the removal of trees on an area to obtain income, to develop the environment necessary to regenerate the forest, or to achieve some special objectives such as the development of special wildlife habitat needs. Harvesting is in contrast with intermediate cuttings.

Hardwood - A term used to describe broadleaf, usually deciduous, trees such as oaks, maples, ashes, and elms. It does not necessarily refer to the hardness of the wood.

Heartwood - The inner core of a woody stem, wholly composed of non-living cells and usually differentiated from the outer sapwood by its darker color.

High-Grading - The removal from the stand of only the most valuable trees; often confused with selection cutting. High-grading usually reduces stand quality seriously, and is not recommended.

Knot - That portion of a branch which has become incorporated in the body of a tree stem.

Log - (a) A piece of the woody stem of a tree. (b) The trunk portion of a tree. (c) A unit of measurement of a merchantable tree stem section 8, 16, or 32 feet in length.

SECTION 1-9: DEFINITIONS - cont'd

Log Rule - A device, usually presented in tabular form, which expresses log volume content based on log diameter (inside the bark of the small end) and length.

Marking - Selection and indication, usually by blaze or paint spot, of trees to be cut or retained in a cutting operation.

Non-commercial Cutting - A cutting which does not yield a net income, usually because the trees cut are too small, poor quality, or not marketable.

Preservation - (a) As applied to wood, the treatment of wood products to prevent damage by insects or decay organisms. (b) With respect to land, the practice of attempting to maintain a natural environment undisturbed by the influence or activities of humans.

Pruning - The removal of live or dead branches from standing trees. With forest trees, pruning is generally done along the trunk to remove the side branches (which cause knots in the wood) to produce a higher quality wood (knot-free).

Pulpwood - Wood cut primarily to be converted into wood pulp for the manufacture of paper, fiberboard, or other wood fiber products.

Punky - A soft, weak, often spongy wood condition caused by advanced decay.

Release Cutting (or Cleaning) - A cutting operation carried out to release young trees (seedlings or saplings) from competition with other trees of the same size (termed a cleaning) or larger and overtopping trees (termed a liberation cutting).

Roots - That portion of the tree which is generally underground and which functions in nutrient absorption, anchorage, and storage of food products. There are several general types of roots including: (1) Tap Root - A strong central descending root with lateral roots branching off horizontally; typical of species such as black walnut, white oak, and some pines. (2) Heart-shaped Root - Consists of several large roots descending at various angles into the soil with smaller roots branching from these. Produces heart-shaped root mass which is broadest near the soil surface but which penetrates a considerable distance into the soil; typical of species such as beech and maple. (3) Flat Root - Consists of several large roots which extend out nearly horizontally with smaller roots branching from these. This produces broad, flat, shallow root systems typical of spruce, hemlock, and trees growing in poorly drained soils, or soils where the water table is close to the soil surface.

Rotation - The number of years required to establish and grow trees to a specified size, product, or condition of maturity.

Sapling - Small trees, often less than 20-30 feet tall.

Sapwood - The outer region of a woody stem containing some living cells and functioning primarily in water movement and food storage.

Sawtimber - Trees that will yield logs suitable in size and quality for the production of lumber. In New York, hardwoods must generally be over 16 inches in diameter at breast height in order to be considered sawtimber.

Scale Stick - A flat stick, similar to a yardstick, which is calibrated so log volumes can be read directly when the stick is placed on the small end of a log of known length.

Seasoning - The process of drying lumber or other forms of wood for better utilization by natural (air-dried) or artificial (kiln-dried) processes.

Slash - Residue left on the ground after logging, pruning, or other forest operations including tree tops, branches, and bark.

Snag - A standing dead tree without leaves and most branches, or a standing section of the stem of a broken off tree. Considered valuable to wildlife as either a perch or nesting site.

Sprout (or Sucker) - A tree that has grown from the base, stump, or root of another tree.

SECTION 1-9: DEFINITIONS - cont'd

Stand - A grouping of trees occupying a given area and sufficiently uniform in composition, age, and condition so as to be distinguishable from the forest on adjoining areas. A forest stand is said to be pure if 80% or more of the trees present are of the same species. If less than 80% of all trees present are of the same species, the stand is said to be mixed.

Stumpage - The value of a tree or group of trees as they stand in the woods (uncut on-the-stump).

Urban Forestry - A new field, developed in 1970's, concerned with management of urban trees, parks, and green spaces for a better environment.

Veneer - A thin sheet of wood cut on a veneer machine and often used for plywood facing; requires big, high quality logs.

Volume Table - A table which estimates the volume of wood contained in a standing tree based on measurements of the tree, most commonly diameters measured at breast and merchantable heights.

Wilding - A seedling naturally reproduced outside of a nursery used in reforestation.

Windfall - A tree uprooted or broken off by wind.

Wolf Tree - A tree which occupies more space in the forest than its economic value justifies. Usually a tree which is older, larger or more branchy than other trees in the stand. These trees represent a positive value to a variety of wildlife.

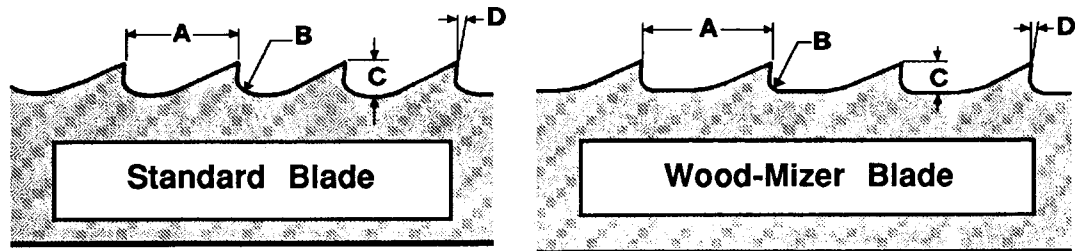
Wood Pulp - Mechanically-ground or chemically-digested wood (composed primarily of wood fiber) which is used in the manufacture of paper, fiberboard, and other products.

SECTION 2-1: THEORY AND TERMINOLOGY

If any one area of our sawmill can determine the success or failure of a cutting operation, it is the blade. Because of this, a clear understanding of both definition and theory about bands is essential. What we have found to be the most productive has not always matched what the textbooks say. For the most part, we believe this is due to the low horsepower and narrow width of our blades compared to larger production band mills. Below is a summary of our best current understanding of blades used with the Wood-Mizer.

Wood-Mizer currently offers two types of blades for use with all models of our lumbermills; Standard blades and Wood-Mizer blades. These two types of blades are offered in varying thicknesses. It is recommended that you discuss with a Customer Service representative which blade is best suited for your cutting application.

Tooth Shape Configurations



A = Pitch (Tooth Spacing)

B = Radius

C = Gullet Depth (Tooth Height)

D = Hook Angle

PITCH

The teeth per inch on a bandsaw blade is called its pitch. The pitch of Standard blades is 1.33 (or 3/4" tooth spacing). The pitch of Wood-Mizer blades is 1.14 (or 7/8" tooth spacing). The smaller the pitch, the more stress or load on each tooth. A larger pitch results in a smoother sawn surface. The pitch is not part of the tooth geometry that is changed on the Wood-Mizer.

DEPTH OF GULLET (TOOTH HEIGHT)

The area between teeth that carry sawdust out of the cut is called the gullet. The gullet of the standard Wood-Mizer blade has proven to be adequate to carry enough sawdust under most cutting conditions. The gullet is determined by the shape, pitch, and height of the saw teeth and needs to be large enough to carry away all sawdust produced. If the space of the gullet is too small, the sawdust is forced out at the side of the blade into the kerf. This increases the friction between the blade and the wood, resulting in heat, sap build-up on the blade, and increased power consumption. If the blade is sharpened several times, the tooth height will decrease, which will result in a gullet area too small to carry the saw dust. Too short a tooth will also result in the inability to set the teeth. To overcome this, the gullet should be ground slightly deeper when tooth height becomes less than 3/16".

SECTION 2-1: THEORY & TERMINOLOGY - cont'd

CLEARANCE ANGLE

The clearance angle is the angle at the top of the tooth. This angle extends long enough down the standard Wood-Mizer blade that it should not need to be ground during the normal life of our blades. It is generally understood that this angle should never be less than 5 degrees and can be as large as 30 degrees. If this back clearance is insufficient, the back of the tooth in the tip region will press against the wood, causing a rubbing action that will overheat and cause early dulling of the blade. The higher the feed rate, the higher the required clearance angle.

TOOTH ANGLE

The tooth angle determines the strength of the tooth. Using the standard clearance angle and recommended hook angle of 10 to 15 degrees, the Wood-Mizer blade is within the recommended 45 to 75 degree range.

HOOK ANGLE

The hook angle is the number of degrees that the tooth face leans forward of 90 degrees. Hook angle and tooth set are the two most critical factors in cutting ability of a blade. Both will have a decisive effect on cutting quality and production capabilities. The proper hook angle is determined by the type of wood and the intended rate. The generally accepted rule is that softwoods require a greater hook angle than hardwoods. Generally, the smaller the hook angle is, the slower the cutting capacity of the mill will be.

The object of the hook angle is for the teeth to "hook" themselves into the timber to remove a certain amount of wood so that the blade feeds itself into the log. If the hook angle is too great in relation to the feed rate, the blade will "pluck" and attempt to move forward in the cut. This results in chatter, a coarse cut, and poor cut quality. This slow feed speed doesn't allow the teeth to fill their function and the tooth points will develop a rubbing action, resulting in premature dullness. If the hook angle is too small, the blade must be forced into the log in order to make the saw cut. This creates side deflections in the blade and will also cause a rubbing action that will wear the teeth faster. Recommended hook angles are 12 1/2 to 15 degrees on softwoods, 10 to 12 1/2 degrees on hardwoods. In theory you should use less of a hook angle when cutting wider boards because of the slower feed rate.

FACE ANGLE

The face angle is the angle of the tooth face in relation to the body of the blade. The face angle is ground to 90° when the sharpener is properly aligned. The setting process will bend the teeth a few degrees past 90°, which is acceptable for our application.

TOOTH SET

The tooth set is measured as the distance that a tooth is bent in relation to the body of the blade. The further a tooth is set, the wider the cutting path of the blade. Wider sets require higher horsepower. A .069" set is recommended for .035" blades for most cutting applications. This translates to each tooth being set to .017 (.017 left + .017 right + .035 material thickness = .069 total set). Set for .042" blades should be .084 (.021 left + .021 right + .042 material thickness = .084 total set). Remember that as you sharpen your teeth, the set will decrease and require resetting as the tooth is ground shorter. Softwoods can require a wider set than hardwoods with total set not to exceed .090" (.042" blade).

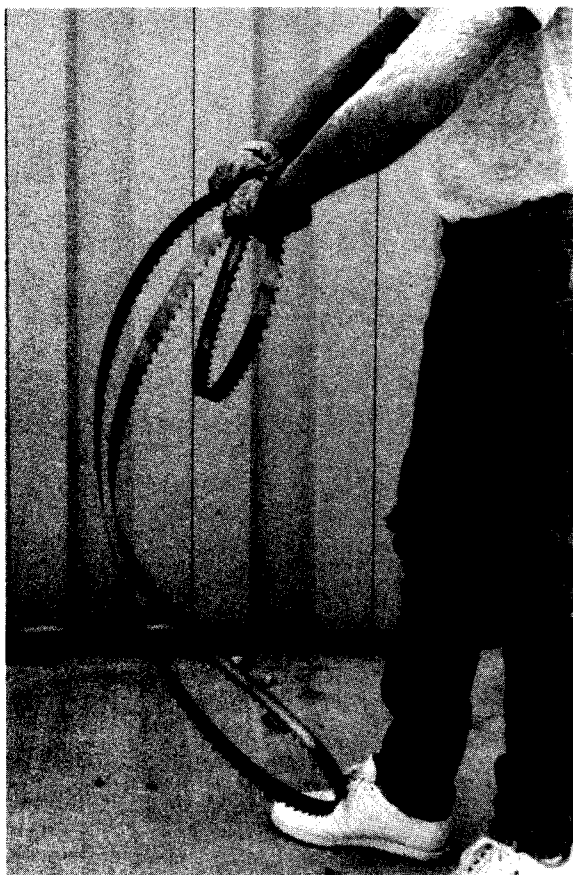
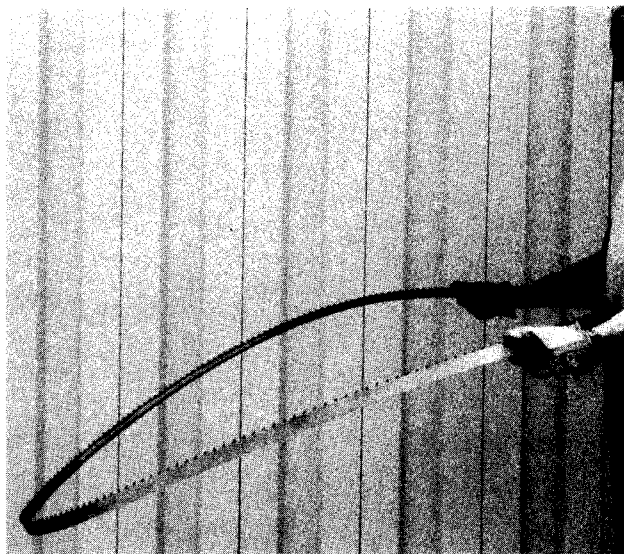
CRITICAL BLADE MAINTENANCE AREAS:

- If the saw teeth require setting, always clean or deburr the blade before setting.
- Be certain that the tip of the tooth has at least 1/2 of tooth height ground to a hook angle between 10 and 15 degrees.
- Do not grind any more metal than required to regain a new, clean cutting face from tip of tooth to gullet radius.
- If you grind too little amount off a new blade, you'll notice black areas on face of tooth; never leave black on tip.
- If you grind too little off of a used blade, you will not remove rounded or dull tip of tooth.

SECTION 2-2: COILING THE BLADE

Warning: Wearing gloves is advised!

1. Hold the blade out in front of you with the teeth pointed up. (Approximately 1/4 to 1/3 of the blade circumference should be between your hands.)
2. Position your thumbs on the outside of the blade against the sides of the teeth. Locate your fingers near the inside bottom of the blade.
3. Hold your hands about shoulder width apart and lift the blade parallel with the ground. Squeeze the blade inward, making it oval shaped.
4. Keeping your wrists "locked" in position, rotate your forearms upward and outward, rotating your thumbs toward each other. (The teeth will rotate inward and the bottom of the blade will rotate outward.)
5. Now bring your hands together and the blade will form 3 loops. Snap the bottom loop upward and catch the 3-loop coil in your hands.

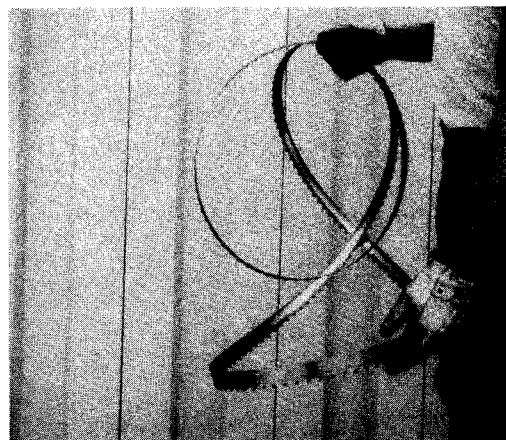


Another method:

1. With the blade at your side, teeth pointed away from you, hold the blade on the ground with your foot.
2. Grasp the blade with your knuckles against your belt.
3. Turn your hand 180 degrees while pushing downward. (The blade will fall into 3 coils on the the ground.)

To uncoil:

1. Shake the 3 coils in your hand until 2 of the coils form an "x" (one coil laying over another at a right angle).
2. Hold the "x" and let the third loop drop downward.
3. Grasp the remaining 2 coils in either hand and separate them. (The blade will open into a full loop).





SECTION 2-3: MANUAL SHARPENER INSTRUCTIONS

The Model LTADS Blade/Chain Saw sharpener is shipped completely assembled except for the grinding wheel installation, blade support assembly, and wet-grind system. If you purchased an automatic sharpener, complete instructions for assembling and operating it are found in Section 2-4.

ELECTRICAL HOOK-UP

The Model LTADS Sharpener can be powered in three different ways:

1. 115V AC
2. 12V DC (From Wood-Mizer Battery)
3. 12V DC (From Battery)

1. Using the AC/DC converter provided, plug the standard power cord into a grounded, 15 amp 115 volt receptacle protected by a fuse or circuit breaker. Mount the grinder per mounting instructions. Plug the Model LTADS sharpener into the pigtail socket of the AC/DC converter. The switch on the sharpener head will start and stop the motor.

2. When using the LTADS in the field with the Wood-Mizer, use the provided socketed pigtail with battery clips. Attach the clips to the back of the power feed control as shown in **Figure 2-1**. The positive lead (red) should be clipped to the longer of the two power feed posts. Ground the negative clip (black) to the short power feed post.

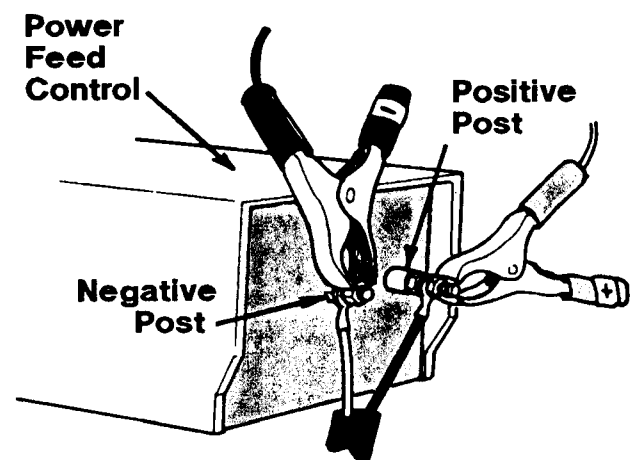


FIG 2-1

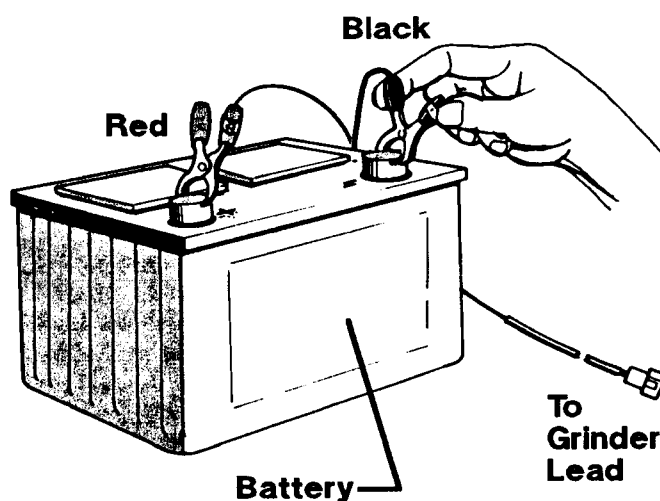


FIG 2-2

3. The LTADS sharpener can also be powered directly by a 12 volt DC storage battery. Use the provided socketed pigtail with the clips as before, but attach the clips to the terminals of a car or truck battery (See **Figure 2-2**). Plug the grinder lead into the pigtail socket. Check the motor shaft rotation. Rotation of the shaft should be counter-clockwise when viewed from the end of the motor shaft. If direction is wrong, reverse the two clips on the battery terminals.

SECTION 2-3: MANUAL SHARPENER - cont'd

MOUNTING INSTRUCTIONS

The LTADS Sharpener can be mounted either on a bench or table, or on one of the Wood-Mizer bed rails.

1. For use where 115 volts is available, mount the grinder solidly on a bench or table using the two mounting holes in the grinder base. The mounting holes should be no more than 1" back from the front edge of the bench to allow mounting of the wet-grind catch tray. Mount the grinder so there is at least 32" clearance to the rear and to each side of the grinder to allow enough room for the blade supports. Use the "J" hooks, steel and rubber washers, wing nuts, and wet-grind catch tray to mount the sharpener to the bench top as shown in Figure 2-3.

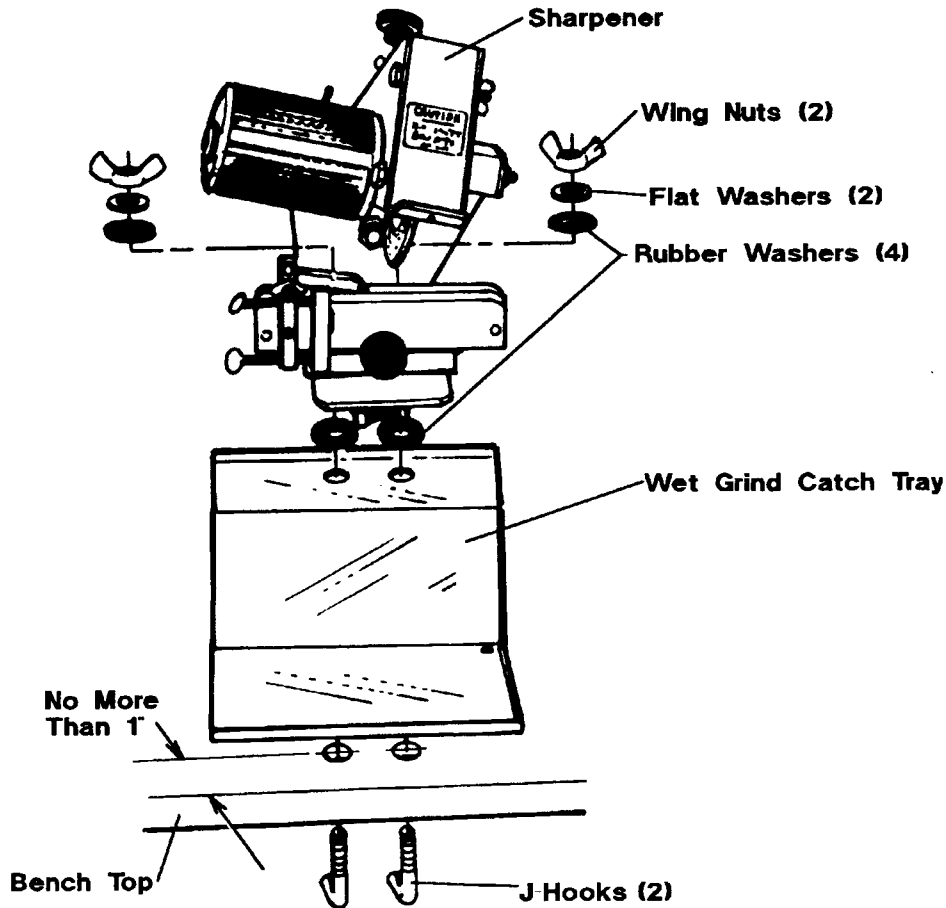


FIG 2-3

2. For use in the field with the Wood-Mizer mill, move the carriage forward to allow a 32" clearance for the blade. The grinder can be mounted at the end of the bed rail as shown in Figure 2-4. The two "J" hooks provided can be used to lock the grinder to the bed rail by simply hooking them under the ramp mounting pin and securing with two flat washers and wing nuts.

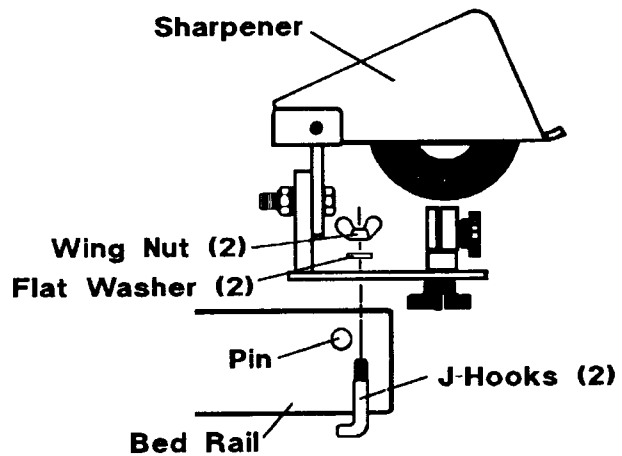


FIG 2-4

SECTION 2-3: MANUAL SHARPENER - cont'd

Thread the three blade support tubes into the tapped holes located near the bottom of the sharpener base. Be sure the support tubes are seated against the base plate. Slide the blade support roller assemblies onto the tubes as shown in **Figure 2-5**. The blade rollers should be 1" from the ends of the right and rear tubes, and 2 1/2" from the end of the left tube (minor adjustments may be necessary for maximum freedom of circular travel of the bandsaw blade).

Chainsaw blades can be sharpened in either of the above set-ups. If additional portability is required, the grinder can be mounted by the user to suit his application.

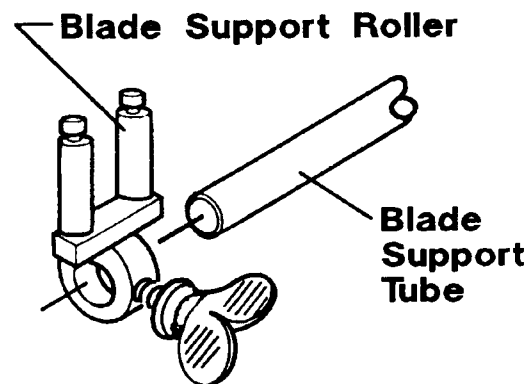


FIG 2-5

WET-GRIND SYSTEM INSTALLATION

The LTWG Wet-Grinding System is simply a system to cool the blade during the blade sharpening process. Cooling the blade during grinding will assure you that the teeth will maintain the hardness that is so critical to maximizing cutting time between sharpenings.

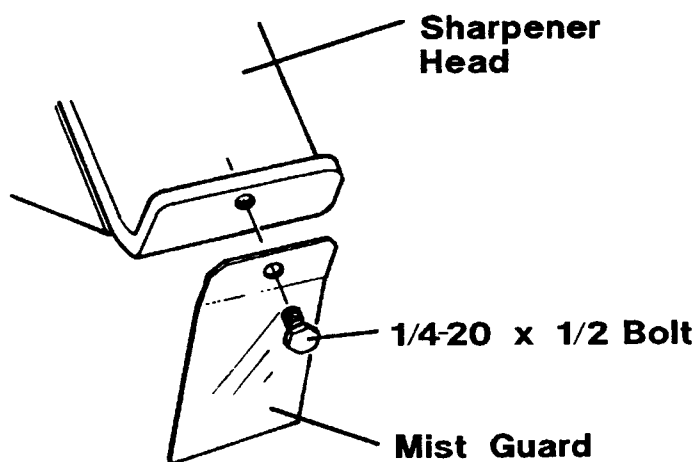


FIG 2-6

1. With the LTADS Sharpener and wet-grind catch tray already mounted, assemble the mist guard to the tapped hole in the sharpener handle with the 1/4-20 x 1/2" bolt as shown in **Figure 2-6**.

2. Apply silicon caulk to the eight corners, bends, and drain hole in the catch tray to stop any potential leaks. Only a small amount of caulk is necessary at the exposed bends in the catch tray, as there is very little water that drains from the upper level of the catch tray.

3. Assemble the three pieces of the adjustable coolant hose as shown in **Figure 2-7**. The pieces simply push together. After assembling the hose, fasten it to the water jug by screwing the threaded end of the hose into the valve of the jug. A thread sealer may be necessary to prevent leakage.

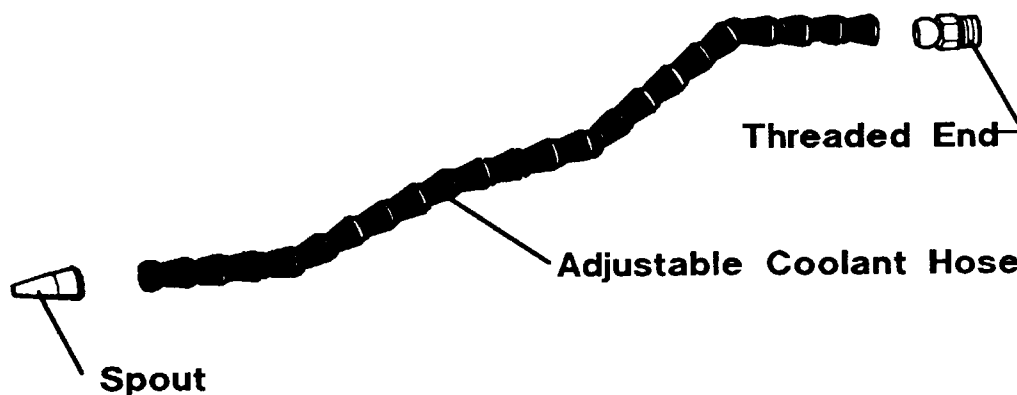


FIG 2-7

SECTION 2-3: MANUAL SHARPENER - cont'd

4. **COOLANT MIXTURE:** Fill the five-gallon jug with approximately 4 gallons of water. Add to the water about 1/3 of a bottle of coolant concentrate provided. Set the jug to left and behind the sharpener (See Figure 2-8). Lay the jug on its side so that the valve is at the lower front. Elevate the jug so that the bottom of the jug is no lower than the top of the blade set in the sharpener. Assemble the drainage hose to the valve underneath the catch tray. Drain the coolant into a bucket as it can be reused several times.

5. **USING THE WET-GRIND DURING SHARPENING:** Use the valve on the water jug to control the flow of coolant to the blade. Adjust the coolant hose so a steady stream of coolant flows on the tip of the tooth to be sharpened. As you sharpen and the water level in the jug goes down, water pressure will drop also. Adjust the jug valve as necessary to maintain a consistent flow onto the tip of the tooth. Allow used coolant to stand for a period of time so that the residue can settle to the bottom. Pour off reusable fluid, avoiding the sediment.

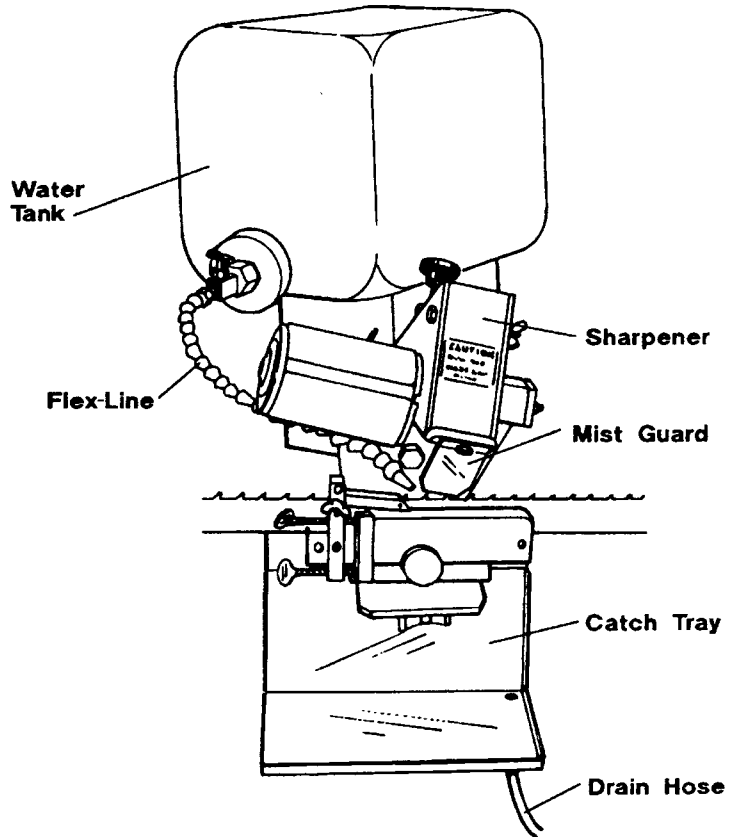


FIG 2-8

6. After the blade has been sharpened, let the grinding wheel spin freely for 15 seconds to dry any excess fluid from its surface.

NOTE: If circumstances require that plain water be used for coolant, clean the grinding unit with a light oil (WD-40) to prevent the assembly from rusting when not in use.

GRINDING WHEEL INSTALLATION

1. Select a 5" diameter, 1/4" wide grinding wheel with a 1/2" bore for sharpening Wood-Mizer blades.

CAUTION: Check the grinding wheel for cracks or chips before using it.
If the wheel is cracked or chipped, **DO NOT USE IT.**
Do not use the wheel after it wears to the edge of the blotters.
Remove the grinding wheel while transporting the sharpener to prevent cracking or breakage due to jarring or bumping of the unit.

2. Remove the right side cover from the grinder head by removing the wing nut. Remove the knurled knob from the motor shaft. Replace the knurled knob, flanged side towards the grinding wheel and hand tighten. Replace the cover and wing nut. Prior to grinding, check that the grinding wheel rotation is counter-clockwise when viewed from the shaft side.

SECTION 2-3: MANUAL SHARPENER - cont'd

SHARPENER SET-UP

Once the sharpener has been mounted and the grinding wheel installed, adjustments need to be made to ensure proper grinding of the particular blade being sharpened. The following adjustments should be made when sharpening Wood-Mizer blades. Set-up for chainsaw blades is described later in this section under saw chain sharpening instructions.

REFER TO SECTION 2.1 OF MANUAL FOR SPECIFIC INFORMATION ON BLADE TERMINOLOGY

1. Set the tooth face angle scale at '0' degrees (See Figure 2-9). The zero on the scale should line up with the '0' line that has been punched into the base plate. As the wheel wears, the blade clamping fixture may be moved away from the operator to keep the blade directly under the center of the grinding wheel (the other marks are for grinding Micro or Super [Round File] Chisel type saw chain). To adjust the face angle or move the blade fixture in or out to compensate for the size of the grinding wheel, simply loosen the bottom hand knob, adjust as desired, and retighten the knob.

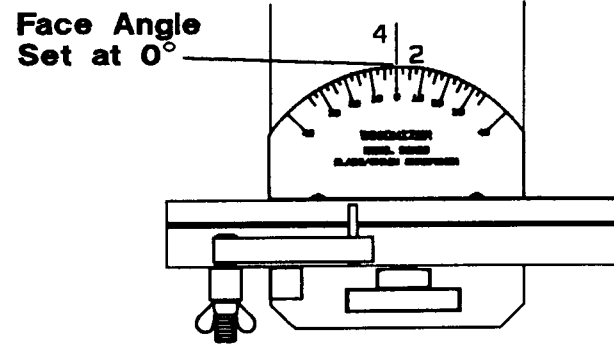


FIG 2-9

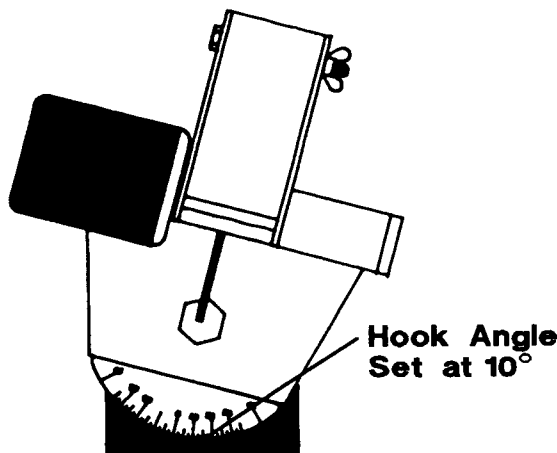


FIG 2-10

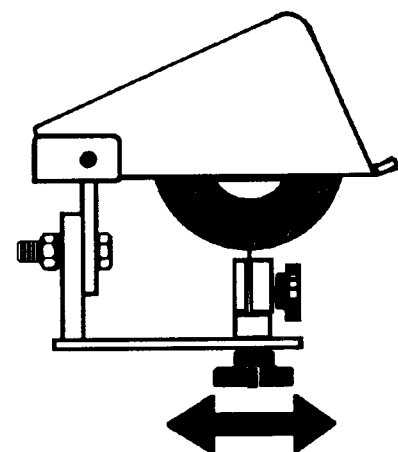
2. Set the hook angle by using the indicator found at the back of the throat (See Figure 2-10). The numbers and hash-marks indicate how many degrees the grinding head is tilted for hook angle. Set the hook angle gauge with the rivet head at the back of the throat. As a general rule, this angle should be set at 10 degrees for most woods. The hook angle can range from 10 to 12 1/2 degrees for hardwoods and 12 1/2 to 15 degrees for softwoods.

INSTALLING THE BLADE

1. Remove the 16 gauge shim from between the clamping plates during set-up steps. Set the blade into the clamping plates with the teeth of the blade facing to the right. Lay the blade in the three roller supports.

2. Position the blade so the first tooth right of the weld is positioned at the front of the machine. Position blade clamping fixture so that the wheel's lowest point contacts the blade gullet. To adjust, loosen the hand knob underneath the unit (See Figure 2-11).

3. Turn the clamping knob so that the fixture holds the blade straight, yet still slides easily right to left.



Center Blade Under Wheel

FIG 2-11

SECTION 2-3: MANUAL SHARPENER - cont'd

CAUTION: ALWAYS WEAR EYE PROTECTION WHEN OPERATING THIS EQUIPMENT

DRESSING THE GRINDING WHEEL

1. Position the first tooth right of the weld so the wheel will lightly touch new metal on the length of the tooth face. Before sharpening a new blade, dress the wheel to match the shape of the tooth. There are three areas of the wheel that need to be dressed to ensure proper sharpening (See Figure 2-12). Dress Section 'C' first by holding the dressing stone horizontally and dress a flat surface on the bottom of the grinding wheel (See Figure 2-13). This is the area that will grind the gullet base.

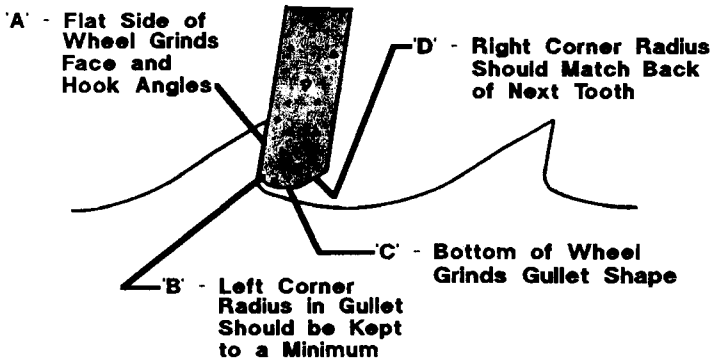


FIG 2-12

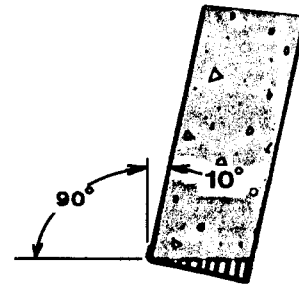


FIG 2-13

2. After obtaining the results shown in Figure 2-13, dress a small radius on Section 'B' of the grinding wheel as shown in Figure 2-14. During sharpening, this is the section which does most of the grinding and therefore requires the most maintenance. As you sharpen, Section 'B' will wear into a larger radius and start wearing into Section 'A' as shown in Figure 2-15. The result will be little or no hook angle left in the tooth. The straight portion of the tooth (Section 'A') should extend approximately 3/4 of the way down the tooth height (See Figure 2-16). If Section 'A' is 2/3 of the tooth height or less, the wheel needs to be redressed. Recommended procedure for re-dressing the wheel is to dress the bottom of the wheel flat again as described in Step 1. Re-dress a small radius on Section 'B', if necessary. Readjust the depth of the wheel to the gullet of the blade. **NEVER** attempt to dress the wear area by using the dressing stone on the side surface (Section 'A') of the wheel. Depending on the amount of material being removed from the teeth while sharpening, it may be necessary to re-dress the grinding wheel 1-3 times during one sharpening.

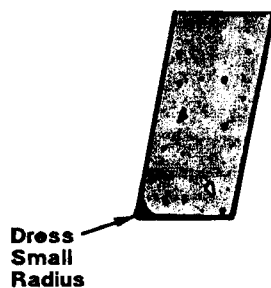


FIG 2-14

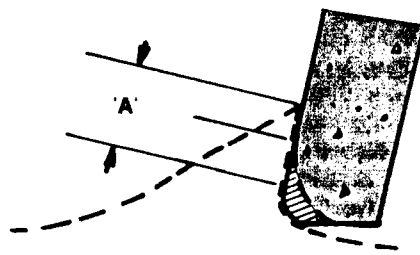


FIG 2-15

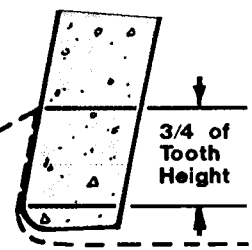


FIG 2-16

3. Section 'D' of the grinding wheel is only needed when "gumming out" the gullet as described later in this section. Section 'D' needs to be dressed so that it doesn't contact the gullet of the tooth.

GRINDING WHEEL PROFILE GAUGE

A profile gauge is supplied with each sharpener to help you properly maintain the shape of the grinding wheel. Simply slip the template onto the edge of the grinding wheel (with sharpener NOT running) and check to see the wheel matches the shape of the profile template. Redress as necessary and check with the template again. **IT IS CRITICAL THAT THE SHAPE OF THE GRINDING WHEEL BE CONTINUALLY MAINTAINED IN ORDER FOR THE BLADE TO CUT PROPERLY.**

SECTION 2-3: MANUAL SHARPENER - cont'd

SHARPENING THE BLADE

NOTE: Sharpening procedures are the same for different thickness of blades. The grinding of the thicker blades will SEEM heavier because of the extra material being removed.

1. It is recommended that new blades be sharpened and then set before using. A light "touch-up" of the face of each tooth should be sufficient. You should not have to grind any material from the gullet on the first sharpening.
2. With the sharpener properly assembled, the blade inserted, and the grinding wheel dressed, you are ready to sharpen your blade. Locate the first tooth right of the weld and position in the clamping fixture so that the grinding wheel does not contact the tooth when lowered. Clamp the blade firmly and set the depth adjustment on the sharpener so that the grinding wheel will grind only the straight portion of the tooth. You will not enter the radius of the tooth until subsequent sharpenings.
3. Turn the sharpener on and GRADUALLY lower the head until the wheel is positioned to the right of the first tooth to be sharpened. Do not "chop" the grinding wheel into tooth. This will cause the grinding wheel to wear prematurely and grind improper hook angles into the teeth. (**NOTE:** The spring action of the grinder head may be made stiffer by tightening the nut on the back side of the machine, and vice versa). Slowly slide the blade to the right until the face of tooth contacts the grinding wheel. Only grind the amount of material off the tooth necessary to regain a sharp point.
4. Turn off the sharpener and check the tooth just ground. Check to see that the face of the tooth has been ground from the tip down to the end of the straight section. Redress the grinding wheel or adjust the sharpener depth and regrind the first tooth, if necessary.
5. Now that the first tooth is ground properly, you may index off of this tooth to sharpen the remaining teeth. Flip the index pawl into position in front of the tooth just sharpened. The index pawl should be in the lower pivot hole (See Figure 2-17). The upper hole is used when sharpening chain saw blades. Adjust the thumb bolt adjusters so that when the sharpened tooth is pushed against the pin, the grinding wheel lightly grinds the second tooth as it did the first.

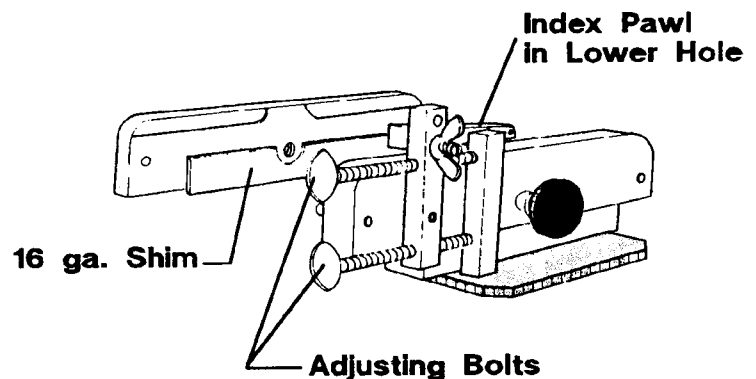


FIG 2-17

6. Replace the shim between the clamping plates. This will allow you to completely tighten the fixture, yet still let the blade slide freely. Sharpen each tooth by sliding the blade to the left until the indexing pin falls in front of the tooth just ground, pull the grinding wheel down and push the blade to the right against the index pin to sharpen the next tooth. Continue around the blade until you reach the weld. Some blades have more than one weld. Never index across a weld, use the freehand method for the tooth right of a weld and then continue to use the index.

NOTE: SOME BLADES DO NOT HAVE CONSISTENT TOOTH SPACING. If, while grinding, you notice the grind starting to become heavy, simply slide the blade slightly beyond the index pawl to re-establish a proper grind of the tooth. Then proceed as normal. Also, adjusting the index too often will result in uneven pitch.

SECTION 2-3: MANUAL SHARPENER - cont'd

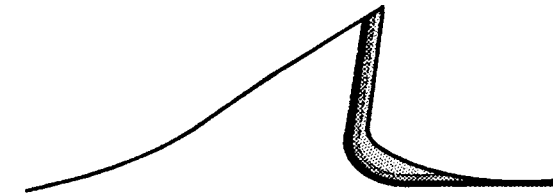


FIG 2-18

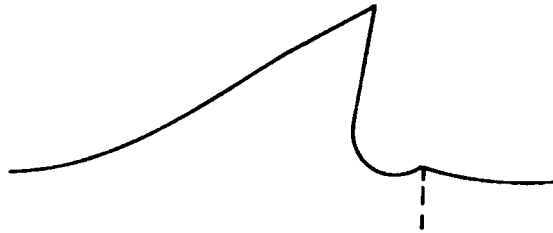


FIG 2-19

7. As you sharpen a blade and the face of the teeth recede, the tooth height (tip down to gullet) will get shorter. For this reason, it is recommended that from the second sharpening on, you start grinding into the gullet. A good rule of thumb is to grind as much out of the gullet as you grind off the face of the tooth (See Figure 2-18). When grinding into the gullet, be sure to maintain a smooth radius into the gullet. An inconsistent gullet (See Figure 2-19) can cause premature blade breakage. Subsequent sharpenings will require a large amount of the gullet to be ground, until you get to approximately the fourth or fifth sharpening. At that time, it will be necessary to gum across the entire gullet (explained later). A tooth height of not less than 3/16" is recommended.

8. When a blade becomes dull from cutting, the tips of the teeth become rounded and shiny. To regain a sharp tooth, they must be ground back enough to regain a new edge. If the teeth aren't ground back far enough, they really aren't sharp and the time invested will be wasted because the blade will need to be re-sharpened shortly.

GUMMING OUT THE BLADE

As the teeth are ground and become shorter, you will need to grind the gullet out to regain a 3/16" tooth height. This process is referred to as "gumming out" the blade. Standard blades usually need gumming out about the third or fourth sharpening. Wood-Mizer blades require gumming out on every sharpening as they start with a 3/16" tooth. Dress the lower right corner to match the angle of the back side of the teeth. Find the first tooth right of the weld and sharpen as normal except bring the head down at the back of the next tooth and drag the gullet across the wheel, leaving a smooth gullet with no sharp breaks. Continue for the remaining teeth until you return to the weld.

TROUBLESHOOTING

1. Improper Hook Angle:

-Worn grinding wheel. Caused by normal wear or heavy "chopping" action down on tooth. Bring grinder head down with a gradual motion to deter premature wearing of wheel.

-Grinding head set at wrong angle. Check indicator at rear of sharpener throat for proper setting.

-Blade being tilted while sharpening. Keep left hand close to clamping fixture to avoid tilting blade at an angle. Hint: Turn the blade support roller on the right side of the sharpener towards you slightly. Turn the roller on the left side slightly away from you. This will cause the blade to pull down into the clamping fixture while sharpening.

2. Improper Face Angle:

-Base plate set at wrong angle. Check indicator gauge is set at '0'.

3. Short Time Between Sharpenings:

-Not sharpening teeth enough. If a new edge is not formed on dull teeth when sharpening, the blade is not very sharp to begin with.

-Worn grinding wheel. A worn wheel can cause you to dull a blade worse than it was to start with. Dress the bottom of the wheel flat and re-dress a small radius on the left corner.

-Heating the temper out of the teeth. Sharpening a blade causes the teeth to heat up and loose their hardness. When this occurs, the teeth become dull very quickly. Use of the LTWG Wet Grind System eliminates this problem.

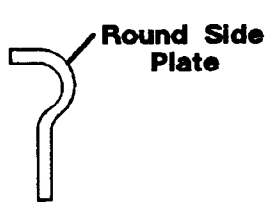
-Dirty logs. mud, sand, rocks, and other foreign matter can cause a blade to dull very quickly. The best way to clean a log is with a high pressure water spray. If this is not available, use a wire brush to clean the side of the log that the blade enters. You may also debark logs if they are the type that will allow this. Another recommendation would be using an old blade to square up the log where fencing, nails, or other debris is suspected inside.

SECTION 2-3: MANUAL SHARPENER - cont'd

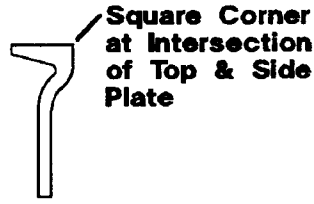
SHARPENING INSTRUCTIONS FOR SAW CHAIN

BEFORE GRINDING SAW CHAIN THERE ARE SEVERAL IMPORTANT POINTS THAT ARE OUTLINED IN THE FOLLOWING PAGES. PLEASE READ THEM BEFORE USING YOUR CHAIN GRINDER.

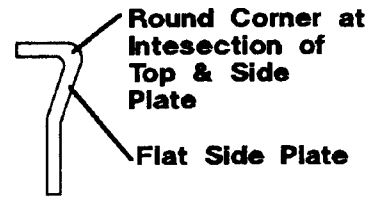
SAW CHAIN TYPES



Chipper Type Chain

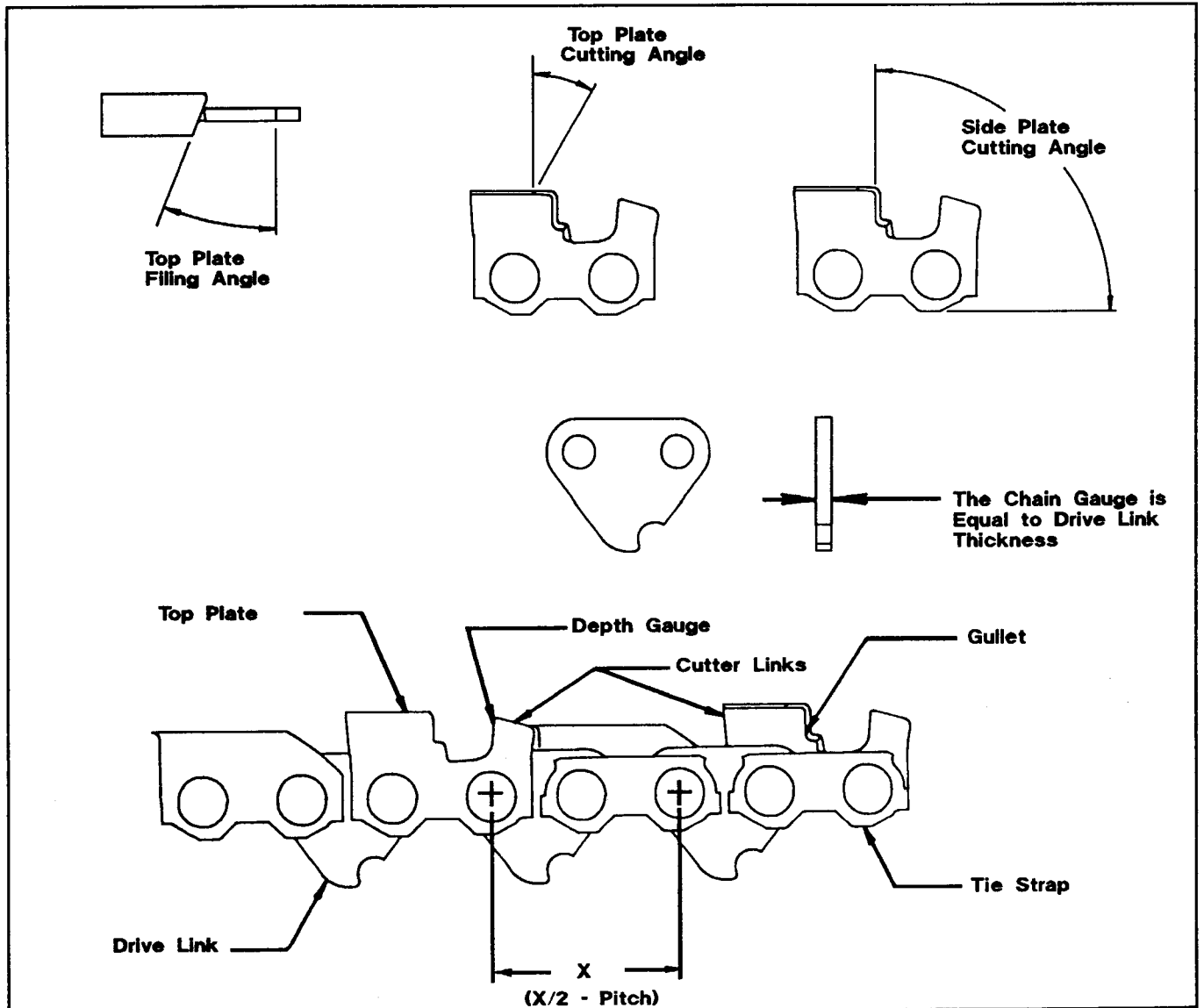


Chisel Type Chain



Semi-Chisel or Micro-Chisel

SAW CHAIN TERMINOLOGY



SECTION 2-3: MANUAL SHARPENER - cont'd

PREPARE SAW CHAIN FOR SHARPENING

Remove saw chain from bar.

Clean saw chain in solvent to remove pitch and resin.

Inspect saw chain for:

Abrasive damage to side plate and top plate cutting edges. The damaged cutting edges should be ground back to completely eliminate damaged portion.

Top plate angle excessively blunt or feathered.

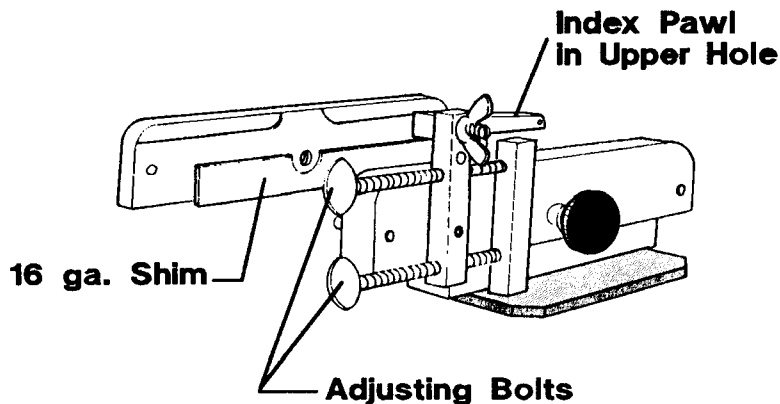
High and low depth gauges and square leading edge of depth gauge.

Side plate angle excessively hooked or backsloped.

SHARPENER SET-UP

Select the grinding wheel to be used. The grinder uses a 5" diameter wheel by 1/2" bore. As a general rule, the grinding wheel thickness should be that thickness nearest to or less than the recommended file size.

The bolt that the index pawl pivots from should be moved to the upper hole for sharpening saw chain (See Figure 2-20). The pawl should be located directly over the chain and locked in place with the wing nut.



Make sure the 16 gauge shim is located in place between the clamping plates (See Figure 2-20).

Place the saw chain in the clamping plates with the cutting edge facing to the right.

FIG 2-20

Set Top Plate Angle by setting the protractor of the clamping plate assembly to the desired angle (we will use 30 degrees for an example) (See Figure 2-21). The clamping plate assembly will be moved from front to back as the wheel wears, to keep the blade in proper placement with the wheel.

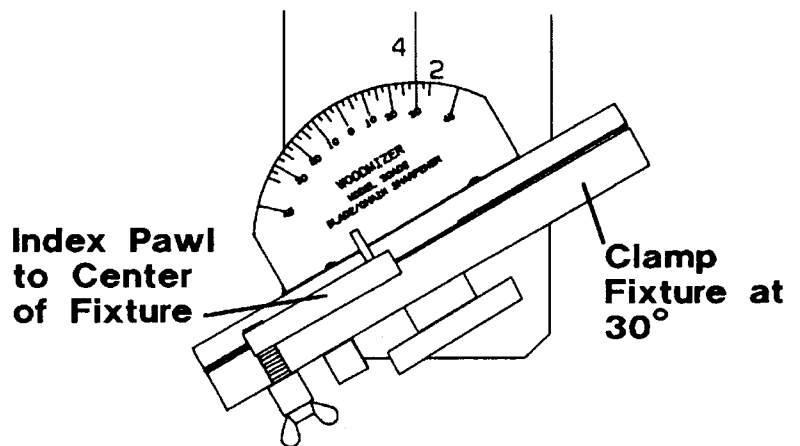


FIG 2-21

SECTION 2-3: MANUAL SHARPENER - cont'd

Set Top Plate Cutting Angle by setting the scale on the back of the throat to the desired angle (again, we will use 30 degrees as an example) (See Figure 2-22). Follow manufacturer's specifications for recommended angles. This represents degrees this angle tilts past 90 degrees.

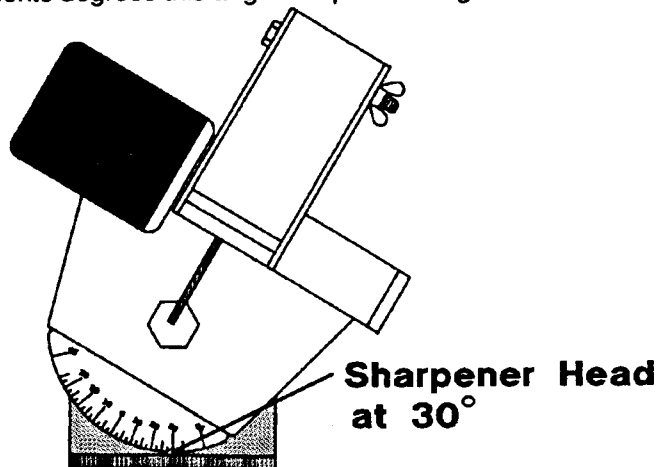


FIG 2-22

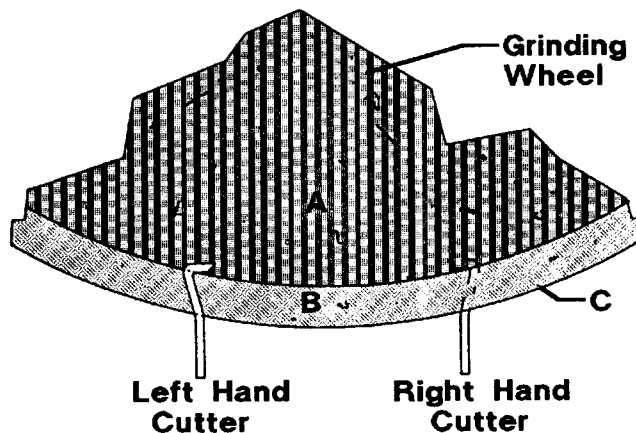


FIG 2-23

Set Offset. The offset allows for the proper Top Plate Cutting Angle to be ground across the full width of the Top Plate of a cutter link. To set offset, move the clamping plates so the cutter link will be located properly under the grinding wheel. There are offset marks punched in the baseplate of the grinder to be used for reference purposes. A properly placed cutter link under a grinding wheel is shown in Figure 2-23. There will be final adjustments of the offset after the grinding wheel has been dressed.

After setting the Top Plate Angle and Offset, set Depth of Grind. With the chain securely clamped and the motor turned off, pull the motor down until the grinding wheel sets down in the cutter link to the desired depth. Adjust the depth setting to that depth and lock in place with the jam nut. Depth setting knob located on top of the machine. (There will be final adjustments of the depth setting after the grinding wheel has been dressed.)

DRESSING THE GRINDING WHEEL

This is one of the most important steps in chain grinding, as the form or shape of the grinding surface of the wheel determines the cutting angles of the chain (See Figure 2-24).

READ THIS ENTIRE STEP BEFORE DRESSING THE GRINDING WHEEL!

DRESSED GRINDING WHEEL FUNCTIONS

Portion "A" grinds the Top Plate Angle and Top Plate Cutting Angle.

Portion "B" grinds the Side Plate Angle.

Portion "C" is used to grind the gullet and to keep it smooth and flat.

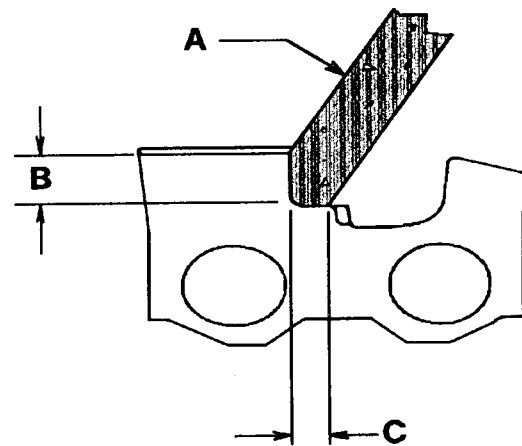


FIG 2-24

SECTION 2-3: MANUAL SHARPENER - cont'd

To dress a grinding wheel properly, the results and remedies of improper wheel dressing must be known. Using the popular Chisel-type saw chain as an example, Figure 2-25 shows the proper angles.

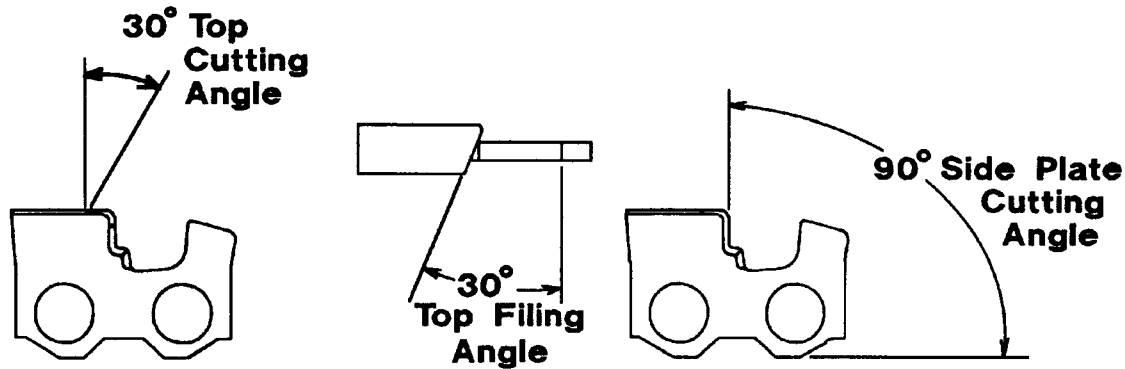


FIG 2-25

RECOMMENDED PROCEDURE FOR DRESSING THE WHEEL:

A. Tilt the cutting head to 30 degrees.

B. Dress section "C" of the wheel by holding the dressing stone horizontal and dress a flat on the bottom of the grinding wheel (See Figure 2-26). This is the portion that will grind the gullet area.

C. After obtaining the results shown in Figure 2-26, hold the dressing stone vertical and dress the vertical portion "B" which grinds the side plate angle of the cutter link (See Figure 2-27). If you dress the wheel too far at this point, the portion "B" will be too large and will cause the side plate angle to run into portion "A" and "C" during the grinding process.

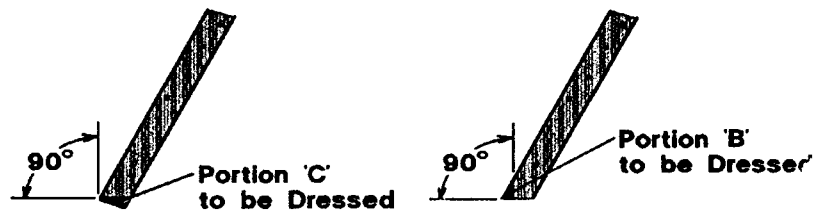


FIG 2-26

FIG 2-27

Figures 2-28 through 2-30 show results and remedies of improper wheel dressing.

Curved or blunt Top Plate Angle caused by worn wheel (See Figure 2-28). The radius of portion "B" has worn into the "A" region. To correct, redress the wheel to decrease the size of area "B" on the wheel.

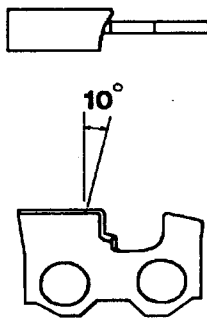


FIG 2-28

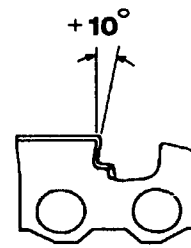
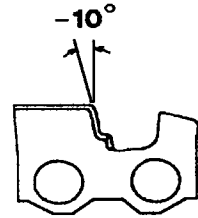


FIG 2-29

SECTION 2-3: MANUAL SHARPENER - cont'd

Positive Hook on Side Plate Angle (See Figure 2-29). Make sure that portion "A" is grinding only the Top Plate Cutting Angle and not the Side Angle. Make sure portion "B" of the grinding wheel has been dressed vertically.



Negative Hook on Side Plate Angle (See Figure 2-30) caused by the portion "B" of the grinding wheel being dressed with a negative angle. Make sure portion "B" of the grinding wheel has been dressed vertically.

FIG 2-30

SET THE INDEXING PAWL

Using the thumb bolt adjuster (front left of the machine), set the indexing pawl to the back side of the cutter that is being sharpened (See Figure 2-31), to a position that will sharpen just enough cutter to regain a new, clean edge. After setting the indexing pawl, refer back to Figure 2-23 to make the final offset setting and also the correct depth setting to leave a clean, flat gullet.

Make sure the shim between the clamping plates is in place. The chain should be clamped when grinding each tooth and released when indexing or when adjusting the indexing pawl.

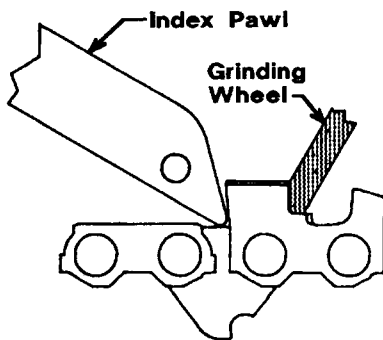


FIG 2-31

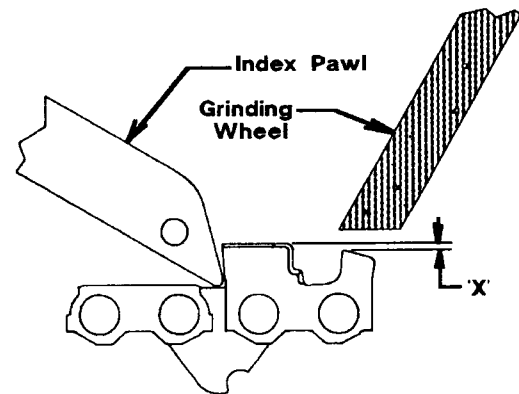


FIG 2-32

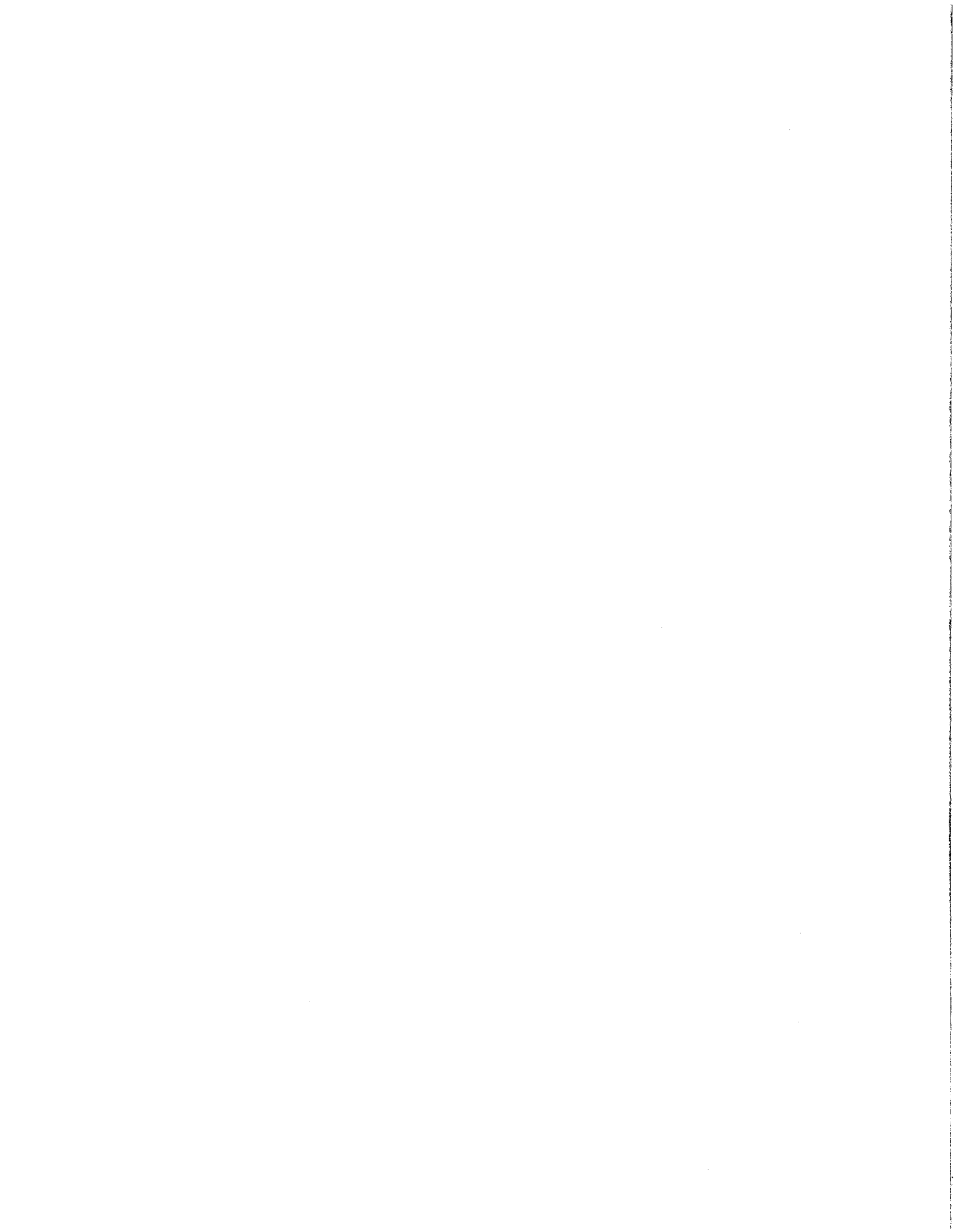
GRINDING THE DEPTH GAUGES

The depth gauges are the part of the chain that regulate how deep each tooth bites into the wood. If the depth gauge is not ground deep enough, the chain will cut slower than it should. If the depth gauges are ground too deep, the chain will become too aggressive. An aggressive blade will tend to get stuck in the cut and also overwork the engine. A blade with properly-ground depth gauges and properly sharpened teeth will actually self-feed into the wood.

Depth gauges should be maintained at the saw chain manufacturer's recommended setting (X). Use a 1/4" grinding wheel with the bottom of the wheel ground flat (See Figure 2-32). Position the clamping plate line directly under the center of the wheel and set the depth of grind to grind the depth gauge level to the manufacturer's specifications. Position the depth gauge directly under the grinding wheel and then adjust the pawl to the back side of the tooth. Grind the depth gauges by clamping and indexing as you would during the sharpening process.

When grinding the depth gauge, there must be a radius on the right side of the gauge or the top of the gauge should be ground with a downward angle to the right to prevent the depth gauge from hanging up in the cut by a sharp leading corner.

NOTE: The procedure outlined in this manual is just one of many ways to sharpen a chain saw blade. Individual requirements may call for changes to some of the basics of this instruction.



SECTION 2-4: AUTOMATIC SHARPENER INSTRUCTIONS

The Wood-Mizer LTAGA Automatic Grinder Assembly is shipped completely assembled except for the stand and support arms. The kit includes:

- Automatic Grinder Assembly
- Two-height Stand Assembly
- Coolant and Pump
- Bag Assembly Containing Small Parts
- Grinding Wheels
- Support Arms
- Bag Assembly Containing Parts for Manual Operation

STAND ASSEMBLY

The Automatic Grinder Stand Assembly includes 3 short tubes, 3 long tubes, and 1 tray assembly.

The stand can be set up at two different heights (for sitting or standing). If sitting setup is desired, assemble the 3 long tubes to the sockets in the top of the tray assembly (See Figure 2-33). If necessary, use a wood block and hammer to seat the tubes in the sockets. Assemble the Grinder Assembly to the three tubes.

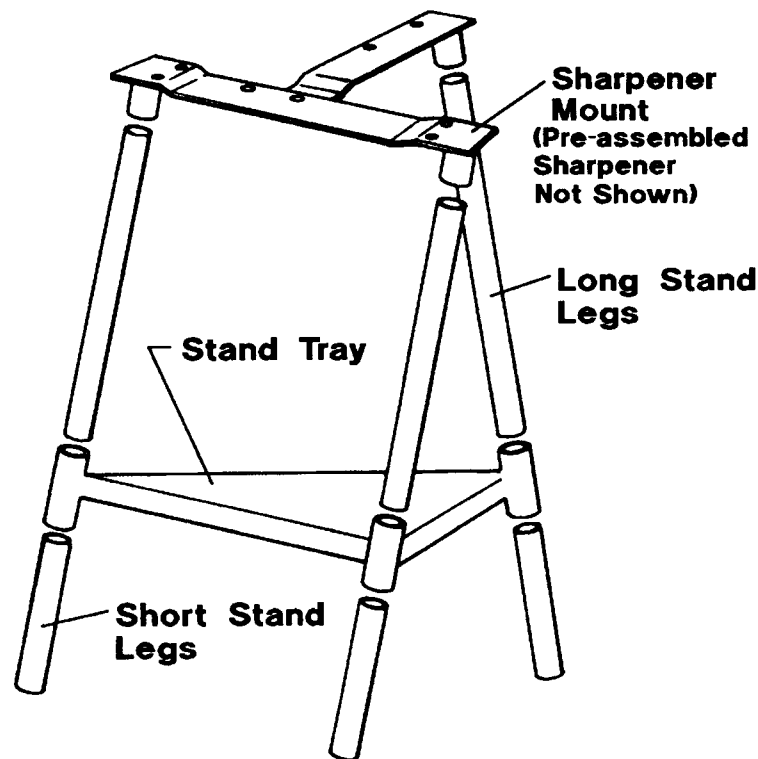


FIG 2-33

If standing setup is preferred, add the remaining three short legs to the bottom of the tray assembly.

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

Plug the hole in the tray with the rubber plug provided. Connect the nylon fitting to the pump and lay the pump in the water tray. Connect the empty end of the plastic hose to the pump fitting. Plug the pump into the cord on the converter box.

Note: Disregard the fitting supplied with the pump. It will not be used in this assembly.

WARNING: DO NOT OPERATE THE PUMP UNTIL IT IS SUBMERGED IN WATER. DRY OPERATION WILL CAUSE DAMAGE TO THE PUMP!

Plug the converter into grounded 115 volt receptacle (See Warning Below).

Wood-Mizer®
AC/DC Converter
Part No. A10531

INPUT: 115VAC OUTPUT: 14VDC (Nominal) 15 AMPS

WARNING

For the user's safety, the power cord on this product has a grounded plug. This power cord should only be used with properly grounded (3-hole) receptacles to avoid electrical shock. To prevent electrical shock hazard, this unit must be connected to a GFI (Ground Fault Interrupter). The National Electrical Code, Article 680-41(A), requires a GFI be installed in the branch circuit supplying fountain equipment rated above 15 volts. See your local electrical supply dealer for various brands of GFI'S.

Install a blade support arm in each of the three threaded holes located around the bottom of the vertical plate of the sharpener. Assemble a blade support roller onto the end of each arm as shown in Figure 2-34. Remove the inner post of the left roller, the inner post of the rear roller, and the outer post of the right roller as viewed from the front of the sharpener. These are not used in the automatic sharpener setup. Unscrew the remaining post of the right roller and remove the bushing. Replace with the short bushing supplied and the plastic roller as shown in Figure 2-35. The left roller should be adjusted to about 5" in from the end of the support arm. The rear roller about 1" from the end of the support tube, and the right roller about 3" from the end of the support arm. Tilt the right roller assembly slightly towards the operator. Final adjustments of these rollers can be made after a blade is installed into the sharpener.

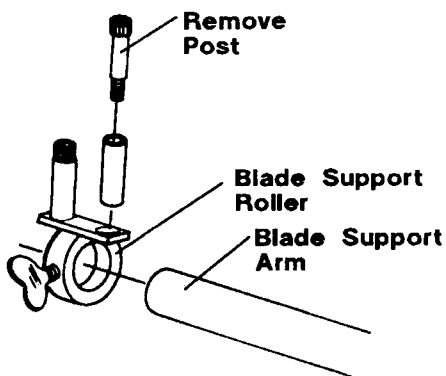


FIG 2-34

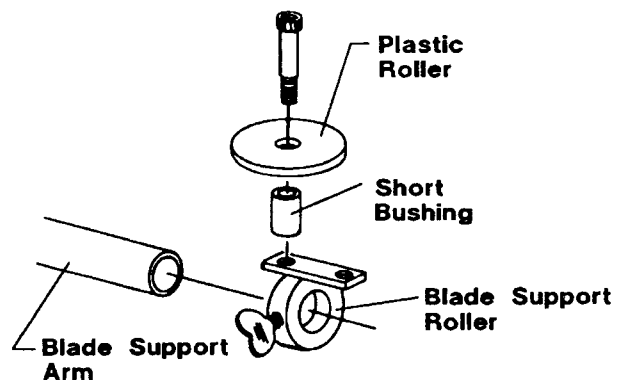


FIG 2-35

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

Fill the water tray to about 1" from the top edge and add approximately 1/6 bottle of coolant.

Turn on the converter switch. A lighted switch indicates the converter is "on". Plug the pump into the converter box and check to see that the pump is operating by opening the loc-line valve for water flow. With the control box speed setting at '0', Push the "START" button on the control box. Turn the sharpener switch to "ON". The sharpener motor should come on and the shaft should rotate counter-clockwise when viewed from the end of the shaft. Increase the speed setting on the control box to engage the automatic sharpener attachment. The cam assembly should also be rotating counter-clockwise. **NOTE:** If the cam assembly does not come to a complete stop when the control is set to '0', adjust the potentiometer (pot) accessed through the top of the control box. With the control set at '0', turn the pot on the left (as viewed from the front of the control box) counter-clockwise with a small screwdriver until the cam assembly comes to a complete stop.

Check all controls for proper operation of grinder assembly. If something fails to operate, check connections as shown in Figure 2-36.

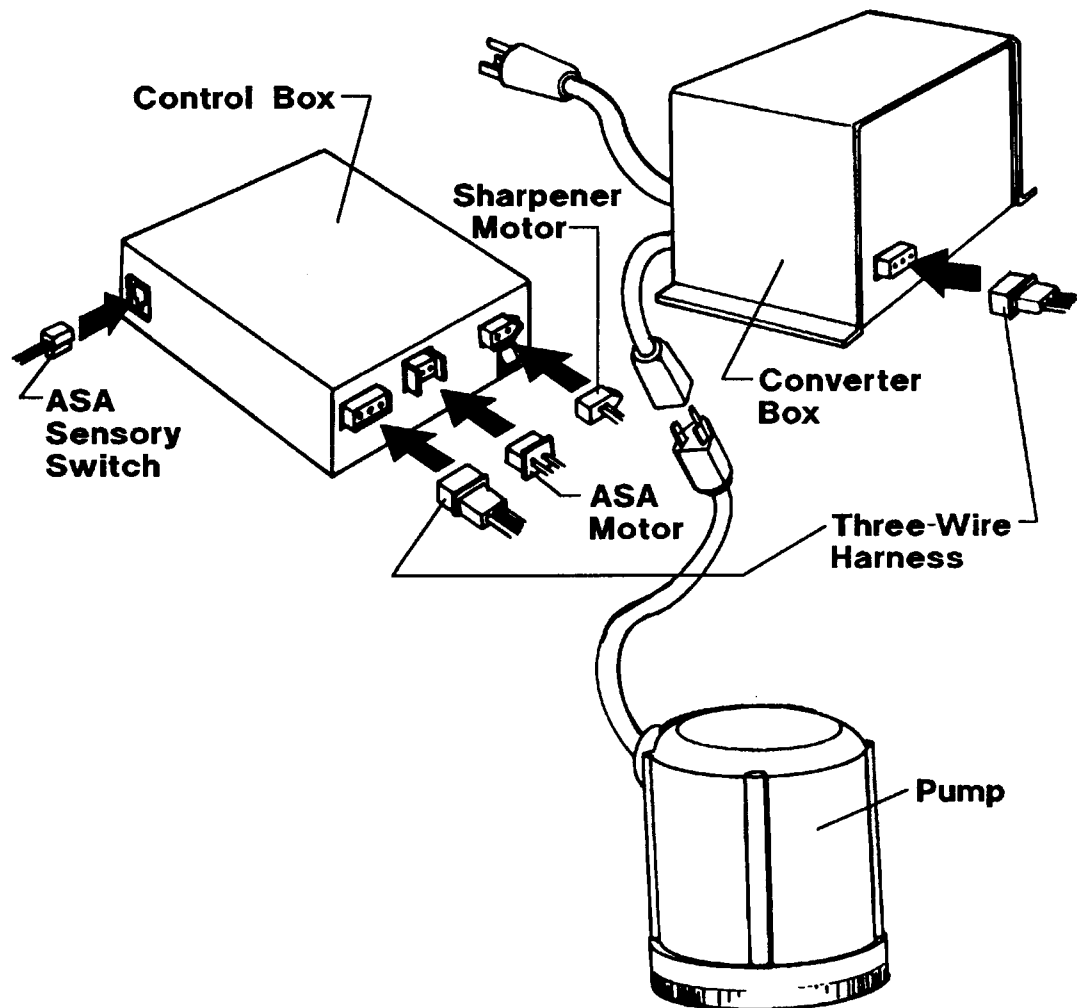


FIG 2-36

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

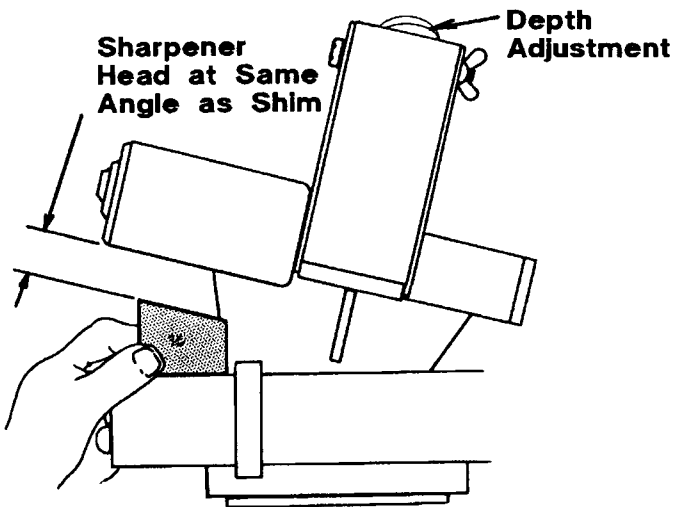


FIG 2-37

SET HOOK ANGLE

Before installing a grinding wheel, set the hook angle at 10 degrees. Since the automatic attachment hinders viewing of the hook angle scale, angled templates are provided to check the angle. The one marked "10" should be used in most cutting applications (The 15 degree template is used primarily when cutting soft woods). Set the straight portion of the template on the clamping fixture, loosen the depth adjustment and/or the back grind adjustment until the sharpener head rests on the hook angle template. (See Figure 2-37). The hook angle is adjusted by loosening the bolt in the vertical plate of the sharpener and tipping the sharpener head until the desired angle is achieved. Be sure the angle is maintained after tightening the adjustment bolt.

INSTALLING THE GRINDING WHEEL

Select a 5" diameter, 1/4" wide grinding wheel with a 1/2" bore for sharpening Wood-Mizer blades.

CAUTION: Check the grinding wheel for cracks or chips before using it.
If the wheel is cracked or chipped, **DO NOT USE IT!**
Do not use the wheel after it wears to the edge of the blotters.
Remove the grinding wheel while transporting the sharpener to prevent cracking or breakage due to jarring or bumping of the unit

Remove the right side cover from the grinder head by removing the wing nut. Remove the knurled knob from the motor shaft. Place a grinding wheel on the shaft and replace the knurled knob, flanged side towards the grinding wheel and hand tighten. Replace the cover and wing nut.

CAUTION: ALWAYS WEAR EYE PROTECTION WHEN OPERATING THIS EQUIPMENT.

DRESSING THE GRINDING WHEEL

Before sharpening a new blade, dress the wheel to match the shape of the tooth. There are three areas to the wheel that need to be dressed to ensure proper sharpening (See Figure 2-38). Dress Section 'C' first by holding the dressing stone horizontally and dress a flat surface on the bottom of the grinding wheel (See Figure 2-39). This is the area that will grind the gullet base.

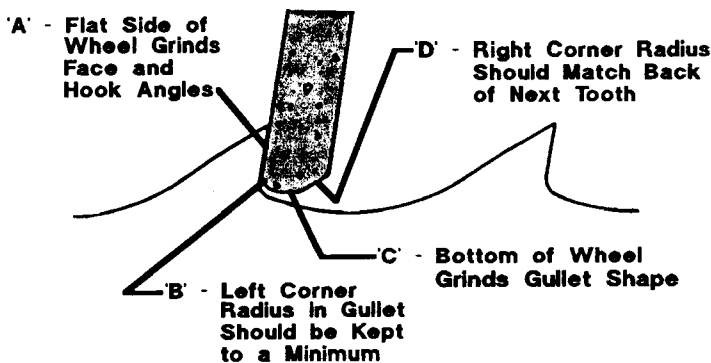


FIG 2-38

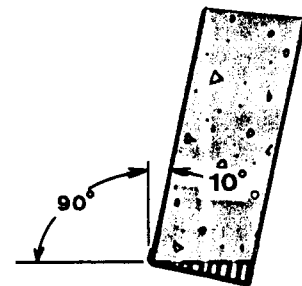


FIG 2-39

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

After obtaining the results shown in **Figure 2-39**, dress a small radius on Section 'B' of the grinding wheel as shown in **Figure 2-40**. During sharpening, this is the section which does most of the grinding and therefore requires the most maintenance. As you sharpen, Section 'B' will wear into a larger radius and start wearing into section 'A' as shown in **Figure 2-41**. The result will be little or no hook angle left in the tooth. The straight portion of the tooth (Section 'A') should extend approximately 3/4 of the way down the tooth height (See **Figure 2-42**). If Section 'A' is 2/3 of the tooth height or less, the wheel needs to be redressed. Recommended procedure for re-dressing the wheel is to dress the bottom of the wheel flat again as described in the previous step. Re-dress a small radius on Section 'B', if necessary.



FIG 2-40

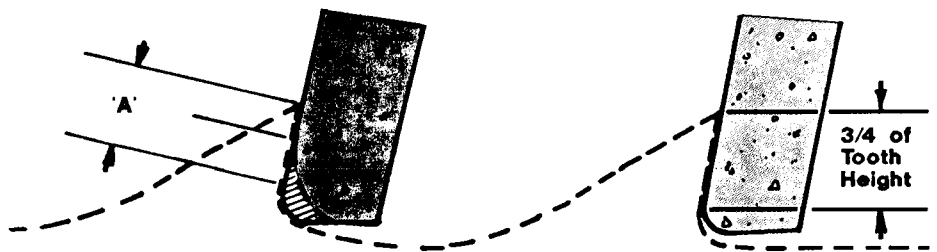


FIG 2-41

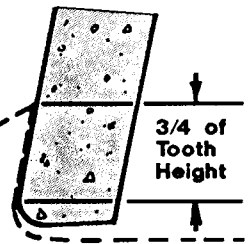


FIG 2-42

Readjust the depth of the wheel to the gullet of the blade. **NEVER** attempt to dress the wear area by using the dressing stone on the side surface (Section 'A') of the wheel. Depending on the amount of material being removed from the teeth while sharpening, it may be necessary to re-dress the wheel each time a blade is sharpened.

Section 'D' of the grinding wheel is only needed when "back grinding" the teeth. This section should be dressed at the same angle as the back of the teeth.

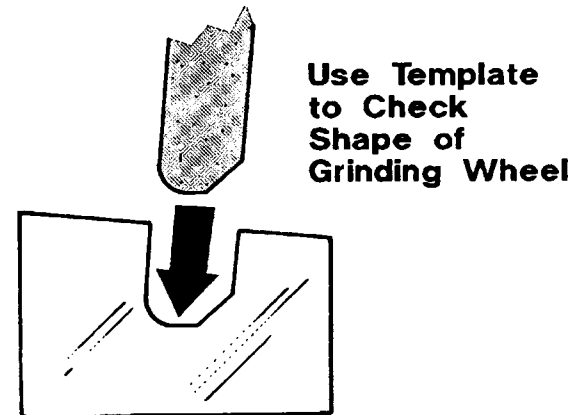


FIG 2-43

GRINDING WHEEL PROFILE GAUGE

A profile gauge is supplied with each sharpener to help you properly maintain the shape of the grinding wheel. Simply slip the template onto the edge of the grinding wheel (with sharpener **NOT** running) and check to see the wheel matches the shape of the profile template (See **Figure 2-43**). Redress as necessary and check with the template again.

BEFORE INSTALLING A BLADE: Make sure the cam pivot bolt is at the 2 o'clock position. Adjust the depth gauge until there is at least 1/2" between the bottom of the grinding wheel and the blade clamp plates. Next, adjust the back grind adjustment until the cam bearing is contacting the cam (See **Figure 2-44**). These adjustments will help prevent a collision of the grinding wheel with some of the other moving parts.

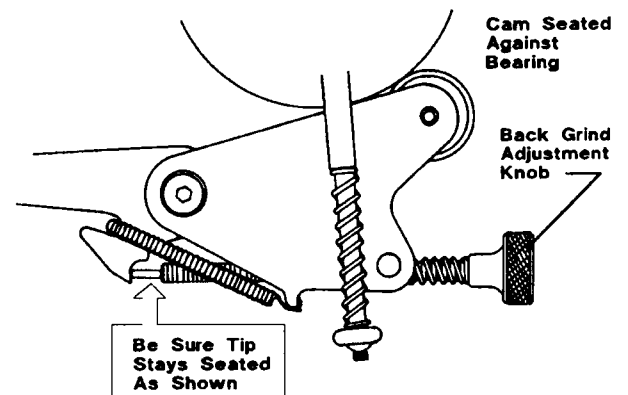


FIG 2-44

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

INSTALLING THE BLADE

Be sure the clamping fixture is unclamped. Rotate the cam of the automatic attachment to a 2 o'clock position as shown in **Figure 2-45** (this will allow the indexing arm to clear the grinding wheel). With your right hand, lift the sharpener head with your thumb and indexing arm with your fingers. Set the blade into the clamping plates with the teeth leaning to the right. Position the blade on all three roller supports. Clamp the blade in the clamping fixture.

ADJUSTING THE AUTOMATIC SHARPENER ATTACHMENT

Once the grinding wheel has been properly dressed and a blade installed into the sharpener, you are now ready to fine tune the automatic attachment and start sharpening the blade. There are three adjustments that will need to be made regularly when using the automatic sharpener. They are typically made in this order:

1. Face Grind
2. Depth of Gullet
3. Back Grind

1. The face grind adjustment determines how much material will be ground off the face of each tooth. By adjusting the two aluminum knobs of the indexing arm (**See Figure 2-45**) to the right, less material will be ground from the tooth face. Adjusting the two knobs to the left will cause a heavier grind on the face of the tooth. These knobs must be tightened against the adjustment block to maintain proper alignment.

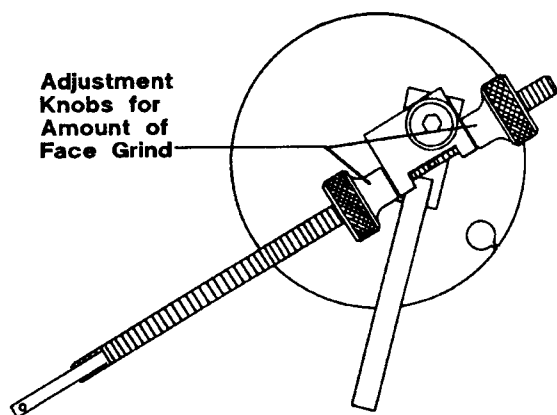


FIG 2-45

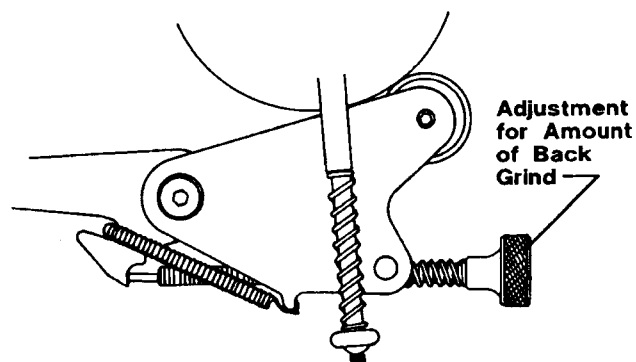


FIG 2-46

2. The gullet depth adjustment raises or lowers the grinding wheel to grind the proper tooth height in the blade (**See Figure 2-37**). The depth of gullet should be set for a nominal 3/16" tooth height.

NOTE: If you attempt to grind too much material at once or dress the grinding wheel heavily, the circuit breaker in the control box may kick out. If this happens, simply wait 15 seconds and push the switch located on the back of the control box so that it locks back in.

3. The back grind adjustment determines how quickly the grinding wheel will be lifted from the gullet grind (**See Figure 2-46**). Turning the adjustment knob clockwise (CW) will lift the grinder head earlier in the sequence, which means you will be grinding less from the back of the tooth. Turning the knob counter-clockwise (CCW) will delay the lifting action of the grinding wheel, allowing it to contact the back of the teeth.

HINT: Spin the grinding wheel by hand when making each adjustment. Each adjustment will be fine turned after the grinding wheel has been turned on.

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

With the sharpener switch in the "OFF" position and the control box setting on '0', lift the sharpener head and push the "START" button on the control box. Slowly increase the control setting until the index arm contacts a tooth, pushes it to the left and rotates away from the tooth. Turn the control setting back to '0' and push the "STOP" button. Lower the sharpener head (the sharpener should NOT be running) and let the grinding wheel contact the tooth. Rotate the grinding wheel by hand to check the amount of grind on the face of the tooth. If the grind is too heavy, rotate the adjustment knobs in **Figure 2-45** counter-clockwise. If the grind is too light, turn the knobs clockwise. Hold the sharpener head up and push the "START" button. Increase the control setting until the index arm places the next tooth in position under the grinding wheel. Turn the control to '0', push "STOP", and check the grind of the wheel against the tooth. Repeat adjustments as necessary.

With the grinding wheel down against the tooth face, adjust the depth setting (top knob on sharpener) to the desired height (A nominal 3/16 tooth height is recommended).

With the sharpener still "OFF", push the "START" button and increase the control setting. Check the contact of the grinding wheel against the back of the tooth to right of the one being sharpened. If no back grind is desired, adjust the knob shown in **Figure 2-46** clockwise until the grinding wheel clears the back of the tooth. If back grind is desired, adjust the knob counter-clockwise to the desired backgrind.

Turn the control setting to '0' and stop the automatic attachment so the grinding wheel is about to come down and grind the face of a tooth. Start the water flow with the Loc-line valve and adjust the Loc-line so the water floods the tooth under the grinding wheel. Turn the sharpener to "ON" and slowly increase the control setting. Most sharpening is done at speeds 1 and 2 to give a clean grind and also to prolong the life of the grinding wheel. The automatic attachment should now be sharpening each tooth automatically. Fine adjustments of the face and back grind knobs may be made while the blade is being sharpened. The shut-off magnet should be placed behind the 6th FACE ground tooth along the bottom edge of the blade if you are grinding blades with 3/4" tooth spacing. The magnet must be installed with the painted side facing away from the blade. If you are grinding a blade with 7/8 tooth spacing, place the magnet behind the 5th FACE ground tooth. As the blade rotates and the magnet returns to the front, it will contact the shut-off switch and stop the sharpener at the last tooth to be sharpened. After the blade has been sharpened, turn the water valve off, turn the sharpener to "OFF", the control setting to '0', and unclamp the clamping fixture.

Remove the blade in the same manner it was installed. See Section 2.3 for trouble-shooting blade sharpening problems.

**CAUTION: Always turn off the converter box after you have finished sharpening for the day.
LEAVING THE POWER ON COULD DAMAGE THE WATER PUMP!**

SECTION 2-4: AUTOMATIC SHARPENER - cont'd

USING THE MANUAL BACK-UP PARTS

A bag assembly is included with your grinder that contains parts that will allow you to manually sharpen blades if your automatic attachment or control box should ever fail.

Perform the following operations on your automatic grinding assembly:

Rotate the cam pivot bolt to a 2 o'clock position. Remove the bolt holding the index arm to the cam and remove the arm from the cam (See Figure 2-47).

Remove the blade fixture clamp, spring, washer and nut.

Disconnect the lift arm from the sharpener head by removing the jam nut. Replace the jam nut after removing the lift arm.

Disconnect the sharpener motor pigtail and the converter box pigtail from the control box.

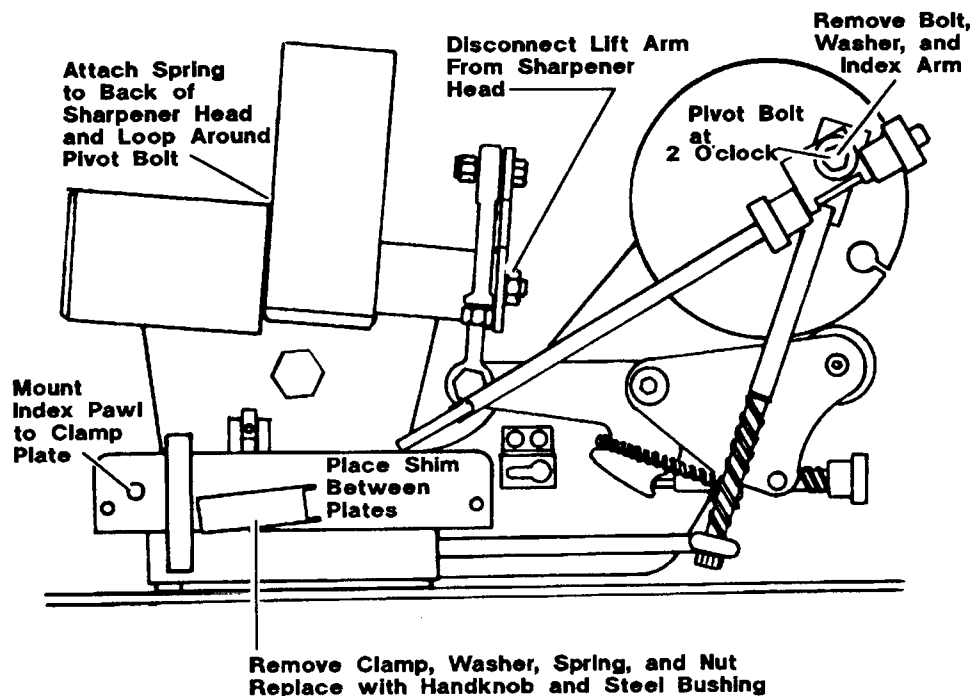


FIG 2-47

Use the supplied parts to convert the sharpener to manual operation:

Mount the index pawl assembly to the blade fixture with the socket head set screw.

Place the shim between the blade fixture clamp plates and install the clamping knob and bushing.

Install the spring in the two holes at the back of the sharpener head. Loop the spring down around the pivot bolt and install the provided nut on the pivot bolt.

Connect the supplied wiring harness to the the sharpener motor pigtail and plug the other end into the converter box.

See Section 2.3 in your Wood-Mizer® manual for manual sharpening instructions.

SECTION 2-5: TOOTH SETTER/GAUGE OPERATING INSTRUCTIONS

There are two steps to maintaining blades used on the Wood-Mizer sawmill. They should **always** be followed in this order:

1. Blade Sharpening
2. Toothsetting

The blades supplied by Wood-Mizer have a raker style set in the teeth. If you view a blade standing on edge, you will see the teeth are set (or bent out) in a repeating sequence; straight, right, and left (**See Figure 2-48**). The teeth that are set left and right do the cutting while the straight teeth (rakers) clear the cut of sawdust. Checking the set of a new blade is recommended as some blades may have inconsistently set teeth from the manufacturer. As the blade is sharpened and the face of the tooth recedes, the set will become smaller (**See Figure 2-49**). You should check the blade regularly with the setter/gauge to see that .011"-.017" (for thin blades), or .015"-.021" (for thick blades) set is maintained. All teeth should be set the same amount within .001" (+ or -).

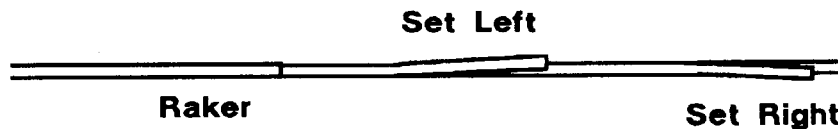


FIG 2-48

The optional LTTSG Tooth Setter/Gauge is a fixture that will accurately and evenly set the teeth of a bandsaw blade. Proper setting practices are critical to efficient and accurate sawing.



FIG 2-49

The spring loaded clamping mechanism allows you to position a tooth in front of the gauge, clamp it, measure the set, then bend the tooth by continuing the clamping motion. Follow the proceeding instructions to properly operate the tooth setter/gauge.

Deburring the Blade

If a blade is to be checked for proper set immediately after sharpening, the blade **MUST** be deburred before the set can be checked. The sharpening process leaves tiny burrs on the back side of the teeth which will cause the setter/gauge to give inaccurate readings. To remove the burrs, simply remove the blade from the sharpener, invert it so the inside of the blade is facing out, and drag the block of wood across the blade in the opposite direction that the teeth cut. Use the weld in the blade as a reference for starting and stopping. If the blade to be reset has been cut with, clean the blade before removing from the mill by engaging the clutch and running the water lube option on it for 15 seconds. After removing the blade, wipe dry with a rag to keep it from rusting. Cutting with a blade removes the sharpening burrs so deburring is not necessary before resetting.

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

TOOTH SETTER/GAUGE SET-UP

The LTTSG Tooth Setter/Gauge may be mounted on a workbench or stand using the mounting holes found in the base plate of the setting fixture. The setter may also be mounted to the front pin of one of the bed rails of the mill by using the provided 'J'-hooks, wing nuts, and washers. Mount the setter so that there is at least 32" to the rear and to either side of the tool to allow enough room for the blade supports. Refer to Figure 2-50 to identify parts of the tooth setter which will be referred to throughout these instructions.

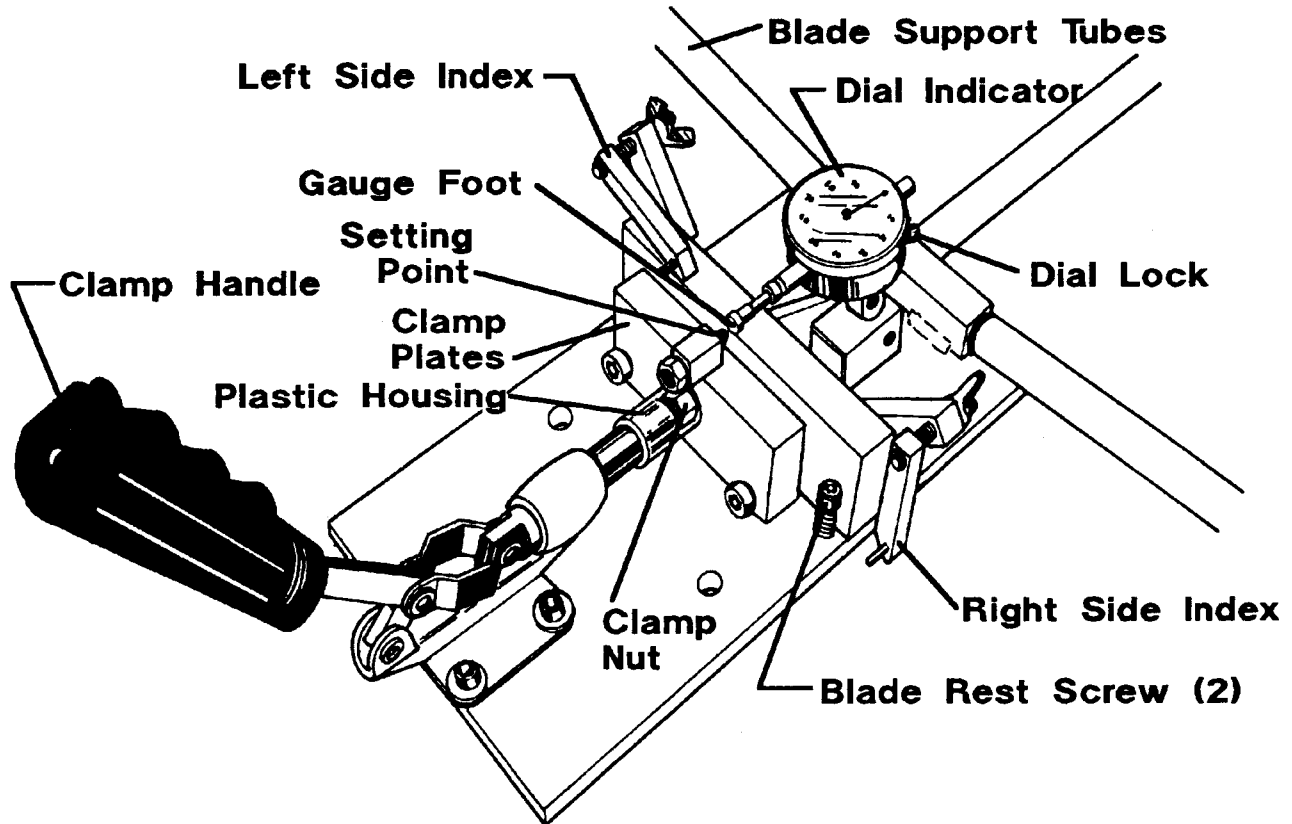


FIG 2-50

Install the three blade support tubes to the threaded mounting bar found at the rear of the setter. Slide a blade support roller onto each blade support tube (See Figure 2-51) about 1" from the ends of the right and rear tubes and 2 1/2" from the left tube (minor adjustments may be necessary for maximum freedom of circular travel of the bandsaw blade).

Adjust both the left and right index pawl assemblies down out of the way. These will be adjusted later.

The dial indicator of the tooth setter/gauge is pre-aligned at the factory. The alignment of the gauge should be checked when setting up the setter to ensure it has not been bumped out of alignment during shipment.

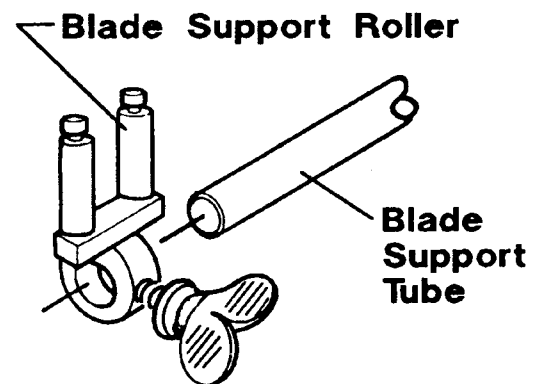


FIG 2-51

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

To check the gauge:

1. Turn the plastic housing to adjust the clamp nut (See Figure 2-52) so the alignment shim can be clamped firmly in the middle of the clamping fixture, directly in front of the gauge foot (be sure the setting point is adjusted back as not to contact the shim). The clamping fixture is opened and closed by throwing the clamp handle forward and back. The clamp nut allows you to open the space between the clamping plates for different thicknesses of blades. It should be adjusted so that a light push on the handle locks the blade (or alignment shim) tight.

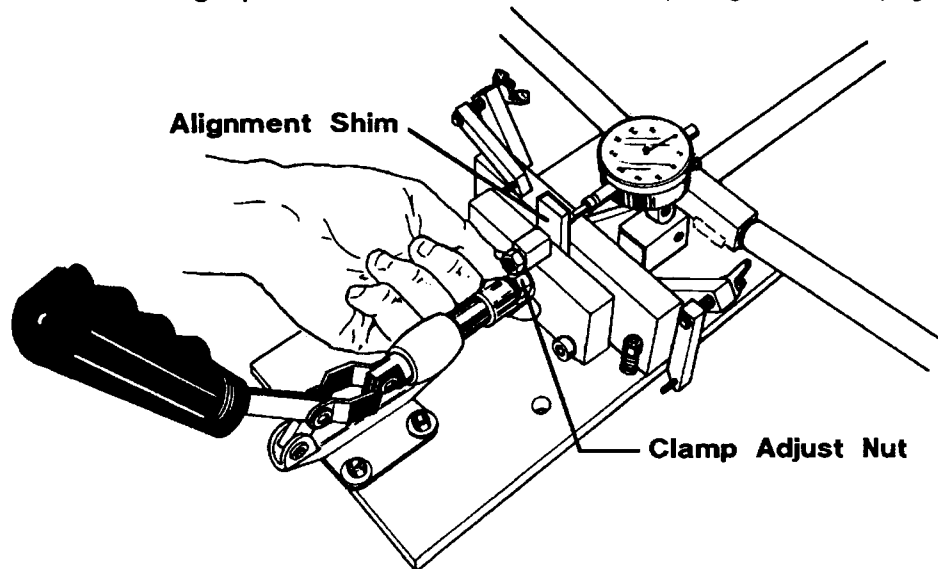


FIG 2-52

2. With the alignment shim firmly clamped in front of the gauge foot, check the indicator dial and see that it reads '0'. Hold a light to one side of the setter and look in from the opposite side to see that the gauge foot is **completely** flat against the alignment shim. There should be no light visible between the foot and the shim. If this alignment is out, refer to the realignment instructions.

3. Remove the alignment shim and place a blade in the blade supports so it lies in all three roller assemblies and routes through the clamping fixture of the setter. Readjust the clamp nut so a light push on the clamp handle holds the blade firmly. Adjust the blade rest screws up or down so that the gullet of the blade is even with the top edge of the clamping plates (See Figure 2-53). During the actual setting operation, the blade rest screws will be adjusted according to tooth height (See Tooth Setter/Gauge Operation). The blade support tubes may need to be bent down in order to prevent them from raising the blade off of the rest screws.

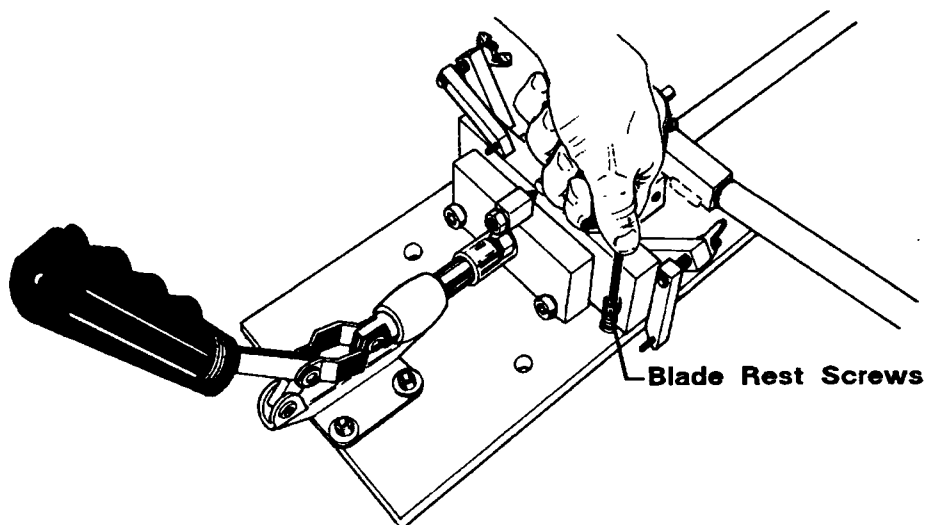


FIG 2-53

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

4. Rotate the blade around the supports until a tooth set toward the dial indicator is positioned in front of the gauge foot. Clamp the blade so the tip of the tooth is located to one side of the gauge foot (See Figure 2-54). Note the reading on the dial indicator, unclamp the blade and move so the tip of the same tooth is located on the other side of the gauge foot. Reclamp the blade and check the dial reading again. When the gauge foot is properly aligned in the horizontal plane, these two readings will be identical ($\pm .0005$). If adjustment is necessary, realign the gauge per the following instructions.

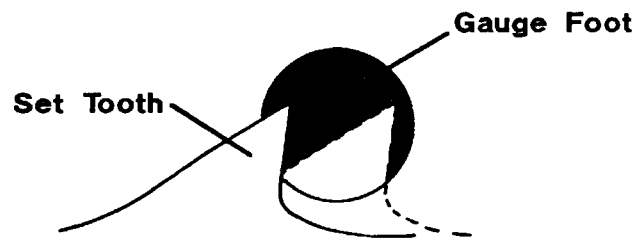


FIG 2-54

To realign the gauge:

NOTE: The following adjustments require good lighting and eyesight to achieve the required alignment. It is also recommended that a second person be present to help lock down the gauge while you make sure the gauge remains aligned. This alignment is critical for proper operation of the setter and particular attention should be directed toward achieving exact alignment of the gauge assembly.

1. The gauge assembly is mounted to the setter in such a way as to provide four separate adjustments (See Figure 2-55). Loosening Bolt 'A' allows you to adjust the vertical angle of the indicator. Loosening Bolt 'B' will allow you to slide the gauge assembly forward and back. Loosening Set Screw 'C' will allow you to pivot the indicator horizontally and raise or lower the indicator. Adjustments of the gauge are explained in the following steps.

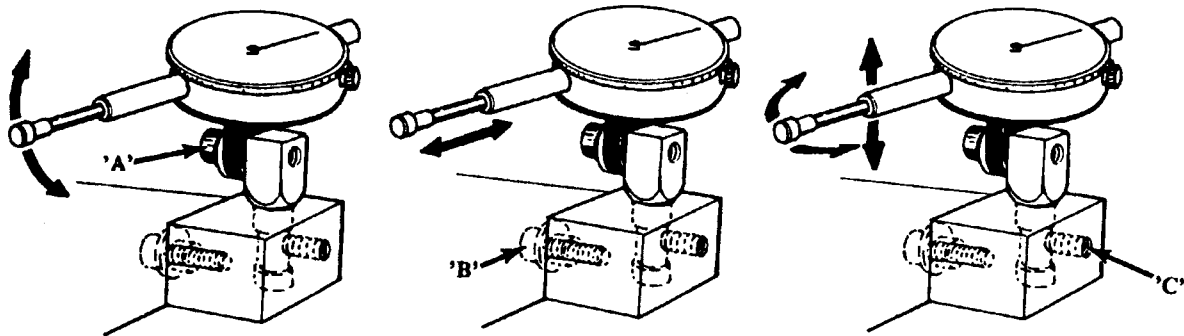


FIG 2-55

2. Clamp the alignment shim in the clamping fixture as described previously.

3. Adjust the face of the dial indicator so the '0' is at approximately the 12 o'clock position. Tighten the dial lock to maintain this adjustment. Hold a light behind one side of the setter and look in from the opposite side to check that the gauge foot is completely flat against the shim. There should be no light showing between the shim and the foot. If the gauge foot is not completely flat against the shim, loosen Bolt 'A' and adjust the vertical angle of the indicator so that no light shows between the foot and the shim. Retighten Bolt 'A' and check the reading of the dial indicator. If the indicator reads '0', go on to the next step. If not, loosen Bolt 'B' and slide the gauge assembly forward or back until the indicator reads '0'. Be sure the gauge foot remains flat against the shim and retighten Bolt 'B'.

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

4. Remove the alignment shim and mount a blade in the blade supports as previously described. Readjust the clamping fixture and blade rest screws as described earlier. Rotate the blade around the supports until a tooth set toward the dial indicator is positioned in front of the gauge foot. Throw the clamp handle to clamp the blade so the tip of the tooth is located to one side of the gauge foot (See Figure 2-56). Note the reading on the dial indicator, unclamp the blade and move so that the tip of the same tooth is located on the other side of the gauge foot. Reclamp the blade and check the dial reading again. When the gauge foot is properly aligned in the horizontal plane, these two readings will be identical (+.0005).

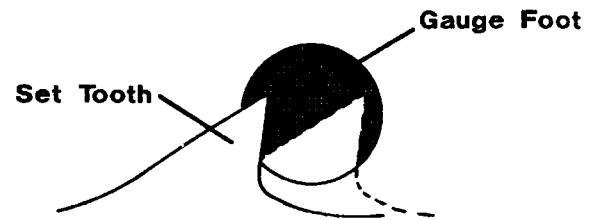


FIG 2-56

5. If adjustment of the gauge in the horizontal plane is necessary, loosen Set Screw 'C' and pivot the gauge slightly. Recheck with a set tooth on both sides of the gauge foot again. Adjust until the same reading occurs with the blade clamped so the tooth is at either side of the gauge foot (within .0005). Loosening Set Screw 'C' also allows you to raise and lower the gauge assembly. The gauge should be adjusted so that the tip of the teeth of a blade are positioned above the center of the gauge foot.

The gauge assembly is properly aligned in the vertical plane when the dial indicator reads '0' while the gauge foot is completely flat against the alignment shim. The gauge assembly is aligned in the horizontal plane when the dial indicates the same measurement of set when a set tooth is clamped on either side of the gauge foot. Time should be taken to accurately achieve both the vertical and horizontal alignments. Once the gauge assembly is aligned, it should not need readjusting although periodic checking is recommended to be sure the alignment has not been lost due to jarring or use of the tooth setter.

TOOTH SETTER/GAUGE OPERATION

Once the tooth setter/gauge alignment has been checked and necessary adjustments made, it can now be used to measure and reset blades.

It is recommended that the setter/gauge be used to measure new blades to check for inconsistent set teeth. It should also be used to check a used blade to see if it requires resetting. A maximum set of .017" (for .035" blades) or .021" (for .042" blades) is recommended for most cutting applications. When a blade is sharpened, the amount of set is reduced. The set should not be allowed to fall below .011" (for .035" blades) or .015" (for .042" blades). The set should not vary more than .001" (+) from one tooth to the other.

NOTE: The tooth setter/gauge sets and measures the teeth that are set away from the operator toward the dial indicator. The blade will need to be inverted (inside-out) to set/measure the teeth set in the opposite direction.

Be sure the blade is clean before placing it in the setter. Sap buildup on the blade or tooth will give false set readings. Metal burrs created by sharpening may also cause false readings. These burrs usually are removed while sawing and should only present a problem if you try to measure the set directly after sharpening without using the blade first. Refer to the deburring instructions if setting a blade immediately after sharpening.

Mount the blade in the setter as previously discussed in the alignment portion of this section. Adjust the blade rest screws so the point of the tooth will lie approximately at the center of the gauge foot.

To reset the teeth of the blade:

1. Place the blade in the setter and rotate the blade to bring the weld (or one of the welds) into the clamping/setting assembly, making sure the teeth are pointing to the right. You will be starting with the first tooth to the right of the weld that has been set back toward the dial indicator. Position that tooth in front of the gauge foot on the dial indicator. Adjust the clamp nut so a light push on the clamp handle will lock the blade firmly in position.

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

2. Adjust the blade rest screws so the setting point will contact the proper point on the tooth (See Figure 2-10). As tooth height varies due to "gumming out" of the gullet during sharpening, the rest screws will need to be adjusted to ensure the setting point contacts the tooth at the midpoint of its height. Slide the blade to the left or right so the setting point contacts the tooth as close to the front edge of the face as possible. Lock the blade in position with the clamp handle.

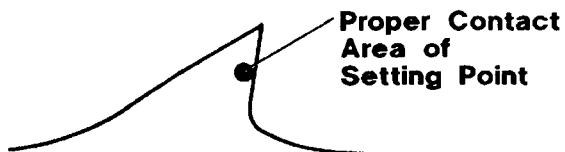


FIG 2-10

3. Adjust the right side index pawl firmly against the tooth two teeth to the right of the one being set. Lock the pawl in position with the allen wrench provided. (If you are like most customers, the tooth spacing in your blades is probably not very accurate in the first couple of teeth. If this is the case, you will be better off adjusting the indexing pawl on a set of teeth 1/2 way around the blade, then come back to the weld. You may have to lift the pawl out of the way and locate the teeth by eye, until the tooth spacing becomes more regular).

4. Loosen the setting point lock nut and adjust the setting point with the allen wrench until it begins to bend the tooth against the gauge foot of the dial indicator.

Example: If you are setting an .042 blade and you want to set it from .015 set up to .020 set, you will need to bend the tooth to approximately .040 as the "memory" of the tooth will cause it to spring back to approximately .020 set. The .040 dimension may need to be adjusted up or down depending on where the tooth bends back to. To check the amount of set in the tooth, release the clamp handle just enough so that the setting point does not contact the tooth but the spring loaded stops hold the blade firmly. The reading on the dial is the amount of set the tooth now has. If it is too much, bend the tooth back with pliers and readjust the setting point back. If the set is not enough, readjust the setting point forward. Repeat the setting procedure for the first tooth until the desired set has been obtained.

5. Unclamp the blade, loosen the lock nut on the setting point without changing the adjustment of the setting point, then turn the setting point 1/4 to 1/2 turn clockwise, then tighten the lock nut again. This adjustment will cause the setting point to bend the tooth to the .040 dimension before the clamp reaches its fully closed and locked position. By doing this, you can visually bend each tooth to the .040 dimension. Due to variable tooth heights, variable tooth spacing, and different steel structure in every tooth, you will get more consistent results by visually bending each tooth to the .040 dimension than you will letting the clamp bottom out every time.

SECTION 2-5: TOOTH SETTER/GAUGE - cont'd

6. Slide the blade to the left until the third tooth from the one just set comes in front of the gauge foot. Push the blade to the right to place a tooth against the index pawl. Throw the clamp handle slowly, being sure the setting point will contact the tooth in the proper spot. (Adjusting the indexing pawl may be necessary every time you set a different blade). Throw the clamp handle until the spring loaded stops firmly clamp the blade and read the dial indicator to determine the current set. If more set is desired continue pushing the clamp handle until the tooth has been set at the pre-determined dimension, and then check the set in that tooth. You may check every tooth if you want to be positive that every tooth has been set to the dimension you want or you may spot check every fourth or fifth tooth to make sure you are still setting the teeth to the proper dimension. Repeat for every third tooth until the weld is reached. Remove the blade and invert it. Reinstall the blade in the tooth setter and repeat the above steps to set the teeth bent in the opposite direction, using the left side index pawl assembly. The amount that you have to bend the teeth to end up with the same set as the first side of the blade will, in all probability, differ (i.e., You may have to bend the teeth on the inverted side of the blade to .045 to end up with a .021 set when you only had to bend the teeth on the other side of the blade to .040 to end up with a .021 set).

After a blade has been sharpened two or three times, enough material has been removed from the face of the tooth to reduce the set to a point where the blade will not cut efficiently. The set in the teeth should not be allowed to fall below .011" (thin blades), or .015" (thick blades).

Remove the blade from the setter and invert it to its original position. The blade is now ready to be installed in the sawmill.



SECTION 2-6: BLADE MAINTENANCE AND CARE

The Wood-Mizer cuts with a 1 1/4" x 158" band with 3/4" tooth spacing (Standard Blade) or 1 5/16" x 158" band with 7/8" tooth spacing (Wood-Mizer Blade). This band will give you approximately 15-30 hours of cutting life if properly used and maintained. Follow the guidelines below to get the most out of each blade.

The best indicator of blade condition is the quality of its cut. IF THE BLADE DIPS OR CLIMBS, IT IS CAUSED BY SOME FACTOR IN THE BLADE 99.9% OF THE TIME, NOT BY MACHINE ALIGNMENT. THE BLADE CAN LOOK SHARP, FEEL SHARP, AND STILL NOT CUT RIGHT.

As the blade gets dull, loaded with sap build-up, or loses set, the quality of the cut will deteriorate. A dull blade will typically start to wave as it cuts and overload the engine. When this happens, you should:

1. Check to see if the blade is loaded with sap build-up. This problem is almost nonexistent in some woods but can ruin the quality of the cut when it does occur. The build-up fills the set of the teeth, creating friction which caused the blade to burn its way through the wood. Use of the LTWLS Waterlube System will eliminate this problem (See Section 7.1).
2. Check the edge of the teeth to be sure that they are sharp. If not, remove the blade and sharpen with the optional sharpening fixture (See Section 2-3 or 2-4).
3. Check the set of the teeth. Your best indication is the quality of cut you are getting. If cuts are wavy, chances are the blade is dull or the teeth need to be reset. If they need to be set, remove the blade and resharpen, then set the teeth with the optional tooth setter/gauge (See Section 2.5).

A consistent gullet should always be maintained when sharpening a blade. Inconsistent gullets will cause premature blade breakage (See Figure 2-58).

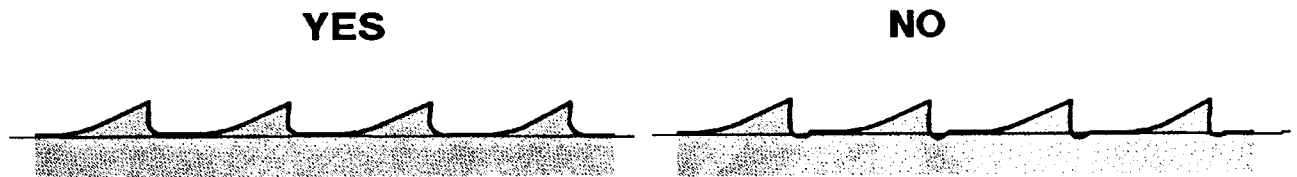
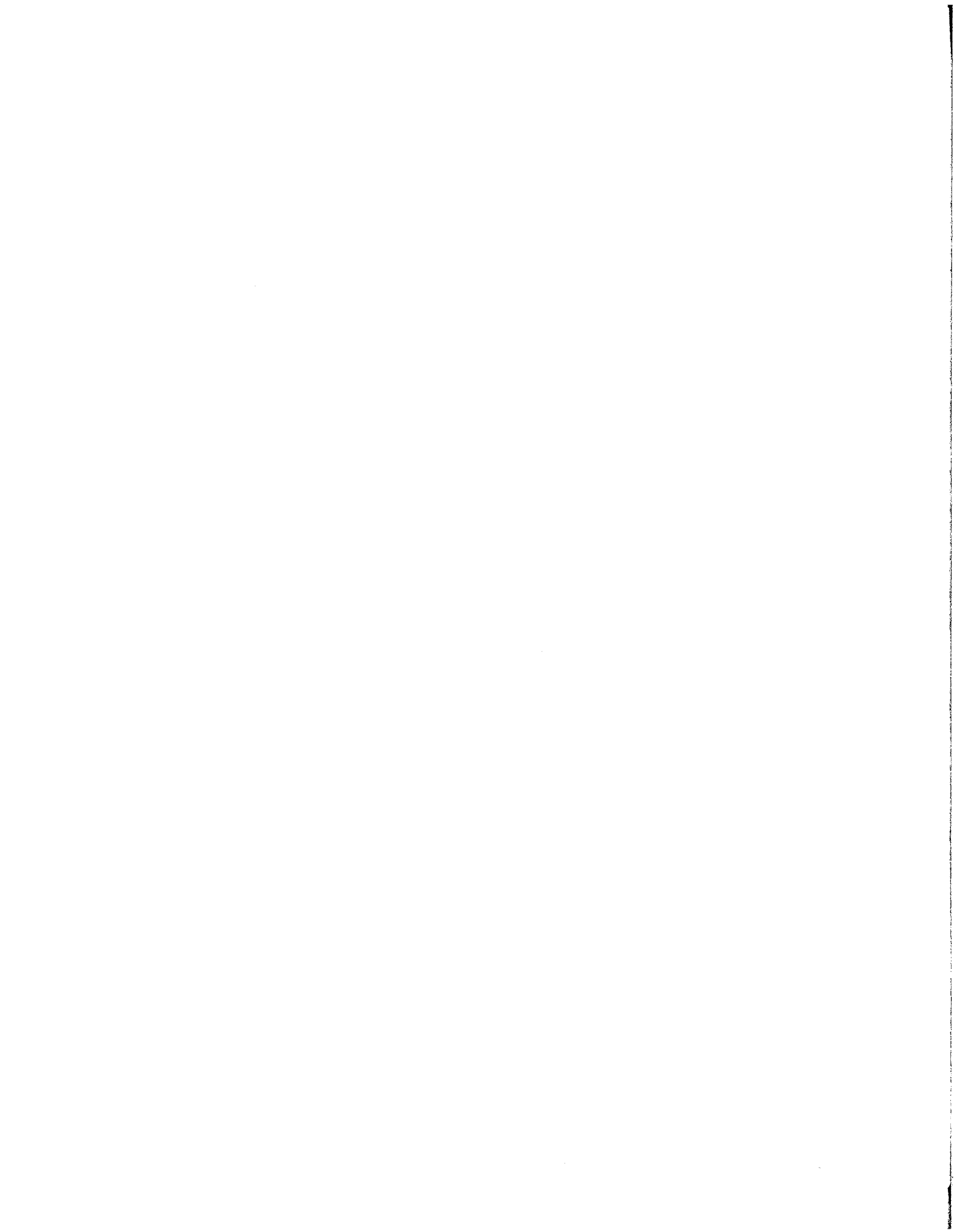


FIG 2-58



SECTION 2-7: CHANGING THE BLADE

CAUTION: WEARING GLOVES AND EYE PROTECTION IS RECOMMENDED WHENEVER HANDLING BANDSAW BLADES. CHANGING BLADES IS SAFEST DONE BY ONE PERSON!

DO NOT CHANGE THE BLADE WITH THE ENGINE RUNNING. Remove the blade housing cover(s) that cover the drive wheels. Release the blade tension by turning the tension control (See Figure 2-59 or Figure 2-60) until the wheel is pulled in and the blade is lying loose in the C-frame housing. Lift the blade out of the C-Frame.

When installing a sharp blade, make sure the teeth are pointing the correct direction. (The teeth should be pointing toward the operator side of the mill.) Install so the blade is roughly lying around the wheels with the gullet of the teeth even with the front edge of the wheels. The next step is to tension the blade by turning the tension handle until the die spring is compressed properly.

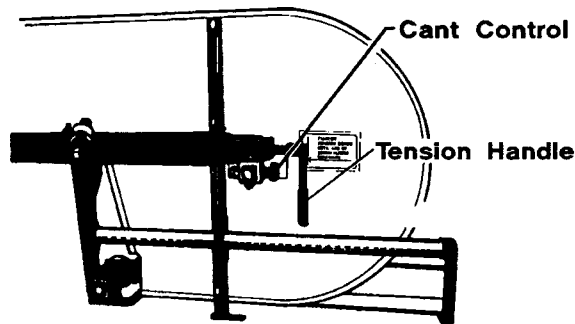


FIG 2-59

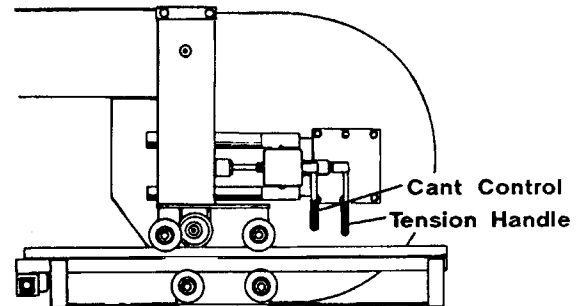


FIG 2-60

PROPER BLADE TENSION FOR LT20D SERIES MILLS

For .035" blades, tension the blade until the back edge of the tension handle is even with the gauge line as shown in Figure 2-59. For .042" blades, tension 1/2 a turn past the line.

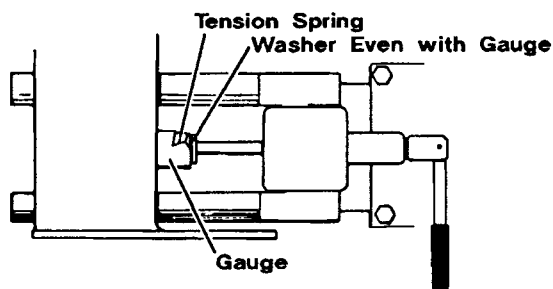


FIG 2-61

PROPER BLADE TENSION FOR LT30 AND LT40 SERIES MILLS

Tension the blade until the tension spring is compressed so the *front* face of the washer lines up with the edge of the spring housing (See Figure 2-61). Do not compress the spring past this point.

The gullet of the blade should ride even with the front of the wheels. Do not let the teeth ride back on the wheel so that the gullet is past front edge of wheel (See Figure 2-62).

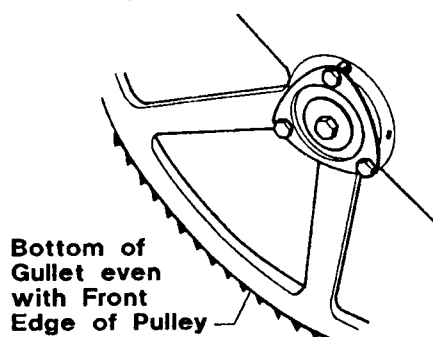


FIG 2-62

Adjustment of the free running wheel is made with the cant control handle shown in Figures 2-59 or 2-60. Start engine and pull lightly on the clutch handle, rotating the blade, until the blade locates itself. If the blade is too far forward on the idle side wheel, loosen the cant control; too far back, tighten the cant control. **SOME ADJUSTMENT IN SPRING TENSION WILL BE NECESSARY TO COMPENSATE FOR ANY ADJUSTMENT IN THE CANT CONTROL.** Replace covers.

IMPORTANT: After lining the blade on the wheels, always double check the blade guide spacing and location (See Section 5).



SECTION 3-1: SETUP & OPERATION

READ ENTIRE OPERATING MANUAL BEFORE OPERATING YOUR WOOD-MIZER LUMBERMILL.

STATIONARY LUMBERMILL

1. Set up mill on firm footing and level by eye before operating. The mill should be secured to the floor or platform or tied down to footing to avoid any creep after prolonged use. Spacing for footings is indicated in **Figure 3-1**.

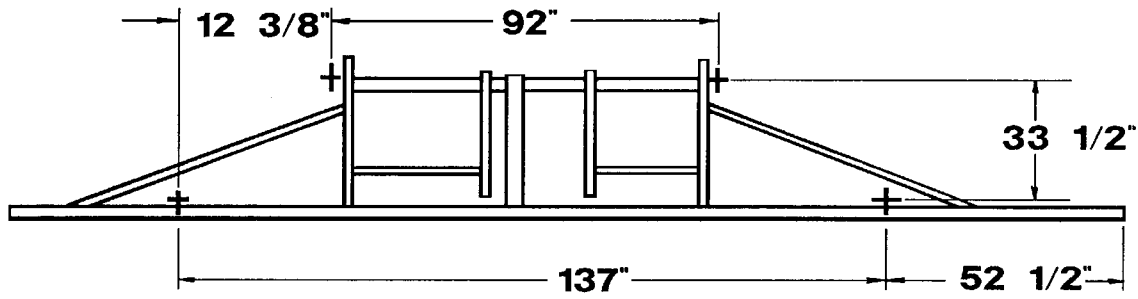


FIG 3-1

2. The unit should be level before securing. It IS possible to twist the mill frame by jacking one foot higher than the others.

PORTABLE MILL

1. Always unhitch mill from vehicle before operating. Pull locking pins to drop all four outriggers. Using the jack handle, jack down each outrigger by lifting weight off locking pin with hack handle, pull out pin, and pull up on handle to lower the outrigger so the locking pin can drop in the next locking hole (See **Figure 3-2**).

2. Level the unit before operating. It IS possible to twist the mill frame by jacking one outrigger higher than the others.

3. Remove fenders by simply lifting out of slots.

4. Set loading ramps in place by sliding over pins on frame. There are three support positions. Select the two which give the best support to the logs.

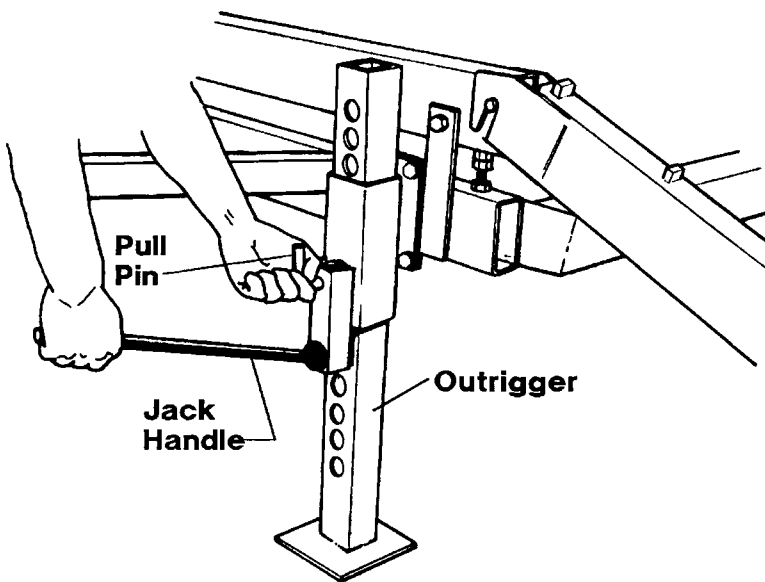
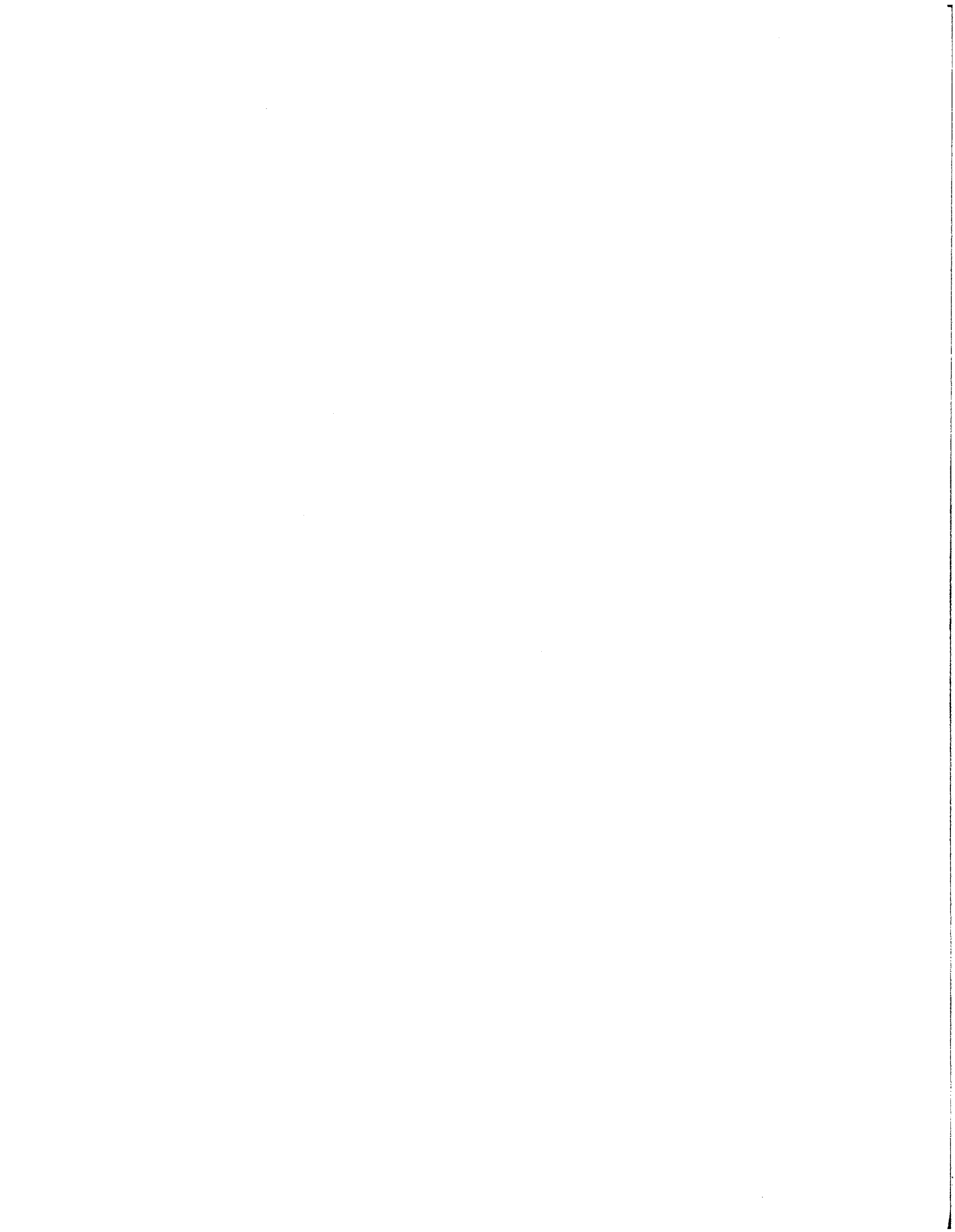


FIG 3-2



SECTION 3-1: SETUP & OPERATION - cont'd

OPERATION

1. Raise the carriage head from the carriage rest pin and move to the front end of the mill using the hand crank or power feed return (See Power Feed Instructions).
2. Load logs onto mill bed.

When using the optional winch, always have the side supports at their highest position (See Figure 3-3). Only two side supports should be used when the log is first being clamped so that it seats firmly against two points closest to the ends of the log. Center the log at the base of the ramps. Feed the winch cable through the cable guides to the idle pulley found just right of the clamping dog receiver. Route the cable through the idle pulley and out to the log to be loaded. Let out enough cable to wrap over the top of the log and come back underneath the log to secure the cable to the locking dog receiver. When winding in loose cable, keep tension on cable with free hand to avoid snarling and pinching the cable when it has load on it. Never stand behind the log while being winched to avoid injury as the log would roll back down ramps if cable broke. Winch the log up the ramps and onto bed of the mill. Leave the cable around the log until it is firmly secured with the clamping dog. Logs may also be loaded with a tractor or other equipment specifically designed for that purpose. Pivoting bed supports are located on the each of the main frame to support logs or boards that tend to sag on the ends.

Caution: Fold these supports out of the way when loading and rolling logs, as they are not designed to withstand heavy loads.

3. Rotate log to desired angular position by spinning it against side supports. If the log is too large to rotate by cant hook, the optional log roller can be used in conjunction with the winch to rotate it (See LTLT Option).
4. Secure log to desired angular position by placing the clamping dog in the closest possible hole to the log with the handle to the right. The arm of the clamping dog should be swung to the operator's left until the cam forces the log firmly against side supports. Place the locking chain into the slot of the clamping dog arm (See Figure 3-4). The slots on the side of the post allow you to set the height of the clamping dog low enough to clear the saw carriage. The clamping dog is typically required only when the log is resting on a rounded portion. Once the log is resting on a flat, the weight of the log is usually sufficient to hold it in position. When a square cant is achieved, the side supports may be lowered and the cant positioned against the welded stop blocks for maximum throat capacity (Refer to Figure 3-3).
5. Install blade, if necessary, and check for proper blade tension (See Section 2.7).

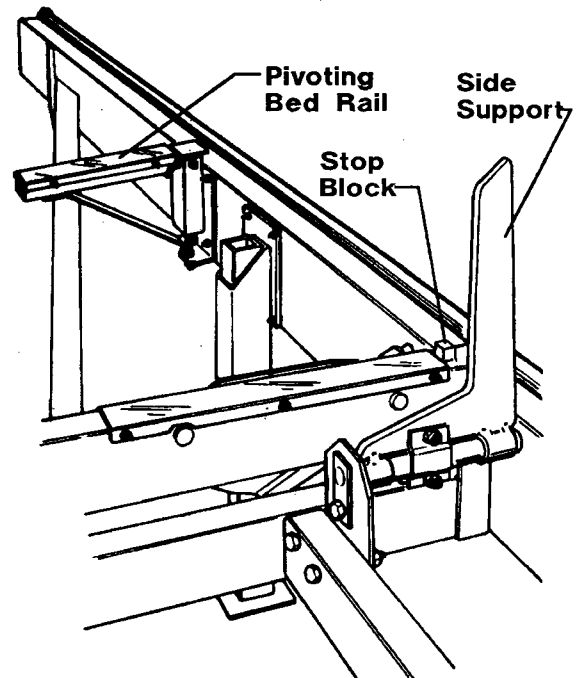


FIG 3-3

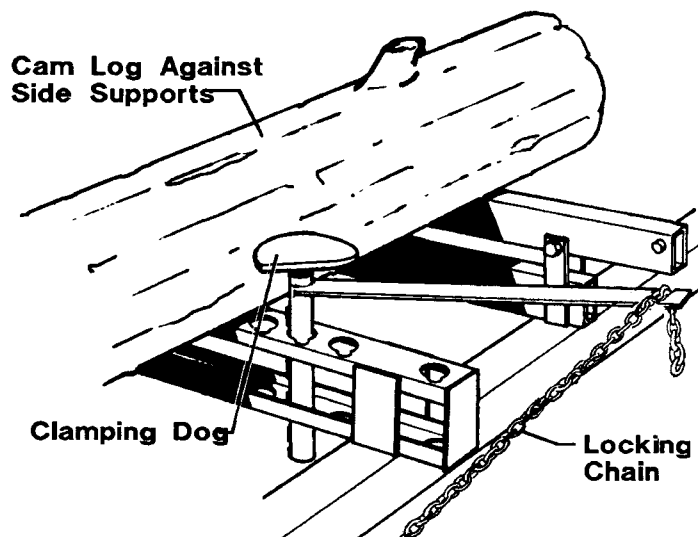
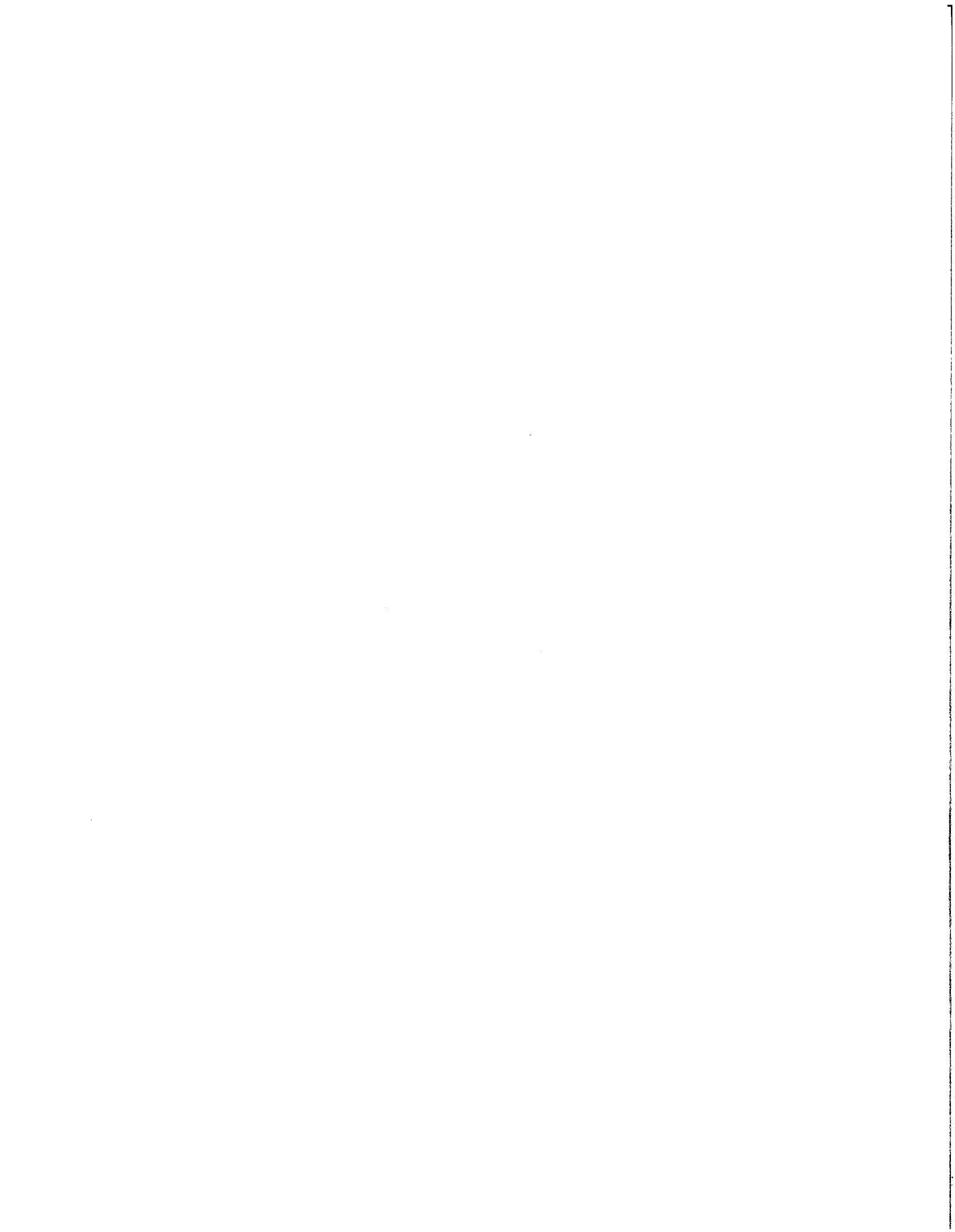


FIG 3-4



SECTION 3-1: SETUP & OPERATION - cont'd

6. Set bandsaw carriage to desired height. The indicator and ruled gauge indicate height of the blade above the bed rails.

The carriage is raised and lowered by the hand crank on the front of the carriage assembly (See Figure 3-5). There are 16 holes in the face plate of the up/down crank assembly. Each hole represents an adjustment in the blade height of 1/16 of an inch. One full turn of the crank is one (1) inch.

7. Move carriage close to end of log to assure better adjustment view.

8. Adjust the width of the throat by sighting down the log to determine its maximum width. The outer blade guide should be adjusted to clear the widest section of the log by less than 1". This is done by loosening the clamping knob and sliding the movable blade guide horizontally in or out as necessary (See Figure 3-6). **NEVER** adjust the throat width while the blade is moving.

9. Clear any loose objects from area of the blade, motor, or drive belts

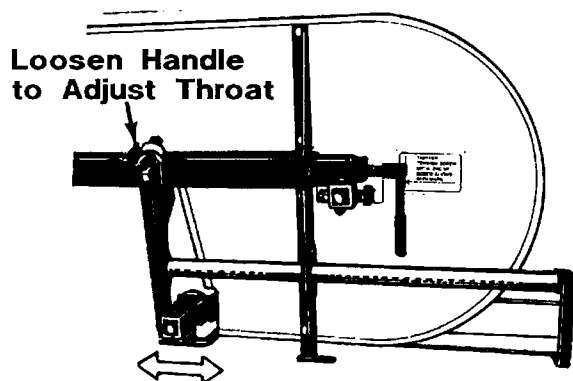


FIG 3-6

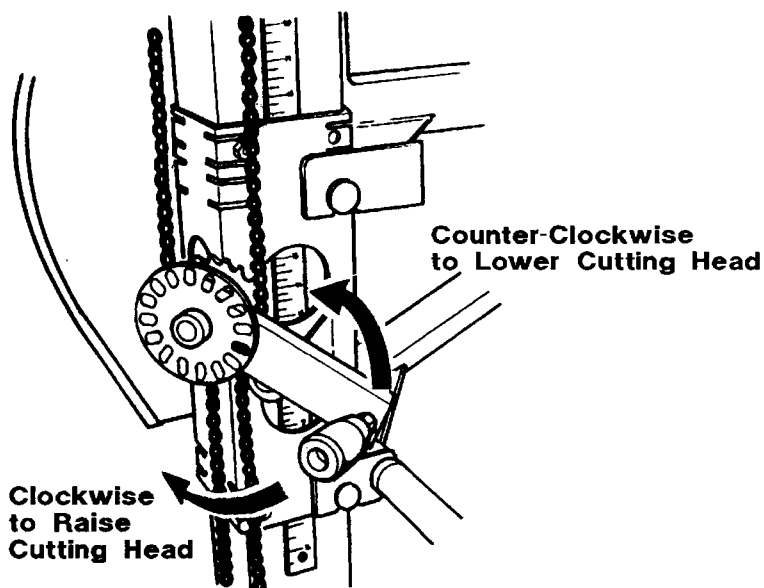


FIG 3-5

10. Make sure clamping dog and side braces are adjusted to be below the cut of the blade.

11. Start engine per instructions found in engine manual.

12. Pull down on brake/clutch lever found at right side of carriage frame. This will engage the drive mechanism, release the blade brake, and increase engine speed to full throttle.

13. Feed the carriage into the wood at a slow speed. When using hand feed, let the blade contact the wood slowly and then feed at a rate that will not load the engine or force the blade to dip down or load with sawdust. Maximum feed rate will vary with width and hardness of wood. Over-feeding will result in excessive engine and band wear and will produce a wavy cut.

When using the Power Feed, approach the wood on the first cut at its slowest speed and raise it to a level below a point where the engine overloads. Subsequent cuts are made at the same speeds (See Power Feed Instructions for specific details).

14. Stop the carriage at the end of the cut.

15. Throw clutch and brake lever to stop blade and drop engine to idle. **Failure to stop the blade can cause the blade to be pulled off (while traveling in reverse) by a wood sliver and be ruined.** This action also increases the life of the blade.

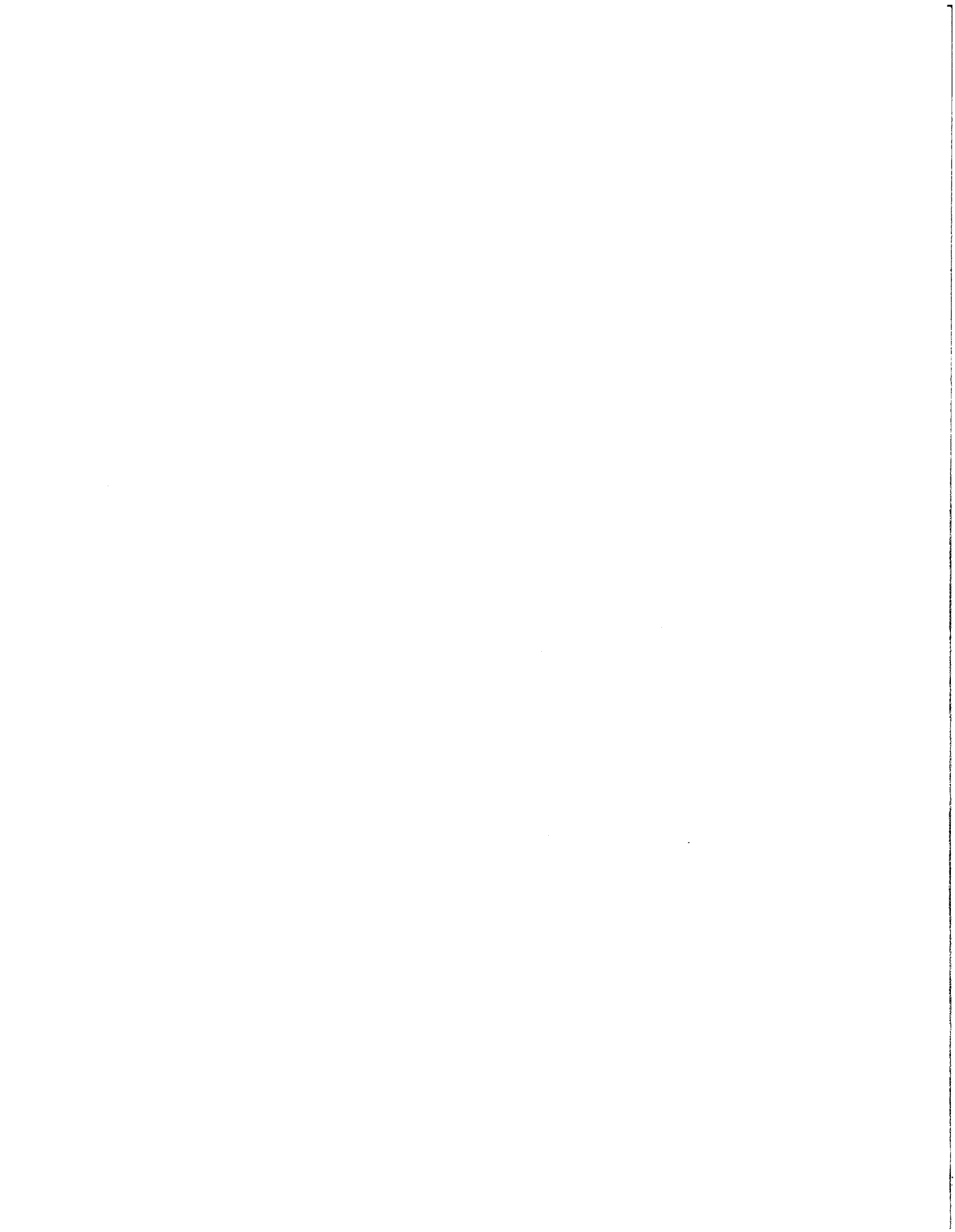
16. Remove board from top of log.

17. Return the carriage being sure that the blade does not catch on the end of the log, or the carriage can be raised slightly to ensure that the blade clears the log when returned. Carriage is returned at full speed. Once bark is removed or you are making the last squaring cut, try to stop the blade while the heel of the blade is still on the log, then bring back the carriage without lifting the carriage. This assures accurate scale readings.

18. Rotate log if you wish to square it after this first cut. Put clamping dog in closest hole to the ramp to stop log should it start to roll off. Rolling is done with cant hooks, log roller, or other tools to spin the log after being unclamped and rotated against the side supports. Typically, the log would be rotated 180 degrees to set the flat of the log on the support frame. If log is rotated 90 degrees, use the side braces against the flat of the log to clamp the log at the proper angle with the locking dog (See LTLT Instructions for rolling large logs).

19. Set cut depth per Step 6. Remember that the blade cuts a 1/16" wide kerf so if you want 1" thick boards, the carriage should be lowered 1 1/16 inches (17 notches) for each board.

20. Repeat Steps 12 through 19 until log is cut as desired.



SECTION 3-2: POWER FEED INSTRUCTIONS

The power feed option of the Wood-Mizer offers infinitely variable forward speed settings. Speeds are changed by two methods: changing the drive ratio by adjusting feed drive belt on 3-step pulley, and by using the feed rate control switch. These steps are examined below.

CHANGING SPEED WITH DIFFERENT PULLEY RATIOS

Changing pulley ratios is done by moving the drive belt to one of three settings on the 3-step pulley. These settings give you three basic ranges of forward speed which are adjustable while in motion with the feed rate control switch. The three belt settings provide the following ranges of feed rates:

Slow belt range: 0 - approx. 21 ft. per minute.
Middle belt range: 0 - approx. 42 ft. per minute.
Fast belt range: 0 - approx. 60 ft. per minute.

The slow belt range is typically used when cutting boards from 10-16" wide. The highest belt range is used when cutting boards less than 10" wide. Board widths can increase or decrease beyond the limits listed above depending on species and condition of the logs cut. Belt ranges are changed by lifting the power feed motor and shifting the loose drive belt left or right, being sure belt sets in left, center, or right groove of both the upper and lower set of cones.

CHANGING SPEED WITH FEED RATE CONTROL SWITCH

A simple variable speed switch gives you fast changes of speed within each belt range. Turn the power rate knob clockwise to increase speed; counter-clockwise to reduce speed.

OPERATION OF POWER FEED ASSEMBLY

Actual operation of the power feed is simple. If you want the cutting head to move forward, push the feed switch forward, and if you want the carriage to move back, pull the switch back (See Figure 3-7). Speeds can be adjusted while cutting the log with the feed rate control switch.

HINT: To maintain a straight cut in the first portion of the board, it is recommended that the blade be fed into the cut at a slow rate of speed to avoid causing the blade to flex and dip up or down. This is done simply by turning the feed rate switch to a slow speed until the entire width of the blade has entered the cut. The control switch can then be adjusted to the feed rate desired.

To return the carriage to the front of the mill, disengage the blade and pull the feed direction switch back. The power feed motor will bypass the rate control switch and the carriage will automatically return at the fastest speed available in the belt range being used.

ALWAYS DISENGAGE THE BLADE BEFORE RETURNING THE CARRIAGE FOR THE NEXT CUT.

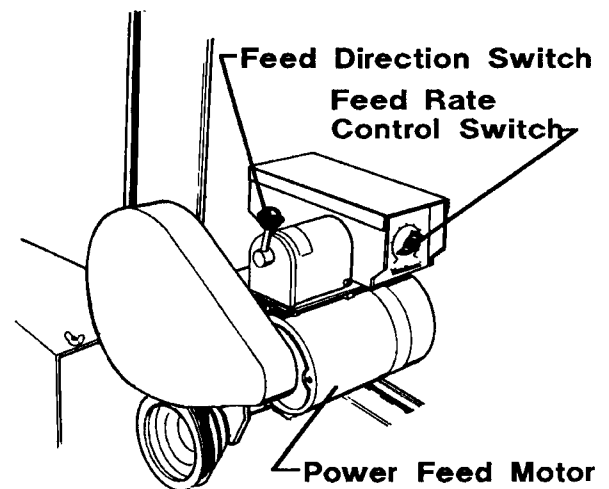
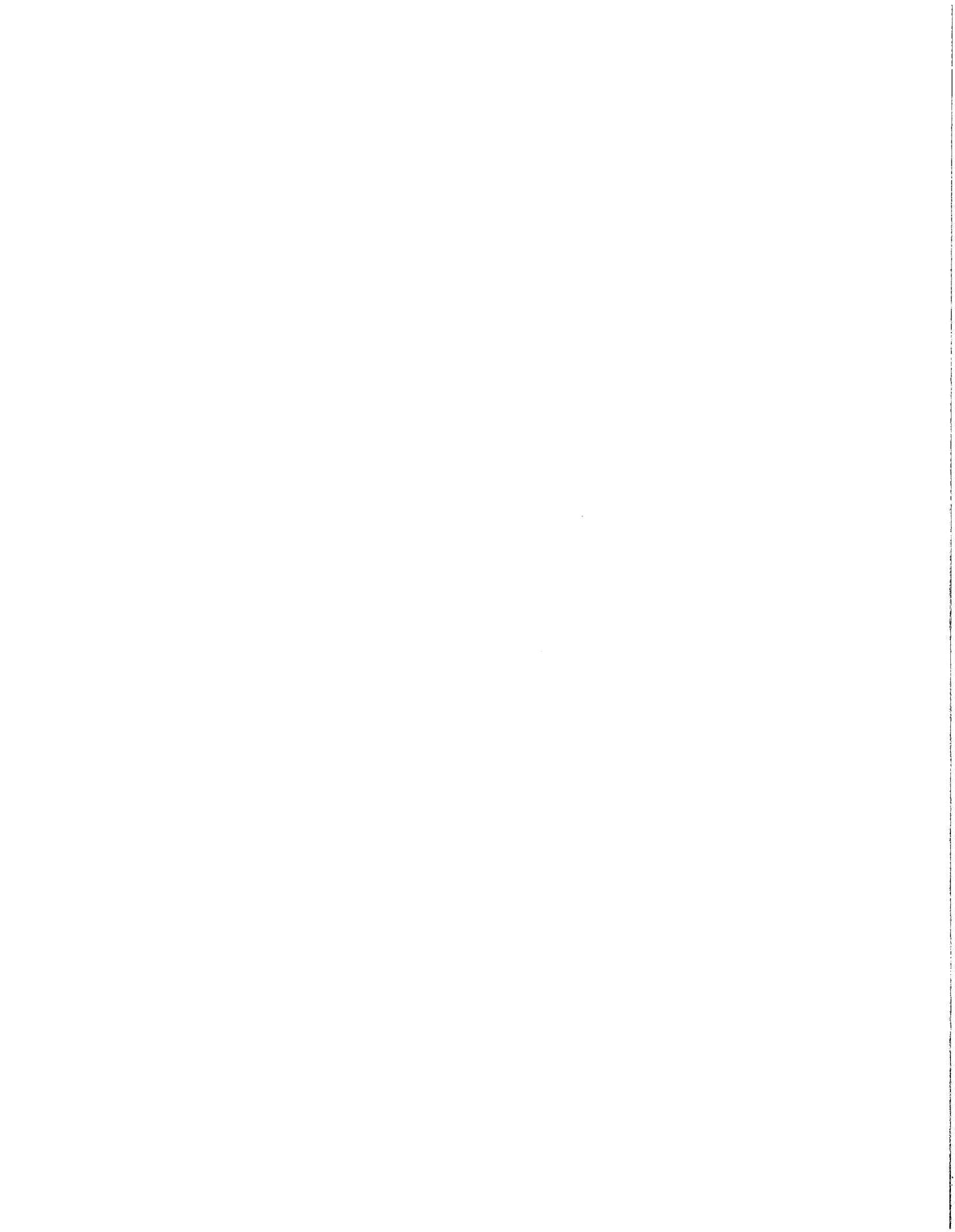


FIG 3-7



SECTION 3-3: TRANSPORTING THE MILL

The Wood-Mizer® optional LTTR Trailer Package makes transporting your mill easy and convenient. To ready your mill for towing:

1. Raise rear outriggers (moving the carriage head toward the front of the mill will take weight off rear outriggers).
2. Move carriage to travel position over rear bed rail. Lower the carriage until it rests firmly on the carriage rest pin (See Figure 3-8).
3. Engage the clutch handle to keep belts tight and motor from bouncing while traveling. Turn key switch off and remove keys.
4. Hook the carriage safety chain on the bracket shown in Figure 3-9. **Note:** Manual units have a U-shaped bracket to hook the safety chain to.

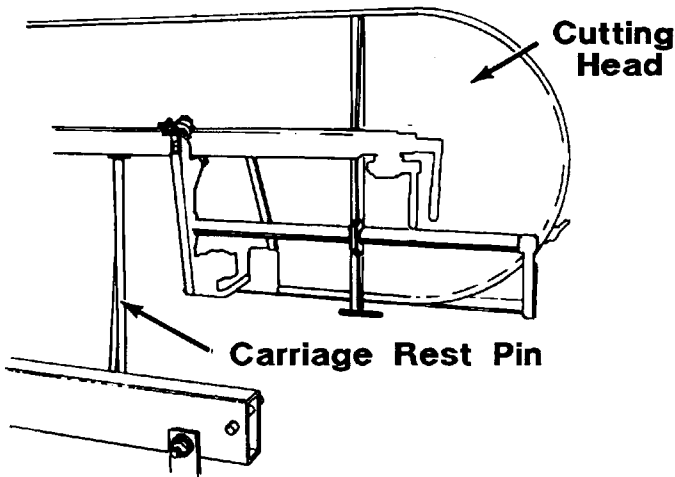


FIG 3-8

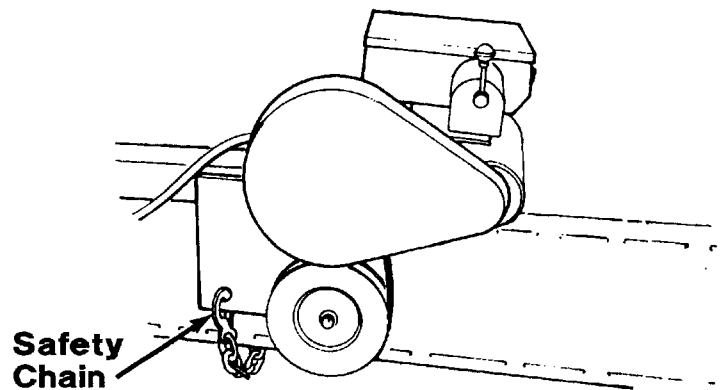


FIG 3-9

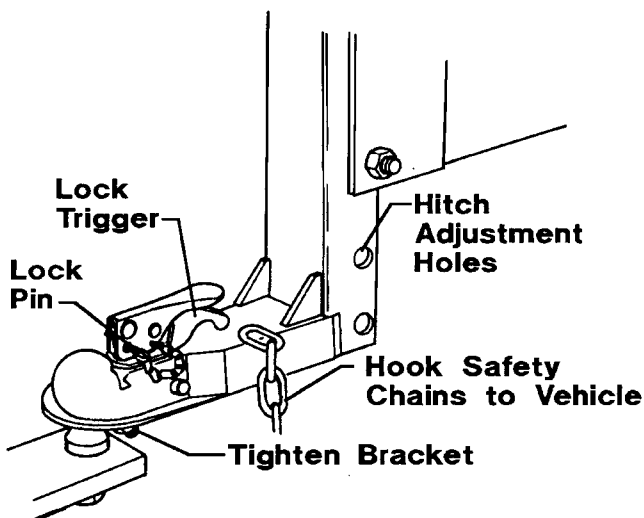


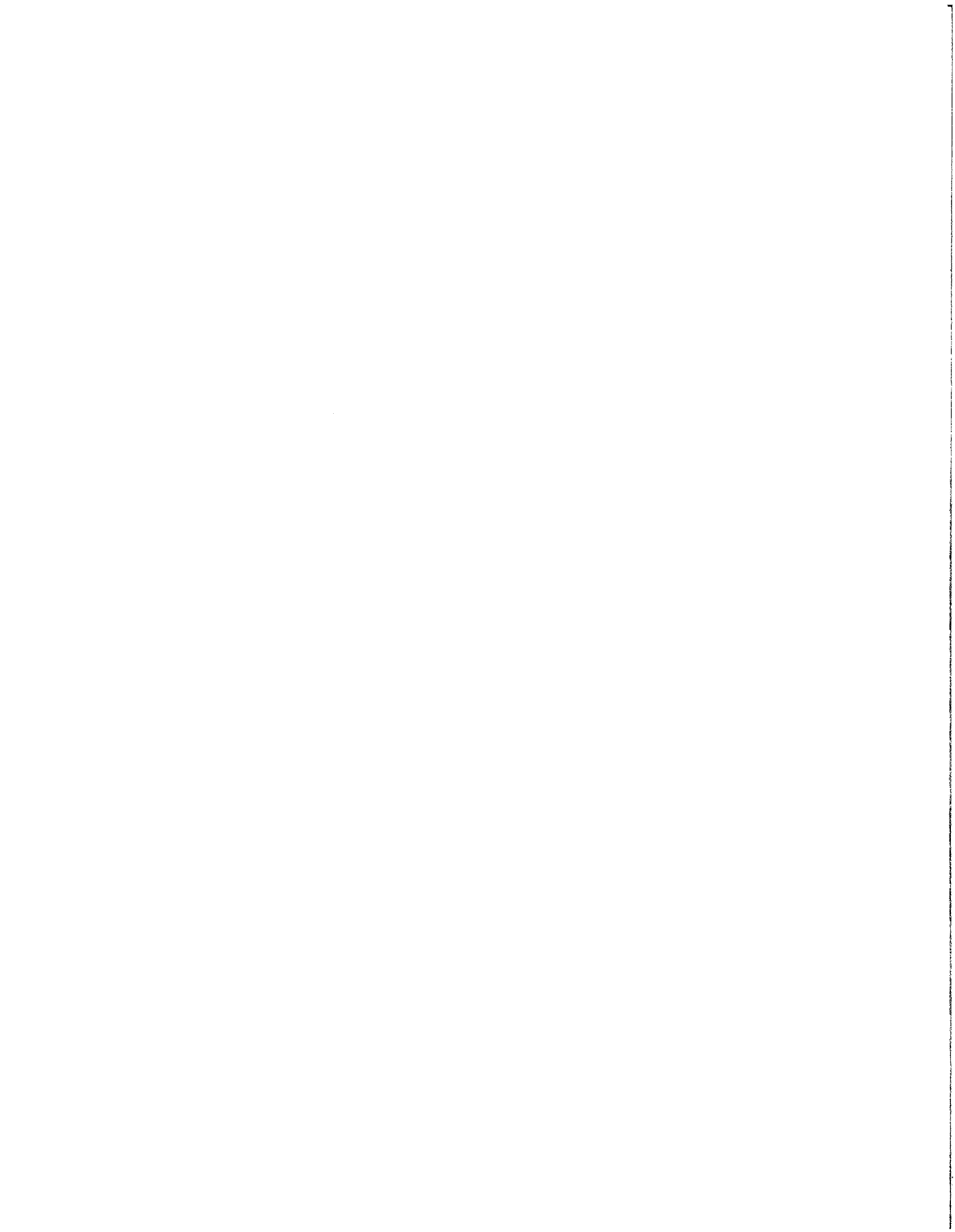
FIG 3-10

5. Remove all loose objects from the bed of the mill. Store the clamping dog in the bed of the mill. Place clamping dog in the fourth hole in the bracket and swing around until handle lies parallel with dog bracket. Store loading ramps in proper place on top of bed rails and secure with the spring loaded 'T'-clamps provided. Store outrigger jack handle in the bracket provided on the rear/loading side outrigger guide. Reel in the winch cable and remove winch handle.

6. Place both fenders in slots behind trailer tires. Raise all but very front outrigger. Pull mill behind towing vehicle and place hitch over 2" ball on your vehicle. Engage locking trigger, being sure bracket underneath firmly clamps around the ball (See Figure 3-10). Cross safety chains underneath the hitch and hook to vehicle. Connect vehicle running lights to mill pigtail and check signals and brake lights.

7. Raise front outrigger. Re-check that all loose items are removed or secured (such as waterlube option, shingle/lapsiding option, cant hooks, etc...).

8. The hitch on the mill is adjustable and should be lowered or raised to let the mill travel fairly horizontal with ground level. Adjust by removing the two mounting bolts and sliding hitch tube up or down to new set of holes. Replace bolts and nuts.



SECTION 4-1: MAINTENANCE SCHEDULE

The procedures listed in this schedule are essential to trouble-free operation of the Wood-Mizer. The small amount of time required by these procedures is the best time investment in a successful sawing operation.

A. EVERY TWO HOURS OF OPERATION:

1. Grease the two blade guides (See Figure 4-1). Do not lubricate until grease is oozing out of the gaps. The purpose of greasing every two hours is to purge the sawdust out of the bearings.

2. Check to see that the blade guide bearings are clean and free-spinning. If not free-running, disassemble and clean with diesel fuel or equivalent, and re-pack with grease (See Section 4.2). If the bearings need to be replaced, notice that one of the shields on each bearing has been pulled off and notches ground in the inner race to allow grease to get to the ball bearings. These bearings are standard R-8 bearings available at most places that sell bearings.

3. Clean any excess sawdust build-up in blade wheel housings.

4. Clean the gas engine air filter daily.

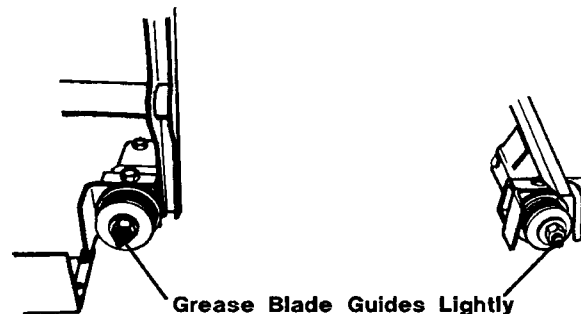


FIG 4-1

B. EVERY FORTY HOURS OF OPERATION:

1. Grease (2) track cam followers (See Figure 4-2). Certain woods have high levels of acid in the sawdust that will react with steel, causing excessive wear. The grease is primarily for purging any sawdust out of the critical areas.

2. Lubricate Up/Down and Feed chains with a penetrating oil, such as WD-40. Do NOT use chain lube as this will cause sawdust build-up in chain links.

3. Check for excessive drive belt wear. If belt is too loose, adjust elbow connection of clutch lever linkage using the slotted hole (See Figure 4-3). Retighten nut and check belt tension. Readjust elbow if necessary.

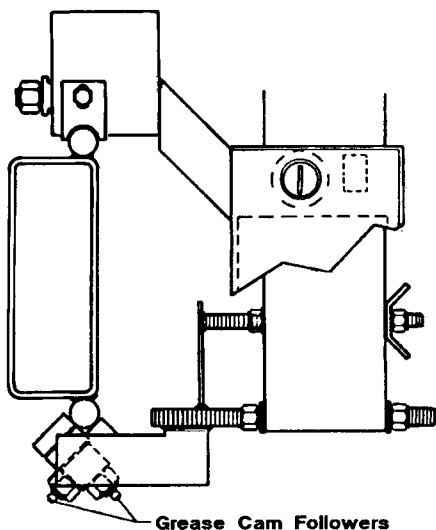


FIG 4-2

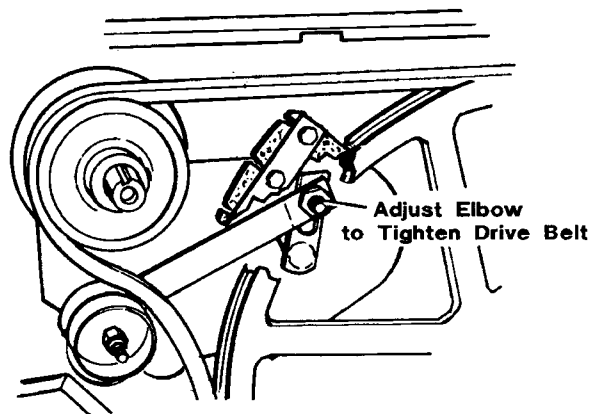
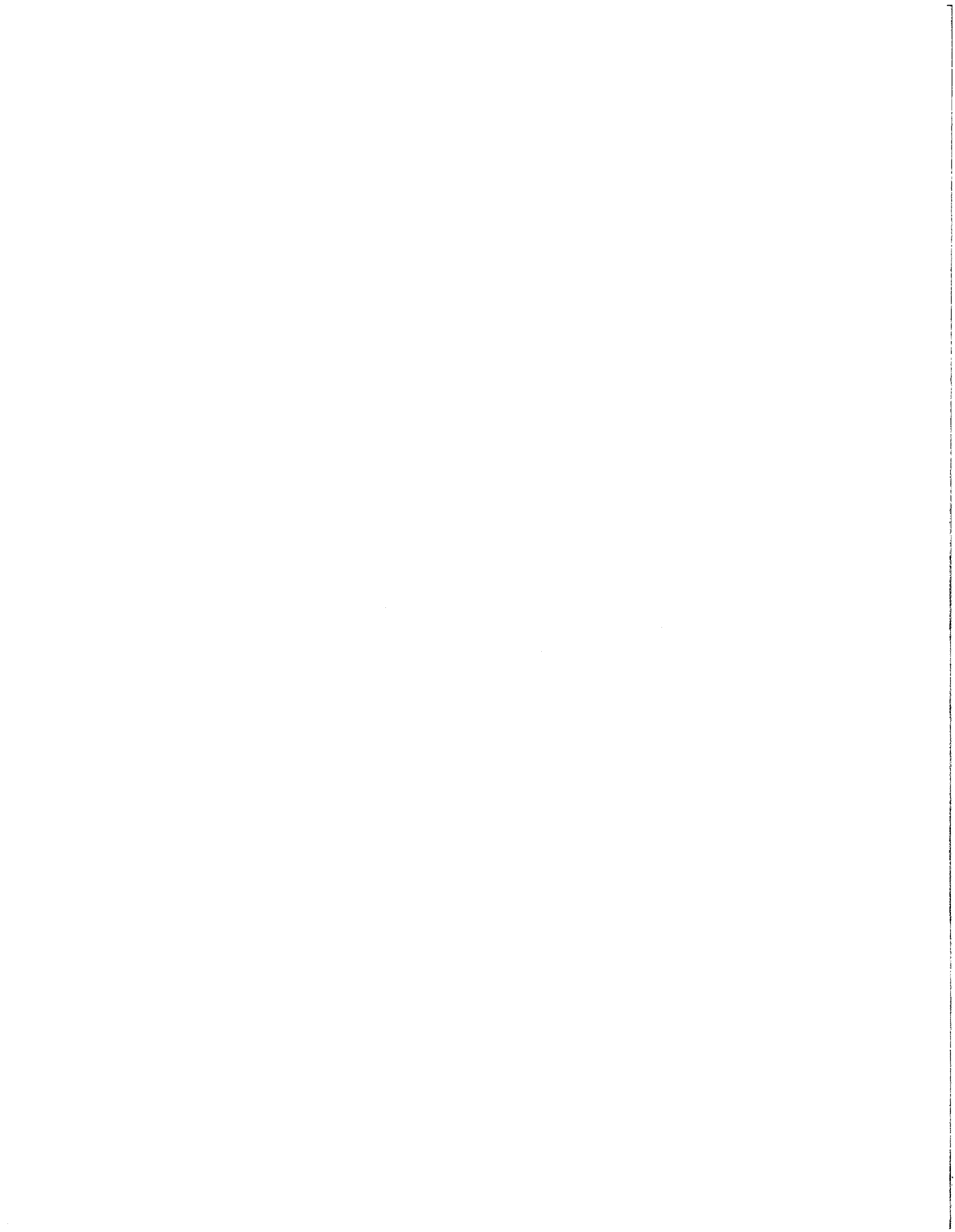


FIG 4-3

3. Oil all pivot points, chains, and bearings. Rebuild or replace bearings as needed.

4. If the blade is not coming to a stop rapidly, the brake shoe is probably worn and needs to be adjusted or replaced (See Section 4-5).



SECTION 4-1: MAINTENANCE SCHEDULE - cont'd

B. EVERY FORTY HOURS OF OPERATION - cont'd

5. Adjust the wear pads on the vertical mast if there becomes noticeable side-to-side movement of the cutting head (See Figure 4-4).

6. Grease power feed cam roller (See Figure 4-5).

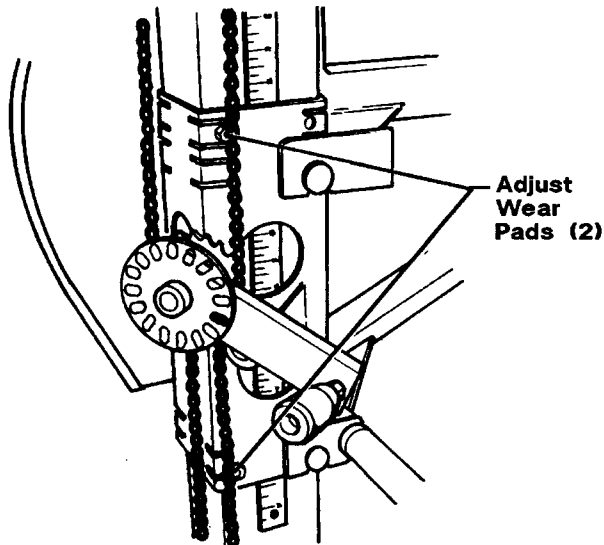


FIG 4-4

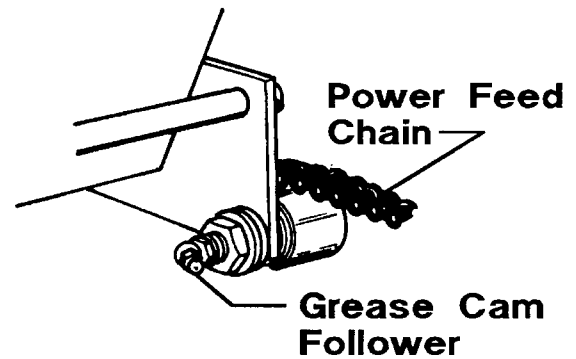


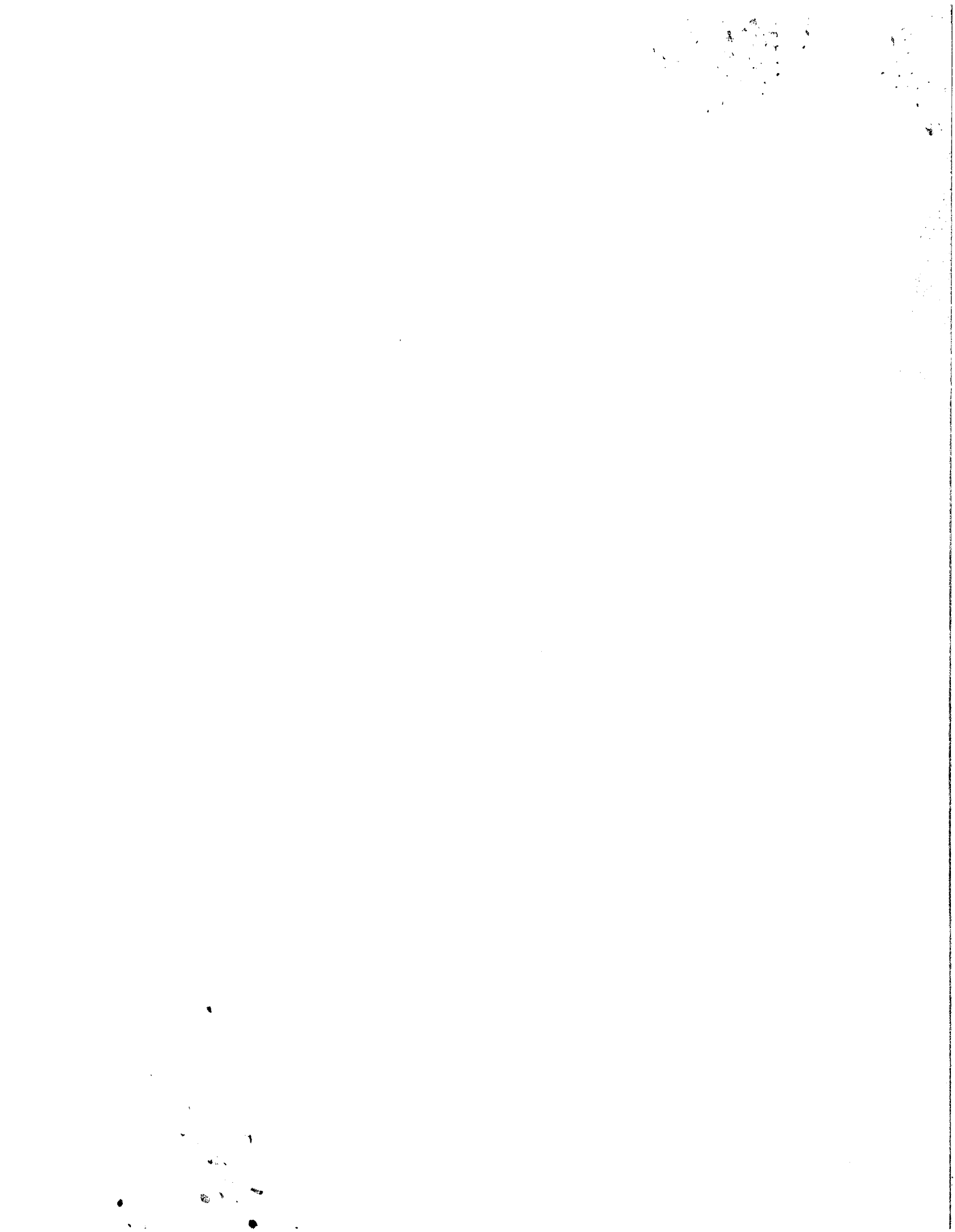
FIG 4-5

7. Clean power feed drum switch contacts with emery cloth or fine file. Spray contacts with WD-40 to keep switch mechanism clean and lubricated.

C. MISCELLANEOUS MAINTENANCE:

Go through alignment procedures per alignment section of manual as often as necessary. Maintain engine or per manufacturer's schedules.

Grease side supports and optional log turner pivots. Also, occasionally grease threads on optional toe board shafts.



SECTION 4-2: BLADE GUIDES AND CARE

The blade guides of the Wood-Mizer are designed to give hundreds of hours of use before needing any servicing.

A. The only maintenance they require is greasing every 2 hours. Failure to keep the guides well greased will cause premature failure. (Greasing every two hours is primarily to keep the sawdust purged out of the bearings. Do not over-grease or over-tighten blade guides).

B. Another condition that causes early failure is pre-loading of the guides. Pre-loading is when the blade is riding too far back on the drive wheels which causes the blade to ride the flange of the blade guide roller. There should be a 1/16-1/8 inch gap between the back edge of the blade and the flange.

Figure 4-6 shows how the blade guides are properly assembled. The only parts needed to rebuild the guides are the set of bearings and the felt washers.

A. The bearings are standard (R-8 Bearings) and are available at most industrial supply companies.

1. If you buy your bearings locally, they need to have the inner face of one bearing slotted to allow grease to work into the two bearings (See old set of bearings). This can be done using a grinding wheel.
2. Once one of the two bearings has been slotted, remove the dust shield of the slotted side and either side of the non-slotted bearing. This can be done with a knife or small screwdriver.
3. These two exposed faces need to face each other when two bearings are pressed into the blade guide roller.

B. Rebuild kits are available from Wood-Mizer[®] which include the bearings, retaining ring, felt washers and spacers. Complete roller assemblies are also available (See Section 6).

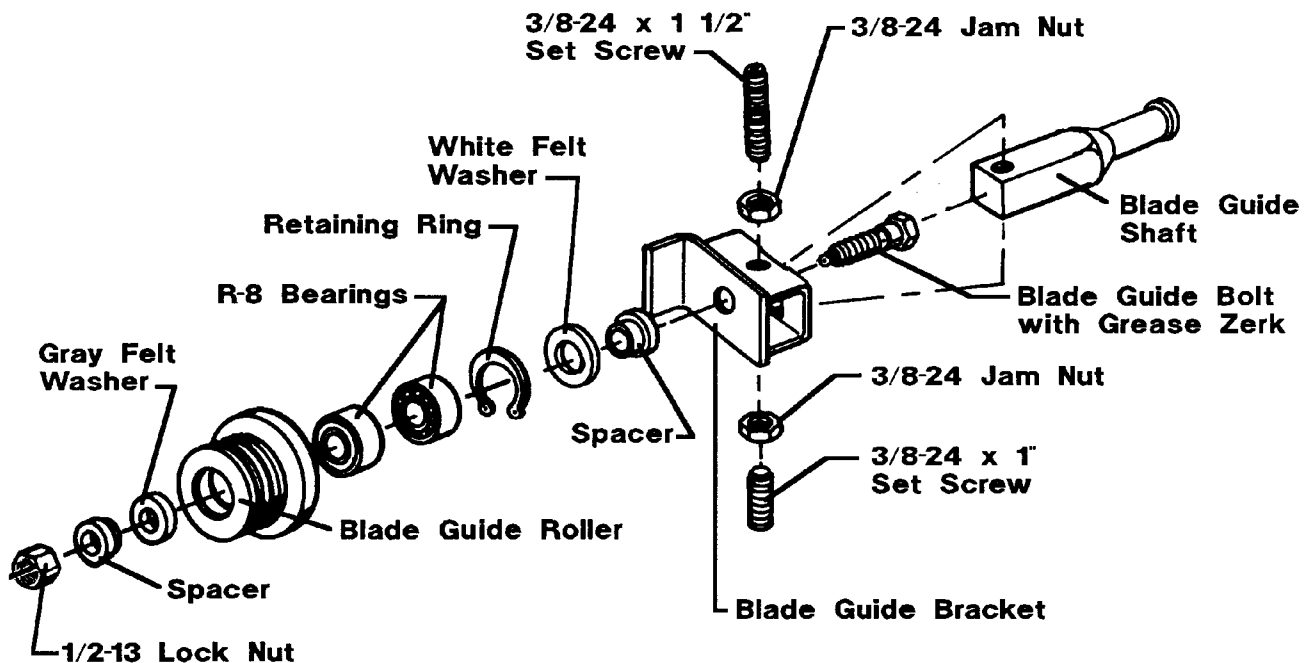
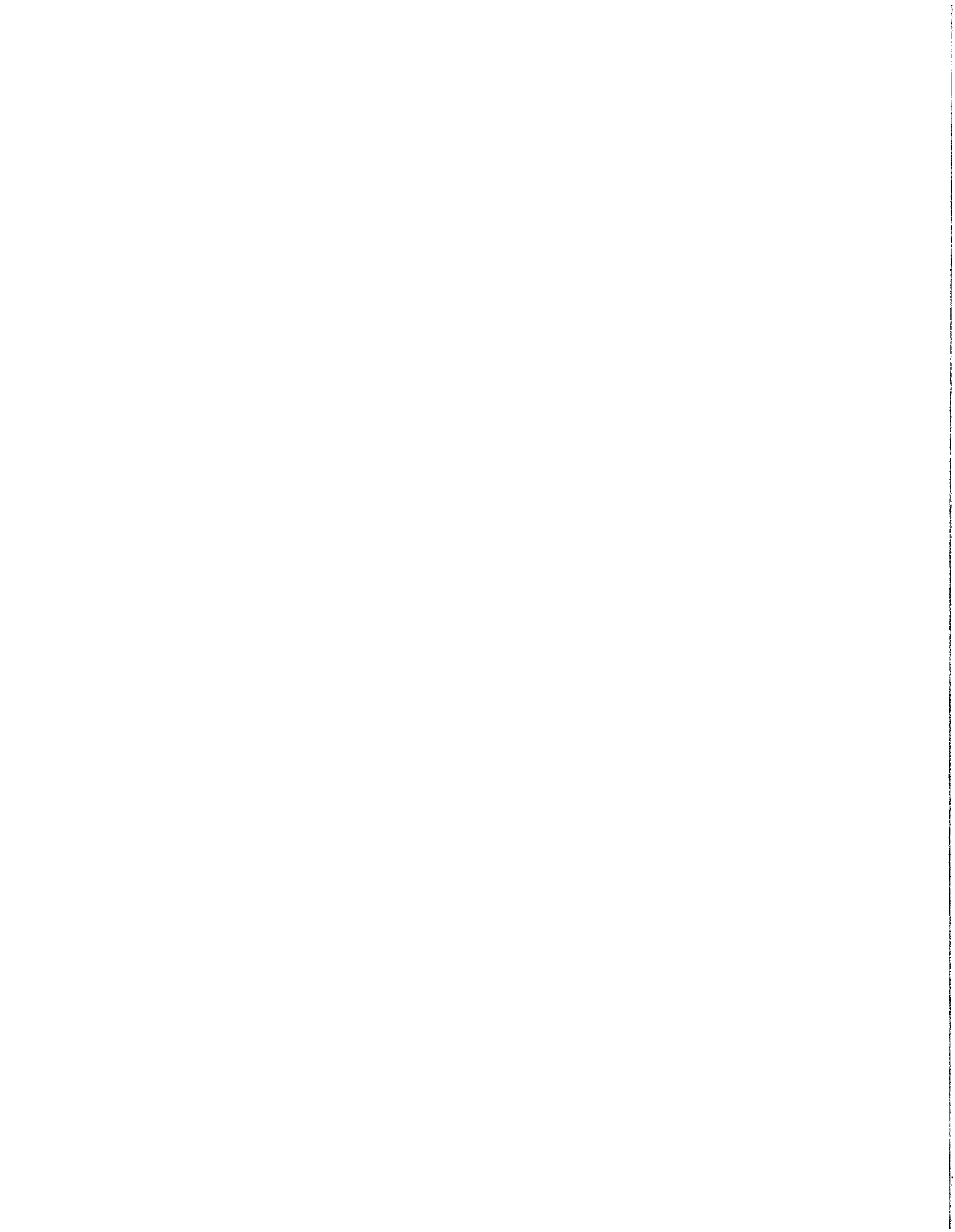


FIG 4-6



SECTION 4-3: CHAIN TENSION ADJUSTMENTS

The power feed and the carriage up/down mechanisms use chains that will require periodic adjustments. Both should be oiled to prevent rust.

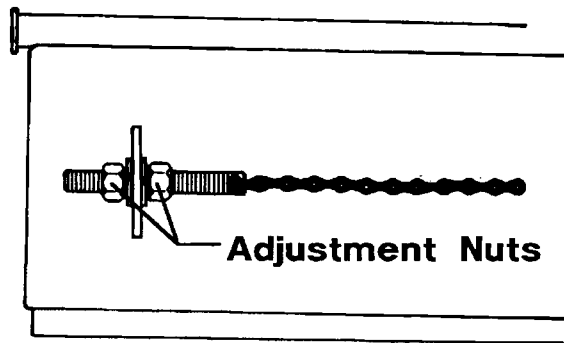


FIG 4-7

1. To adjust the power feed chain, move the carriage to the front end of the mill. The two locking nuts at the rear of the mill are used to tighten or loosen the power feed chain (See Figure 4-7). The chain should be adjusted so that the lower loop doesn't sag below the lower hardened steel track rod. Do not tighten it more than required to raise it 4" from the bottom of the lower track rod at its lowest point.

2. The mechanism for raising and lowering the cutting head incorporates a chain that will require periodic adjustments. The chain should be lubricated to prevent rust.

To adjust the up/down chain, move the idler bearing up or down as necessary. The idler bearing is located at the bottom of the carriage assembly mast tube (See Figure 4-8).

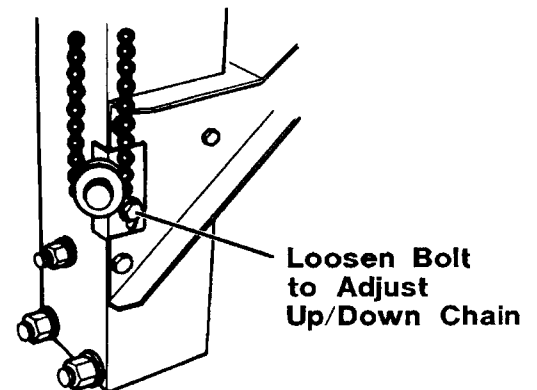


FIG 4-8



SECTION 4-4: THROTTLE ADJUSTMENT

Adjust the engine throttle at idle to approximately 1800-2000 RPM (See Engine Manual for adjustment). After proper idle adjustment is obtained, engage the clutch handle to speed the engine to full throttle. Full throttle should reach approximately 4000 RPM. The blade should not start spinning until the engine picks up in speed. If the blade spins before the engine speeds up, the governor will probably choke the engine and cause it to stop. If this occurs, adjustment of the throttle spring should be made. If adjustment is necessary, move spring shown in **Figure 4-9** one hole over and check throttle again. Adjust until clutch lever can be thrown without stalling the engine.

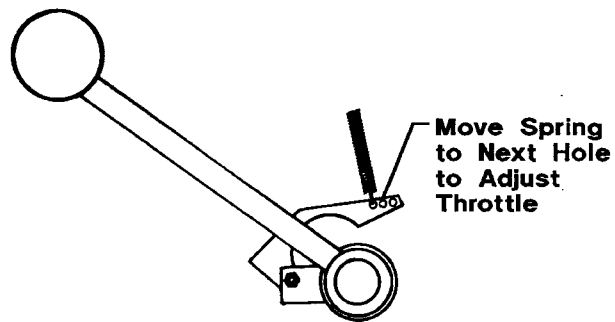
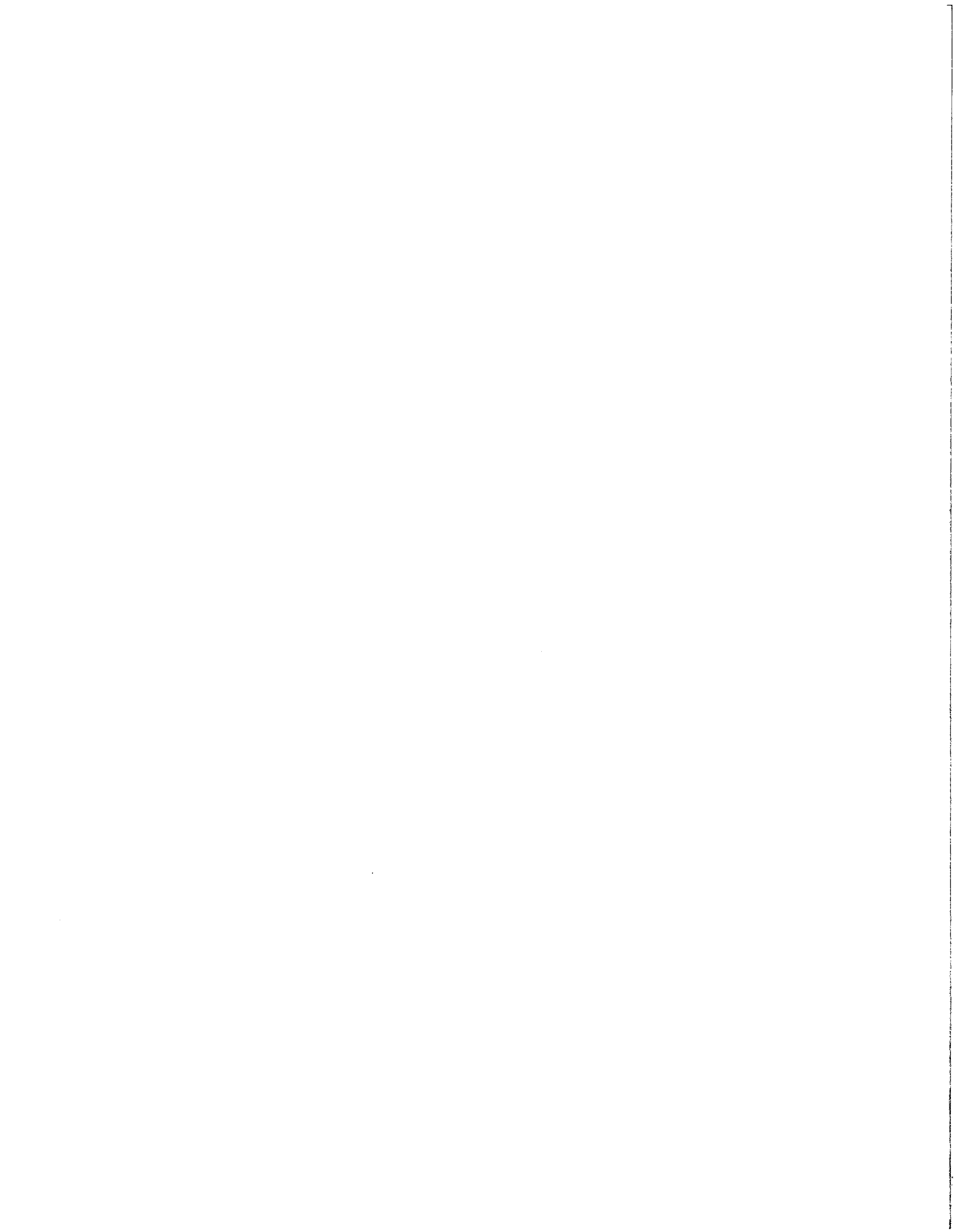


FIG 4-9



SECTION 4-5: BRAKE PAD ADJUSTMENT

Adjust the brake so that the leather pad fully contacts the drive wheel when engaged but make sure the metal bracket is no closer to the wheel than 1/8" at the nearest point (See Figure 4-10). When disengaged, the brake shoe should not contact the drive wheel at all.

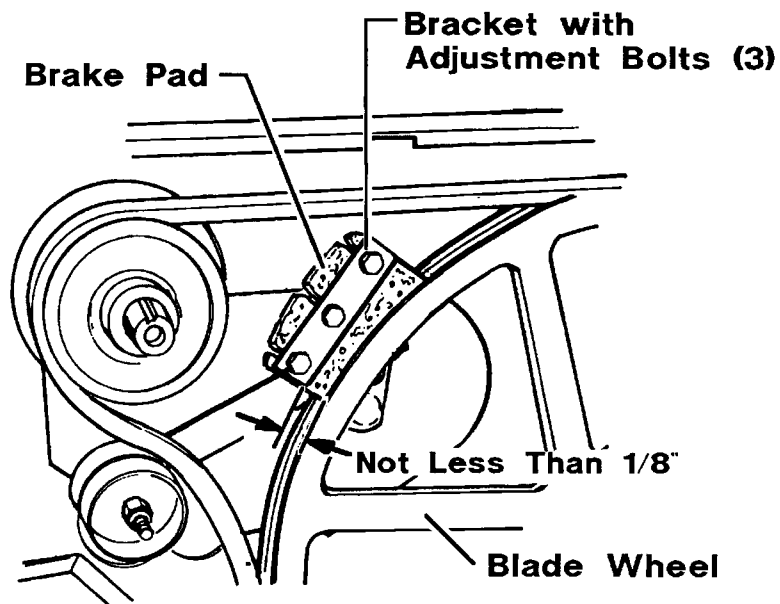
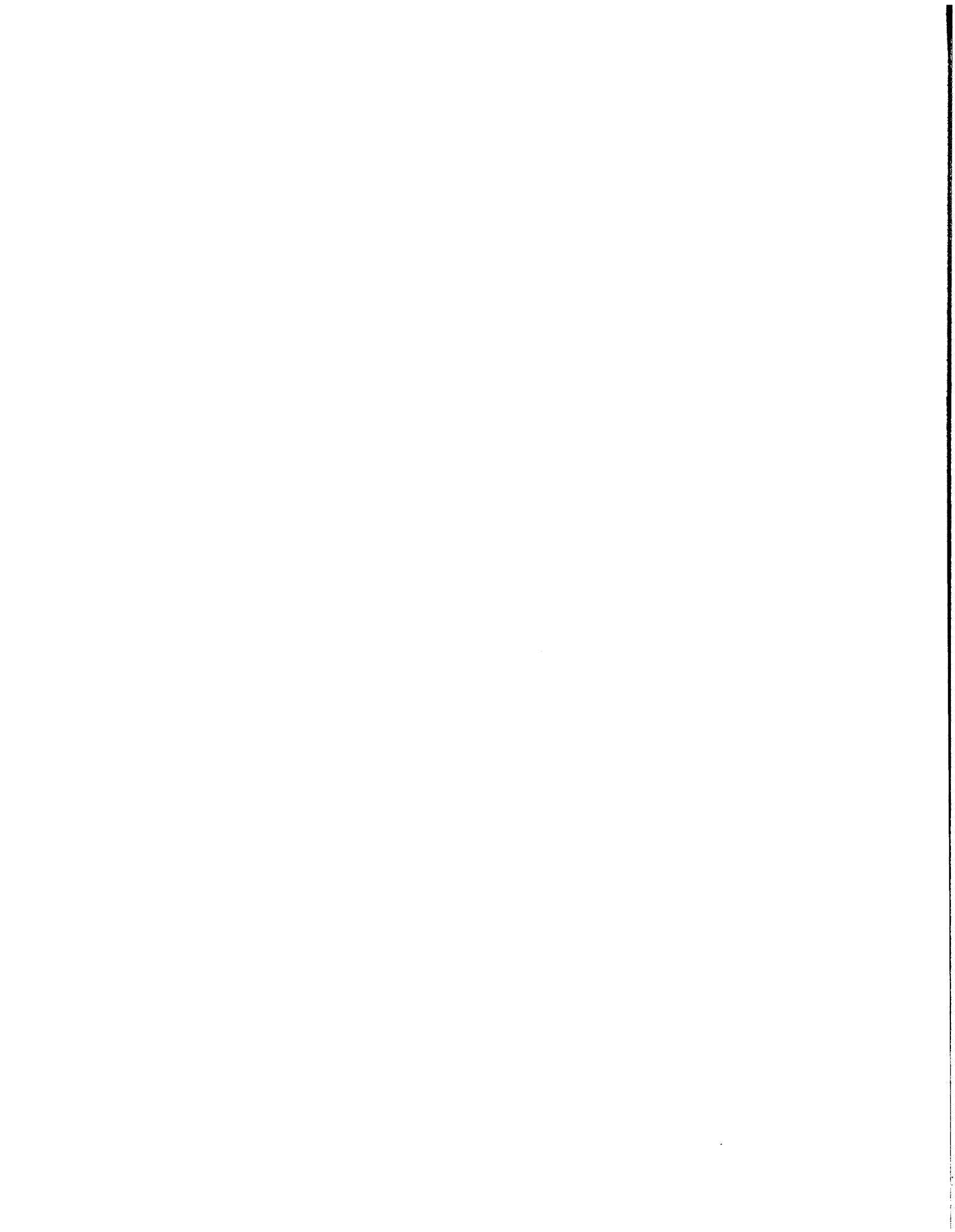


FIG 4-10



SECTION 5-1: BLADE ALIGNMENT ON THE BLADE PULLEYS

Portions of the Wood-Mizer® are pre-aligned. This section will show you how to align the entire mill. Care should be taken in these steps as they will determine how accurate and square your lumber is cut. The areas to be aligned are:

1. Blade aligned on the blade pulleys.
2. Blade parallel to the bed rail.
3. Adjustable bed rails.
4. Blade guide spacing and locations.
5. Side supports square to the bed.
6. Auxilliary supports level to the bed.

The Wood-Mizer® should either be secured to a platform or on firm footing with the outriggers set before aligning. (See Operating Instructions, to set outriggers).

In the following steps the blade should be properly tensioned (See Section 2.7). Spring tension is adjusted with the tension control shown in **Figure 5-1**.

The blade pulleys should be adjusted so that the gullet of the blade rides even with the front edge of the pulleys. Do not let the teeth ride on the wheels (**See Figure 5-2**).

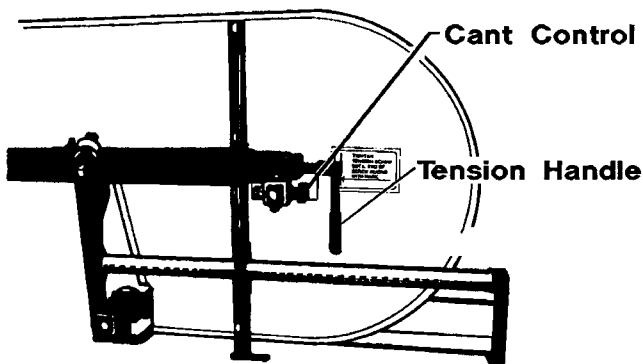


FIG 5-1

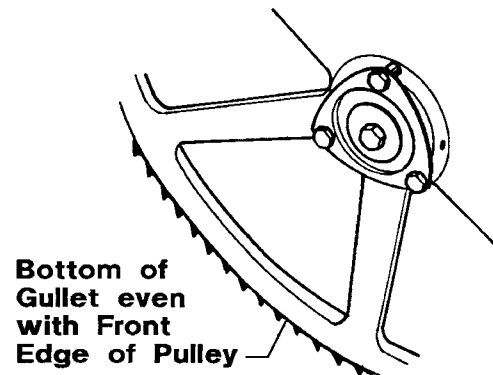
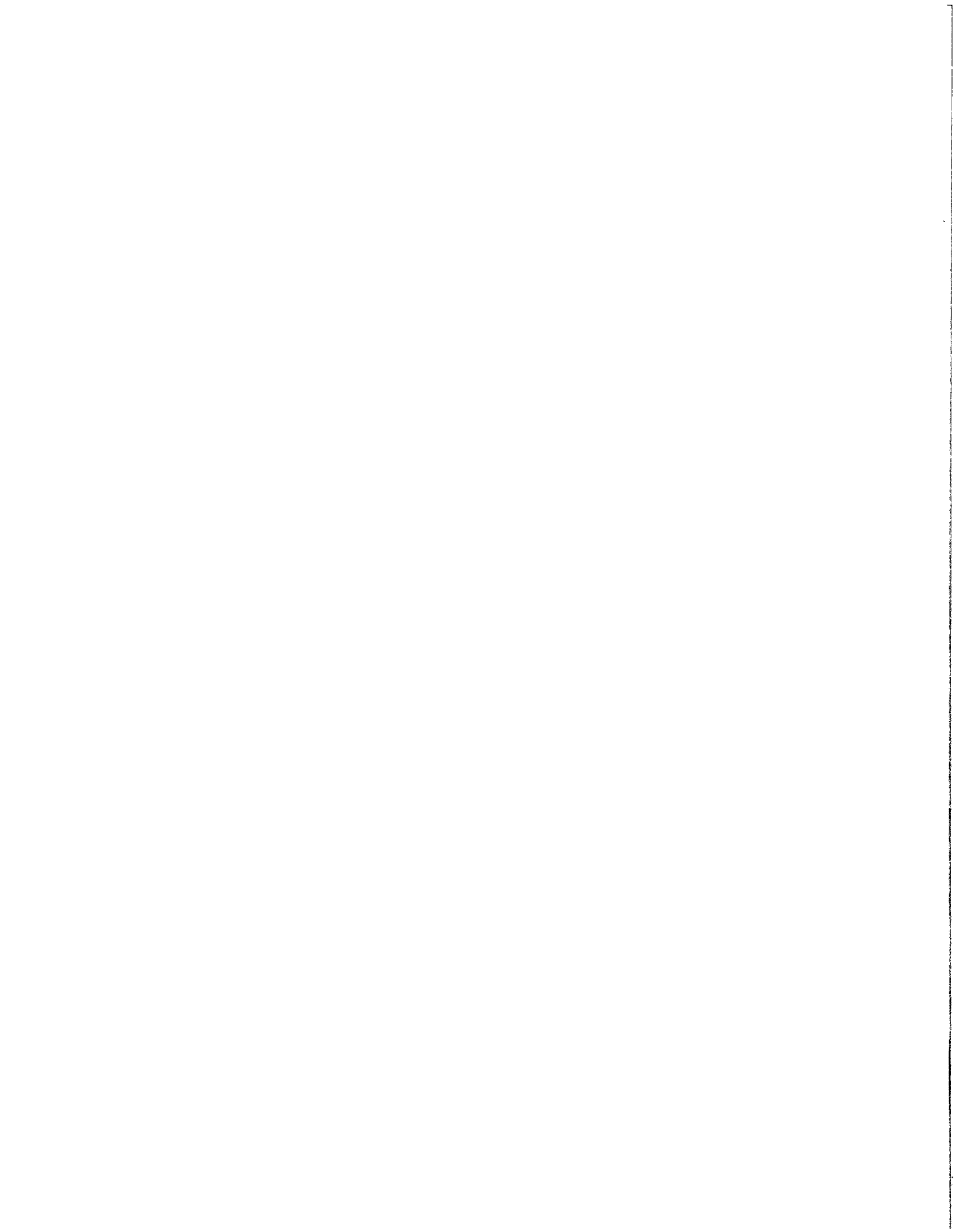


FIG 5-2

Adjustment of the idle side wheel is made with the cant control shown in **Figure 5-1**. Start engine and pull lightly on the clutch handle to rotate the blade until it locates itself. If the blade is too far forward, turn the cant control counter-clockwise; too far back, turn cant control clockwise. Some adjustment in spring tension control may be necessary to compensate for adjustments of the cant control.

The drive-side blade pulley will typically not have to be adjusted; however, the adjustment is available. As you look at the drive shaft from the engine side, you will see four set screws that locate the drive shaft. If you move the drive shaft to the right, the blade will ride further back on the wheel, or vice versa.



SECTION 5-2: BLADE PARALLEL TO BED RAILS

This step will assure you of square cuts and accurate dimensions across the width of your boards.

A. LOWER CAM FOLLOWERS PROPERLY ADJUSTED

Ensure that the lower set of track cam followers contact the lower track rail throughout the entire length of the bed. If adjustment is necessary, use the three adjustment nuts shown in **Figure 5-3**.

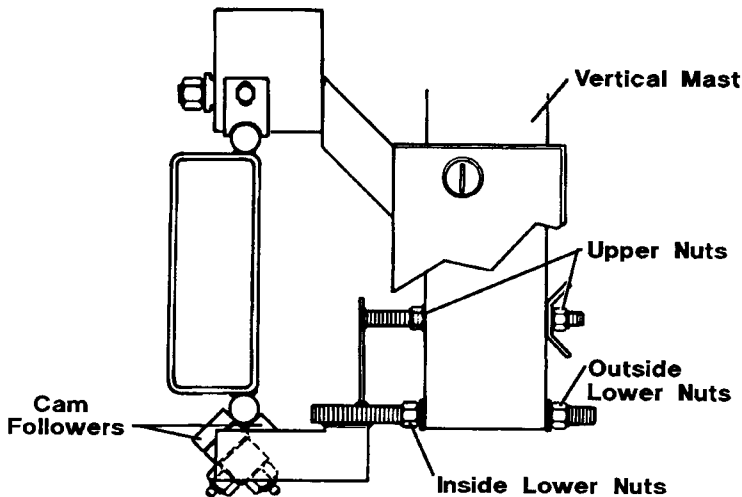


FIG 5-3

Adjustment of the two lower sets of nuts will move the rollers in and out horizontally. To move the rollers out away from the mast, loosen the outside set of nuts and tighten the inside set. To move the rollers in toward the mast, loosen the inside set of nuts and tighten the outside set.

The upper set of nuts is used to raise and lower the roller assembly. Loosen the inside nut and tighten the outside nut to lift the assembly towards the track, loosen the outside nut and tighten the inside nut to lower it away from the track.

Use the three sets of adjustment nuts to adjust the rollers until they both contact the rail through the entire length of the track, but not so tight that the rollers bind and the carriage doesn't move smoothly down the length of the bed.

NOTE: Adjustments of the lower cam followers will change the angle between the carriage head and mill bed. Only minor adjustments of the lower cam followers should ever be necessary. **The bed rails and side supports should always be checked following adjustments of the lower cam followers.**

B. ADJUST BED RAILS TO BLADE

Remove the blade guides or adjust them so they do not contact the blade. Open the adjustable blade guide arm to within 1/4" of full open. Move the carriage head so that the blade is positioned over the fixed log clamp located on the clamping dog receiver (See **Figure 5-4**). Raise the carriage until the bottom of the blade is 6" above the clamp by actual measurement with a tape or ruler.

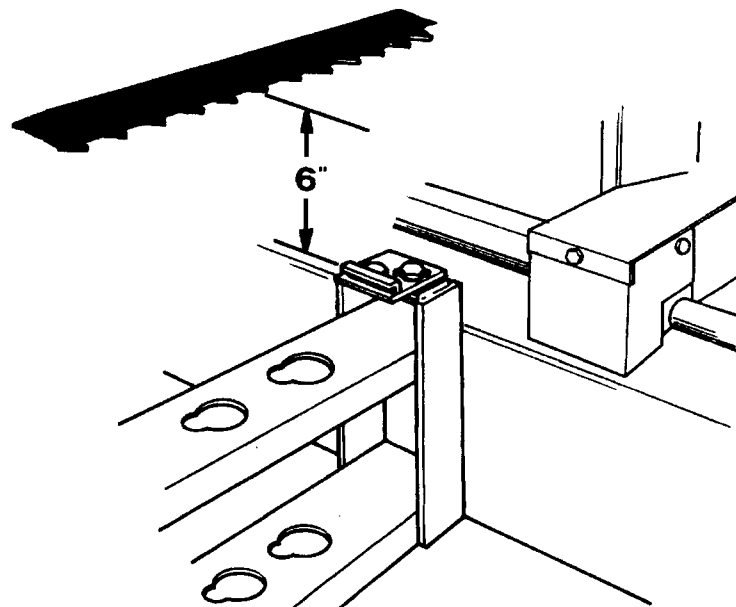
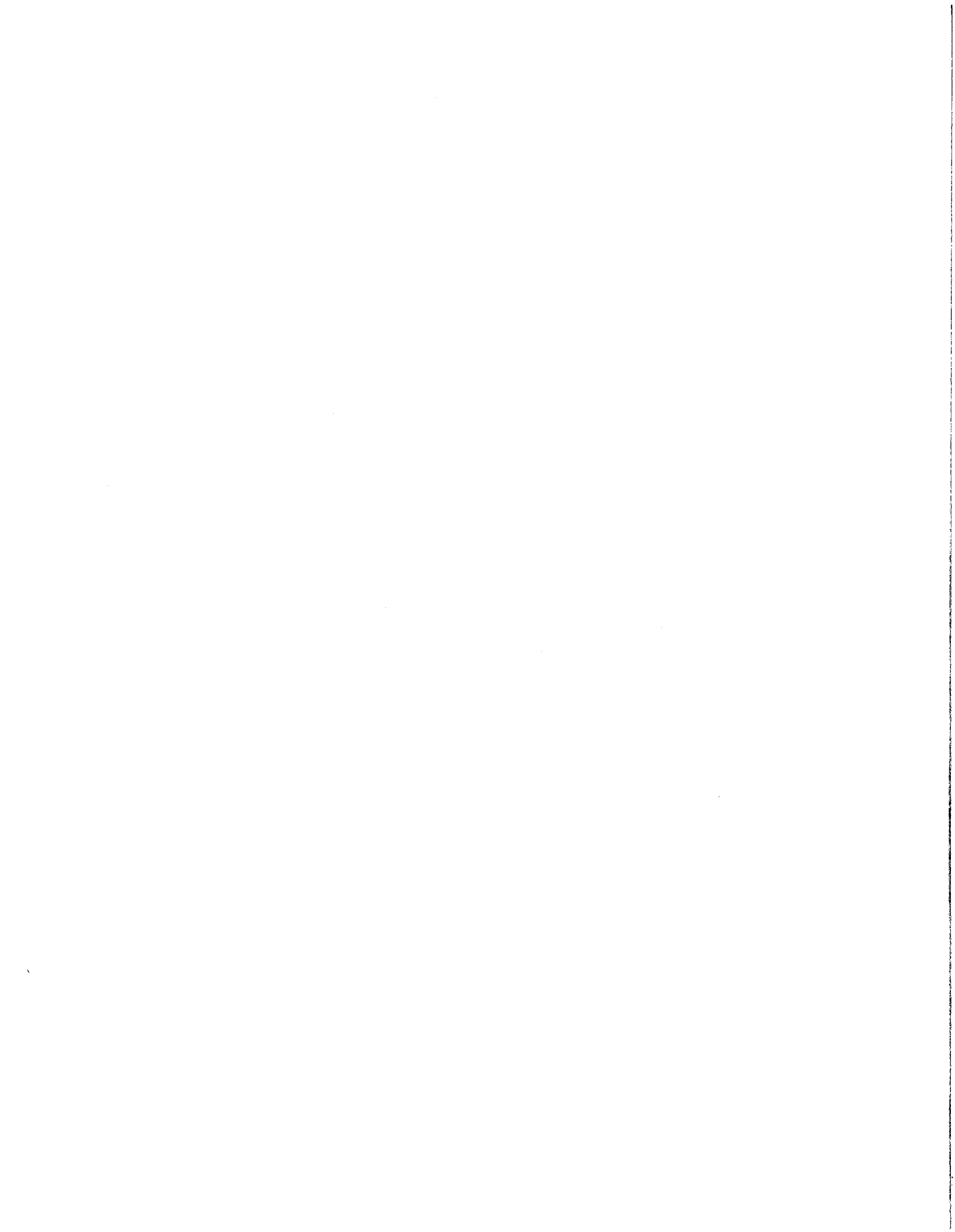


FIG 5-4



SECTION 5-2: BLADE PARALLEL TO BED RAILS - cont'd

Now, move the carriage to position the blade over the rear-most bed rail. Measure the distance between the bottom of the blade and the bed rail at each end of the bed rail (**See Figure 5-5**). This distance should be about $\frac{3}{4}$ " more than the distance measured between the blade and the clamp ($6 \frac{3}{4}$ ", in this case). This will ensure the blade will not contact metal portions of the bed when cutting at 1" above the bed.

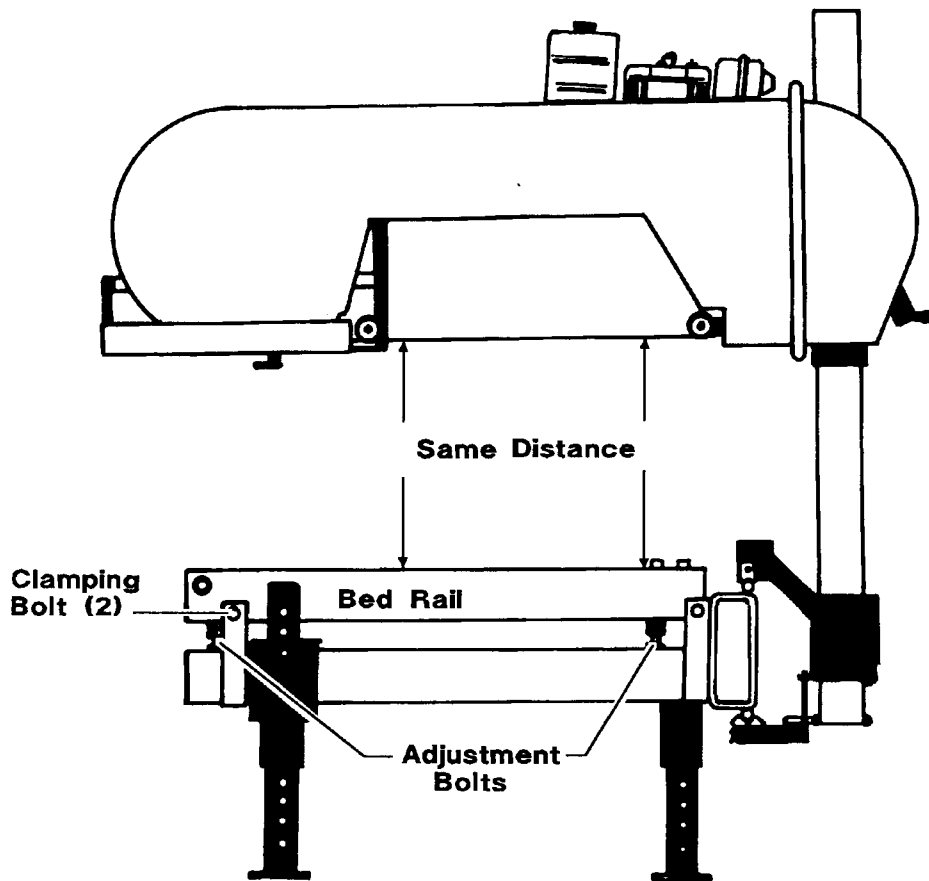


FIG 5-5

The measurements between the blade and the bed rail should be equal at each end of the bed rail. If adjustment is necessary, use the adjusting bolts shown to move the bed rail parallel to the blade. Loosen the clamping bolt and adjust one end of the bed rail until both ends measure $6 \frac{3}{4}$ " from the bottom of the blade.

Without adjusting the carriage height, move the carriage over the next bed rail and repeat previous steps. Check all four bed rails and adjust so that all measure the same distance from the blade at both ends of the bed rail.

SECTION 5-3: BLADE GUIDE ALIGNMENT

Once the blade has been centered on the wheels and the blade and blade guide arm are parallel to the bed rails, the blade guides need to be adjusted to deflect the blade $\frac{3}{16}$ " downward. Raise the carriage until the blade is $10 \frac{3}{16}$ " above a bed rail by actual measurement with a tape measure from the top of the rail to the bottom of the blade. Insert the blade guides and adjust them downward until they hold the blade at $10 \frac{3}{16}$ " from the rail. To lower the blade guide, be sure the two set screws are threaded into the blade guide shaft until they touch each other. Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down $\frac{3}{16}$ " (See Figure 5-6).

NOTE: Be sure that the blade guard clears the blade on both guide assemblies. The guard on the outer guide assembly should be checked with the arm all the way in and all the way out.

Use Jam Nuts to Adjust Roller Up & Down

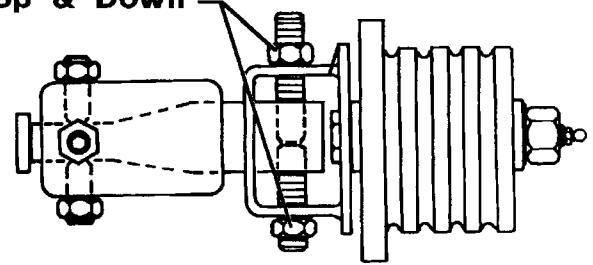


FIG 5-6

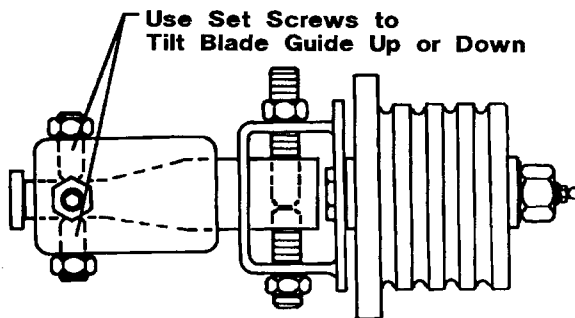


FIG 5-7

NOTE: Once the blade guides have been tilted to the correct angle, any cutting variances are most likely caused by the blade itself and may be solved by proper blade maintenance procedures (See Section 2).

Your blade and guides are now completely aligned to the bed. With the bottom of the blade still $10 \frac{3}{16}$ " from the bed rail, check the indicator on the fixed inch scale. Adjust the indicator to read $10 \frac{3}{16}$ ", if necessary. (See Figure 5-8).

After making the $\frac{3}{16}$ " deflection, you must be sure that the blade guides are tilted at the correct angle.

NOTE: If you have the LTBGAT blade guide alignment tool, skip the following paragraph and see Section 7.5 for instructions on tilting the blade guides.

If the blade guides are tilted up, the blade will tend to rise in the cut. If it is tilted down, the blade will tend to dive in the cut. One good indication of how the blade guides are tilted is what the blade does as it moves off the end of the log after a cut. If the blade falls off the end of the log, the blade guides are tilted up. If the blade guides are tilted up, adjust the upper and lower set screws upward (See Figure 5-7). If there is a gap between the blade and the cant when you bring the carriage back, the blade guides are tilted down and need to be adjusted accordingly.

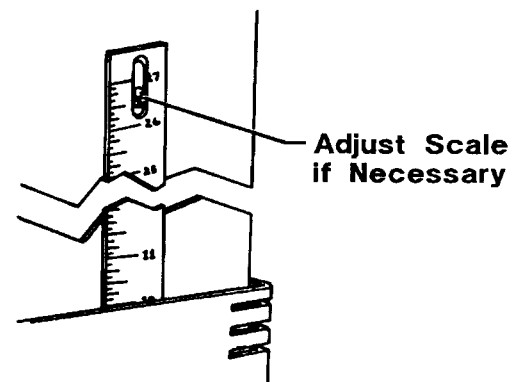


FIG 5-8



SECTION 5-4: SIDE SUPPORTS SQUARE TO THE BED

The side supports are used to clamp flats on a log to set the squareness of the next cut. The cut will only be as square as the supports.

Swing the side support down and measure between the back side of the support and the main bed tube. Make measurements at both ends of the side support to see that it is parallel to the rail. Use the two lower bolts to adjust the side support parallel to the main tube, if necessary (See Figure 5-9).

Place a board across the bed rails and swing the side supports up vertical (See Figure 5-10). Check the angle of each support with a square on the board. Loosen the top adjusting bolt to adjust the angle if necessary, and retighten.

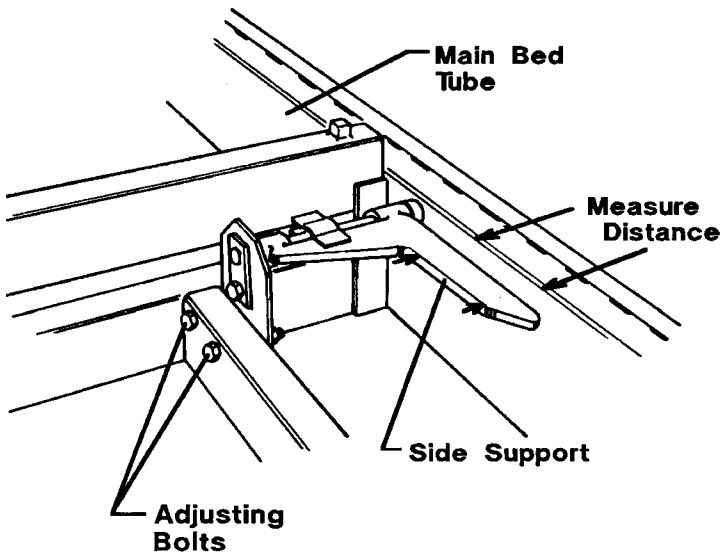


FIG 5-9

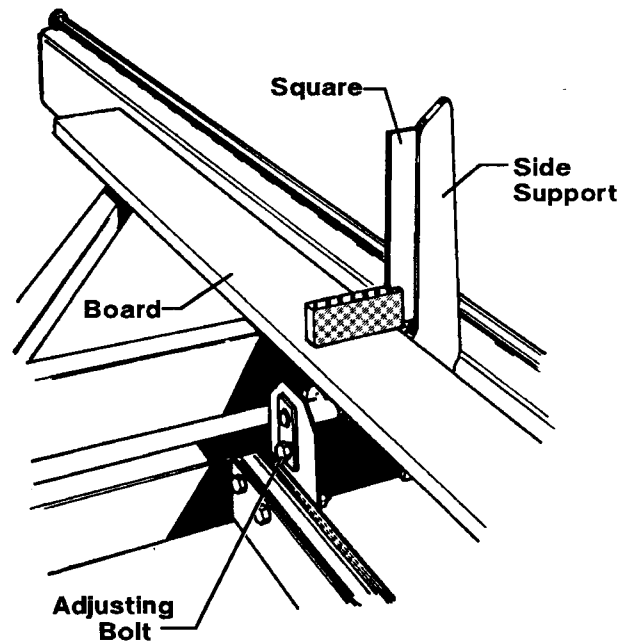


FIG 5-10



SECTION 5-5: ALIGNMENT OF PIVOTING AUXILIARY BED SUPPORTS

The two outside pivoting auxiliary supports are used when long cants are being cut that tend to bend down at the ends. The supports need to be adjusted to the same level as the main bed rails. Position the carriage head so that the blade is over one of the auxiliary supports. Measure the distance from the top of the support to the bottom of the blade at each end of the support. The two measurements should correspond with the reading of the depth scale. Use the bolt shown in **Figure 5-11** to adjust the height of the support and the set screws to adjust the angle of the support. Check the support pivoted in several positions as shown and adjust as necessary until support measures the same distance from the blade in all positions.

**NOTE: AVOID ROLLING LOGS OR LARGE CANTS ONTO AUXILIARY SUPPORTS.
THIS WILL REDUCE THE RISK OF DAMAGING OR KNOCKING SUPPORTS OUT OF ALIGNMENT.**

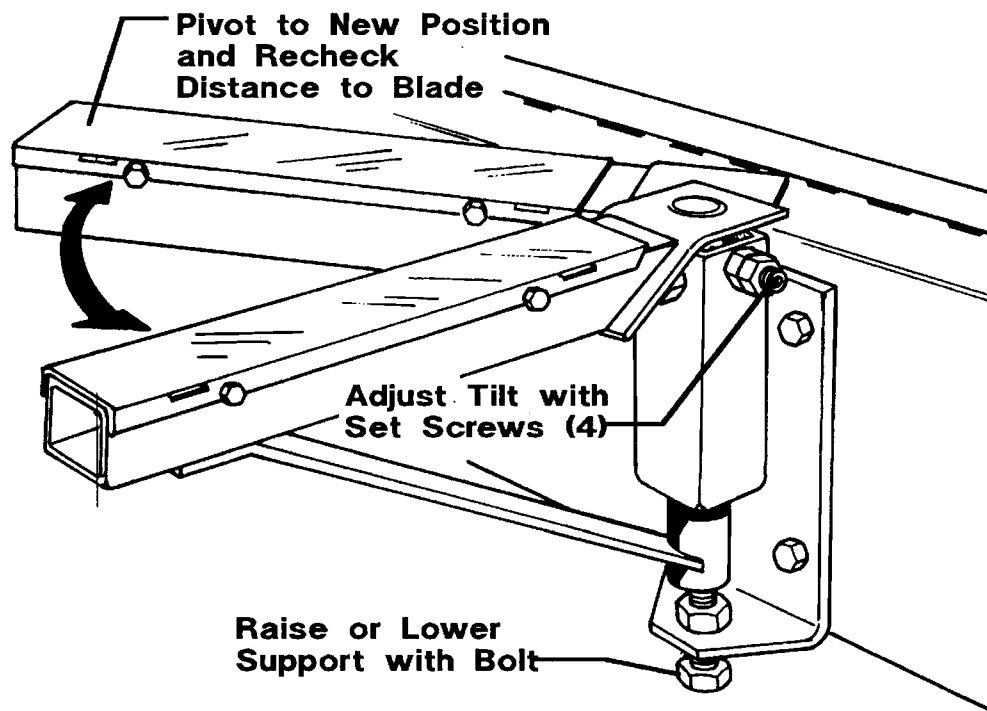
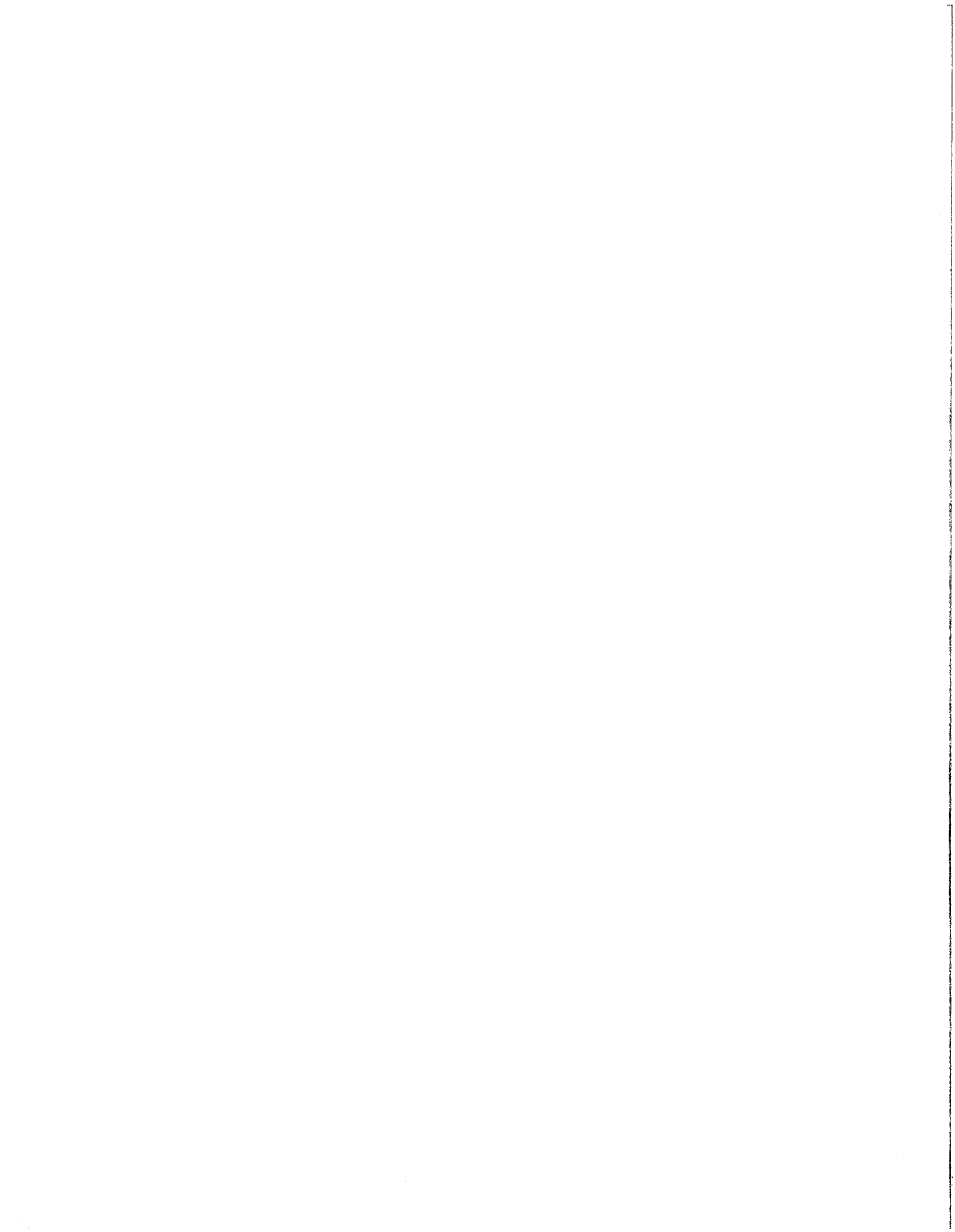
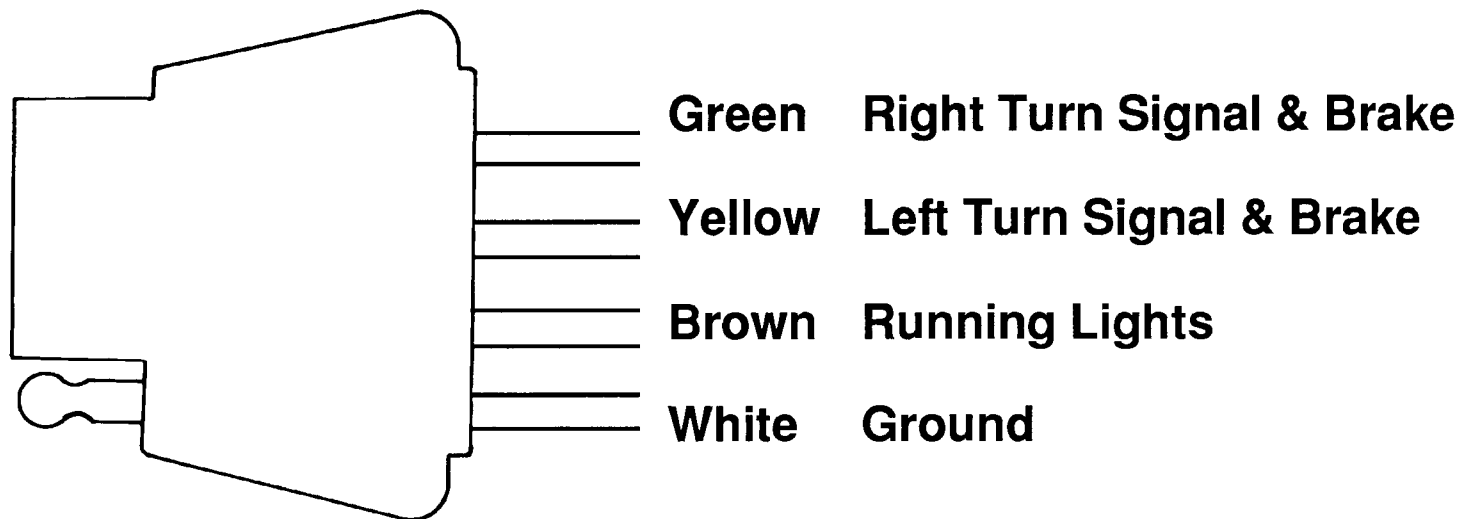


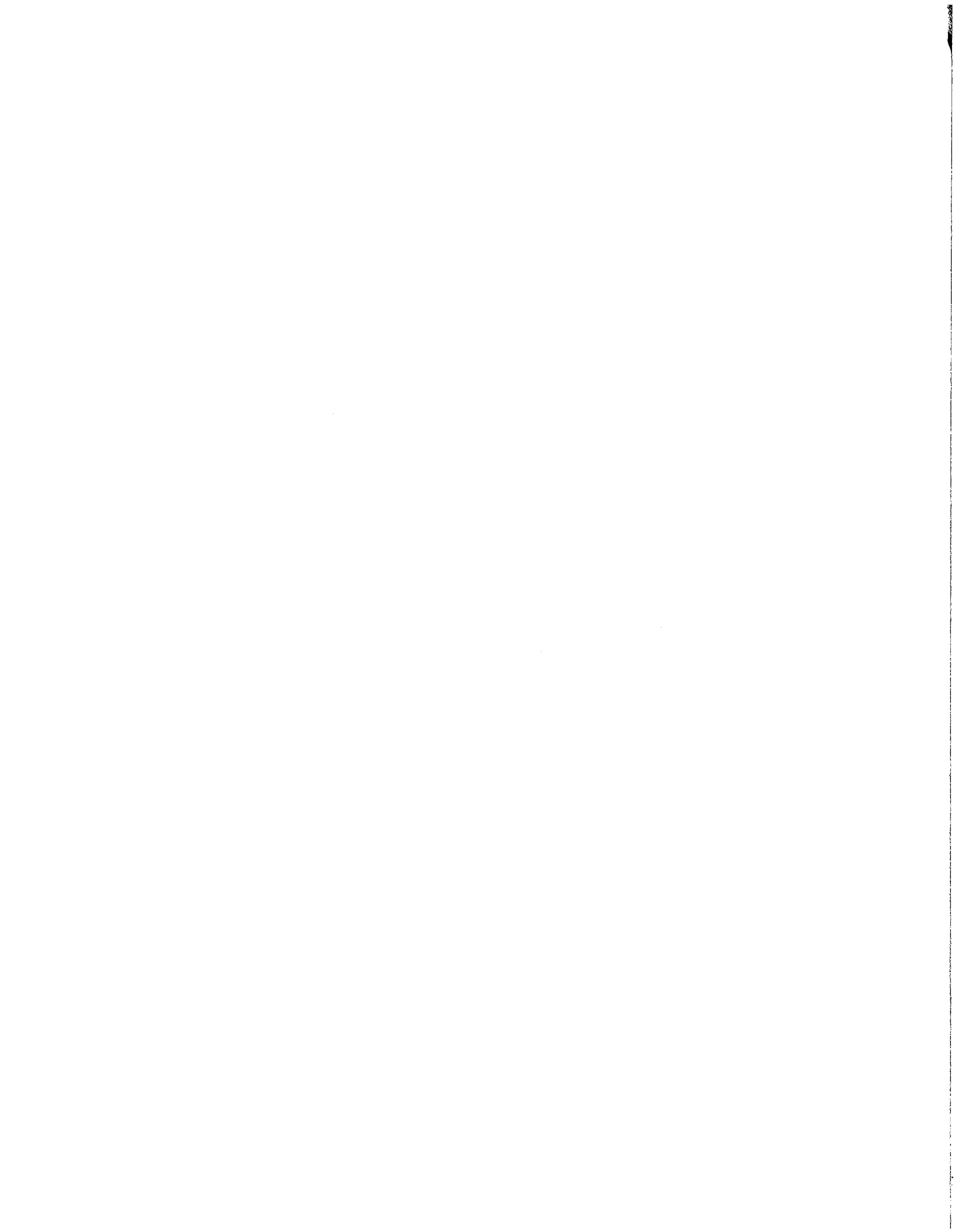
FIG 5-11



SECTION 6-1: RUNNING LIGHTS



**FIG 6-1 WIRING FOR OPTIONAL TRAILER
PACKAGE LIGHTS**



SECTION 6-2: PARTS LIST & ILLUSTRATIONS

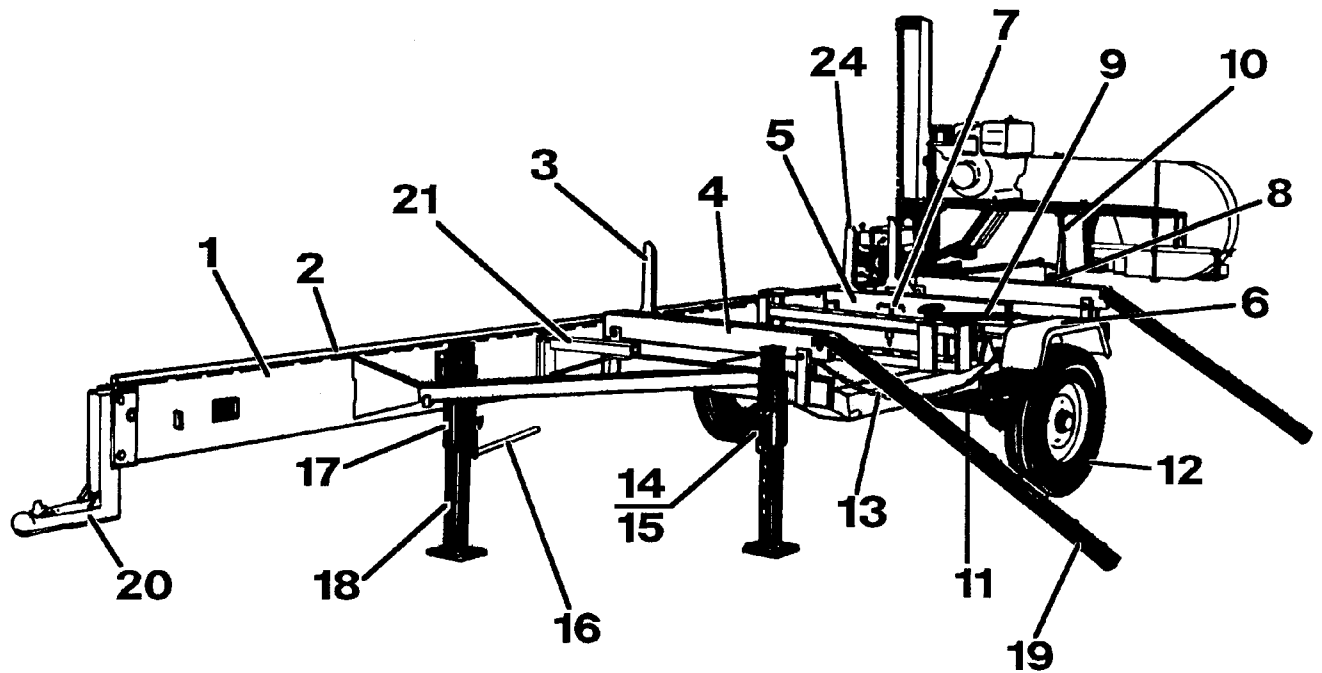
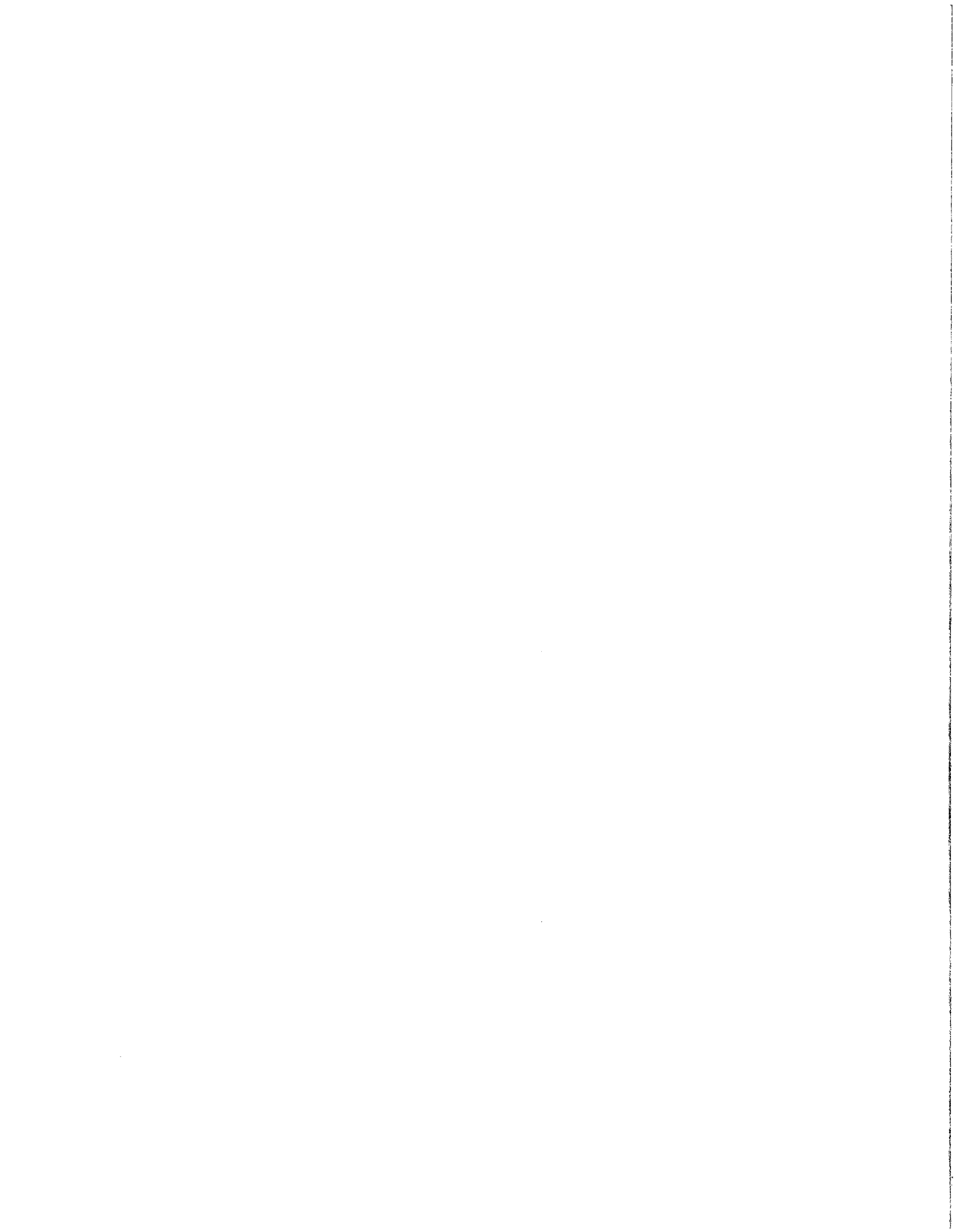


FIG 6-2 LT20D FRAME AND TRAILER PACKAGE

Ref	Part #	Description
1.	R01585	3" x 8" x 3/16" Main Frame Tubing (per ft)
2.	R01840	1" Hardened Track (per ft)
3.	W09401	Side Support with Stop
4.	A08676	Adjustable Bed Rail, Front or Rear
5.	A09565	Adjustable Bed Rail, Middle
6.	W07509	Fender
7.	K09810	Ramp Retainer Kit
8.	P04294	Tail Light
9.	W09412	Clamping Dog
10.	W08629	Carriage Rest Pin
11.	A09479	Axle with Wheel and Tires
12.	P04468	13" Tire and Rim
13.	M04311	Locking Chain
14.	A04278	Outrigger Guide, Front/Loading Side
15.	A09475	Outrigger Guide, Rear/Loading Side
16.	S04827	Jack Handle
17.	A04287	Outrigger Guide, Track Side, Front & Rear
18.	W07537	Outrigger Leg
19.	W09014	Loading Ramp
20.	W04258	LT20D Hitch Assembly
21.	K06897	Pivoting Bed Rail Kit
24.	W09255	Side Support



SECTION 6-2: PARTS LIST & ILLUSTRATIONS - cont'd

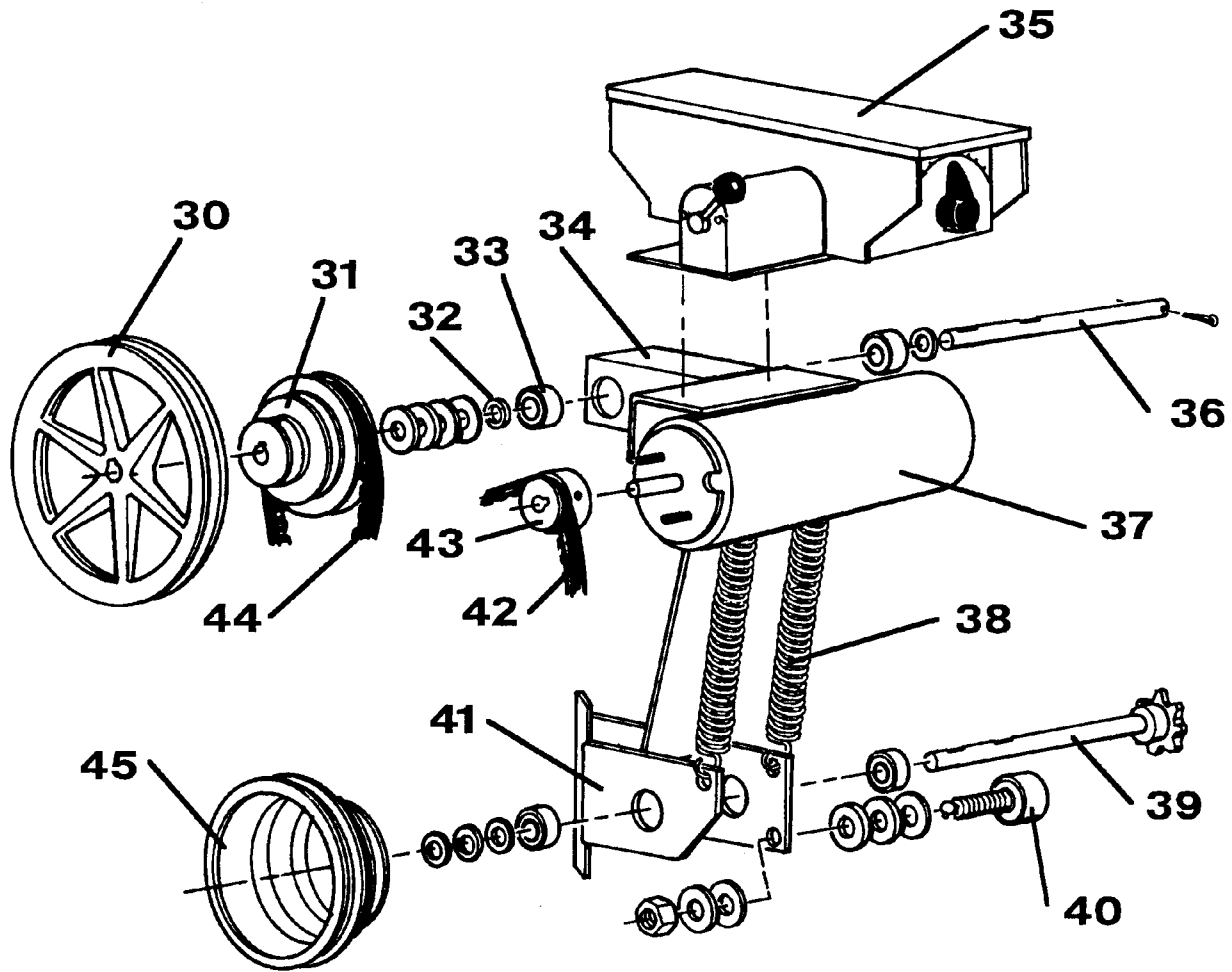


FIG 6-3 POWER FEED ASSEMBLY

Ref	Part #	Description
30.	P04343	8" Pulley
31.	P04100	2-3-4 Step Pulley
32.	F05011-9	5/8" Nylon Washer
33.	P04156	R-10 Bearing
34.	W09008	Power Feed Upper Bracket
35.	A07800-W	Power Feed/Drum Switch Assembly
36.	S04097	Upper Power Feed Shaft
37.	A07974	Power Feed Motor
38.	P09591	Power Feed Spring
39.	W09577	Lower Power Feed Shaft
40.	A05044	Power Feed Cam Follower
41.	W09018	Power Feed Lower Bracket
42.	P04349	3L290 Ribbed V-Belt
43.	S09579-W	Power Feed Motor Pulley
44.	P04031	4L280 Ribbed V-Belt
45.	P04103	4-5-6 Step Pulley

SECTION 6-2: PARTS LIST & ILLUSTRATIONS - cont'd

Ref	Part #	Description
50.	P08592	Spark Arrestor
51.	P08591	Air Filter
52.	P08590	Spark Plug
53.	P08475	Air Pre-Cleaner

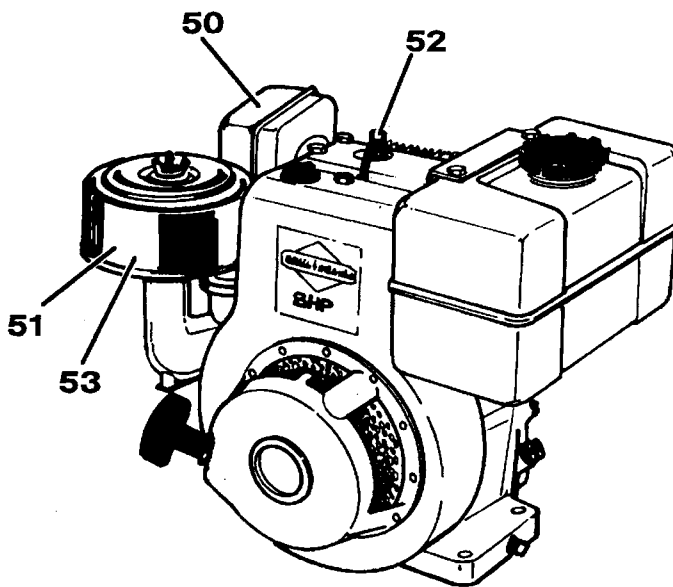


FIG 6-4 BRIGGS & STRATTON 8HP ENGINE

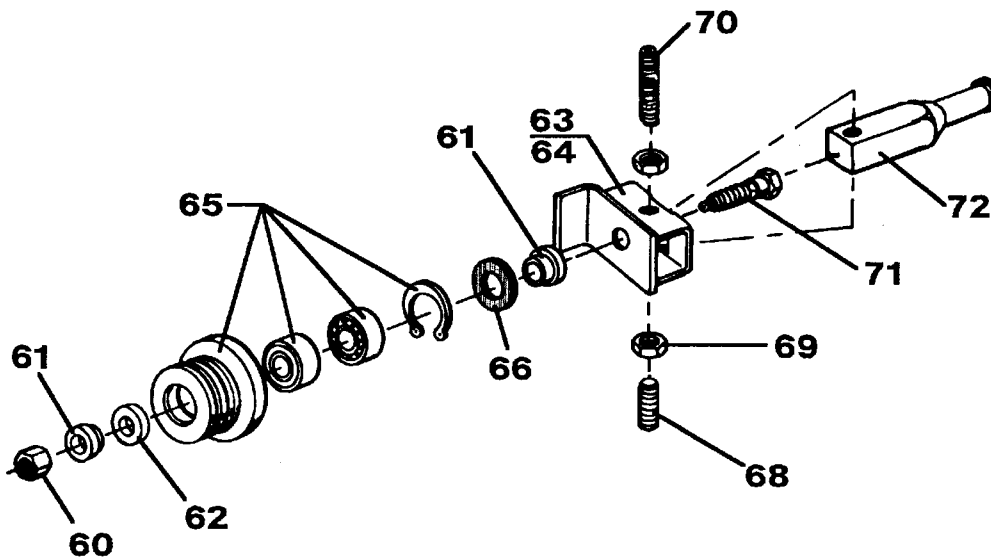


FIG 6-5 BLADE GUIDE ASSEMBLY

Ref	Part #	Description	Ref	Part #	Description
60.	F05010-12	1/2-20 Lock Nut	68.	F05007-48	3/8-24 x 1" Set Screw
61.	S04253-W	Blade Guide Spacer	69.	F05010-22	3/8-24 Jam Nut
62.	P04252	White Felt Washer	70.	F05007-49	3/8-24 x 1 1/2" Set Screw
63.	W08482	Blade Guide Bracket	71.	A09417	Blade Guide Bolt w/Grease Zerk
64.	W08495	Blade Guide Bracket, w/Tube	72.	S08196-W	Blade Guide Shaft
65.	A04925	Blade Guide Roller Assembly			
66.	P06455	Gray Felt Washer			

Complete Blade Guide Assemblies Available

- A08197 All Items Shown - Drive Side
- A08191 All Items Shown - Idle Side
- K07079 Blade Guide Rebuild Kit includes 2 bearings, 2 felt washers, 2 spacers, & 1 retaining ring

SECTION 6-2: PARTS LIST & ILLUSTRATIONS - cont'd

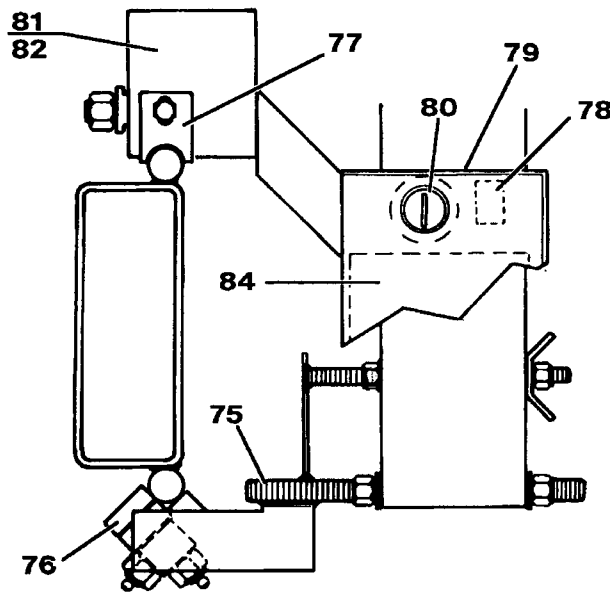
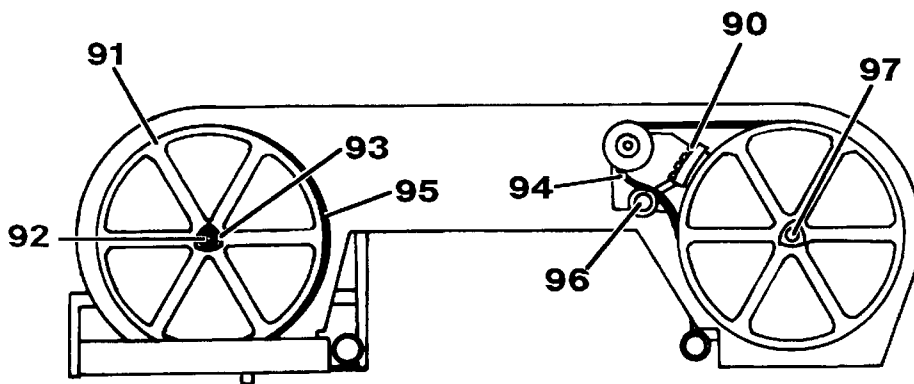


FIG 6-6 TRACK CAM FOLLOWER ASSEMBLY

Ref	Part #	Description
75.	A05043	Cam Follower w/45 Deg. Zerk
76.	S08669	Plastic Track Scraper
77.	A08647	Complete Lower Cam Assy.
78.	A04706	Circuit Breaker
79.	S08617	Battery Box Cover
80.	P04350	Key Switch
81.	A08672	Upper Roller Assy (Drive)
82.	A08673	Upper Roller Assy (Idle)
83.	P04349	3L290 Feed Belt (Manual Feed Only)
84.	P08638	Battery



Ref	Part #	Description
90.	S08548	Brake Pad
91.	P08125	19" LT20D Blade Pulley
92.	P08066	#6203-2NSL Bearing
93.	S08490	Bearing Retainer Plate
94.	P08709	BX66 V-Belt, LT20D Drive
95.	P04185	B57 V-Belt
96.	A08549	Idler Assembly
97.	S08223-W	Blade Pulley Shaft

FIG 6-7 CUTTING HEAD (REAR VIEW)

SECTION 6-2: PARTS LIST & ILLUSTRATIONS - cont'd

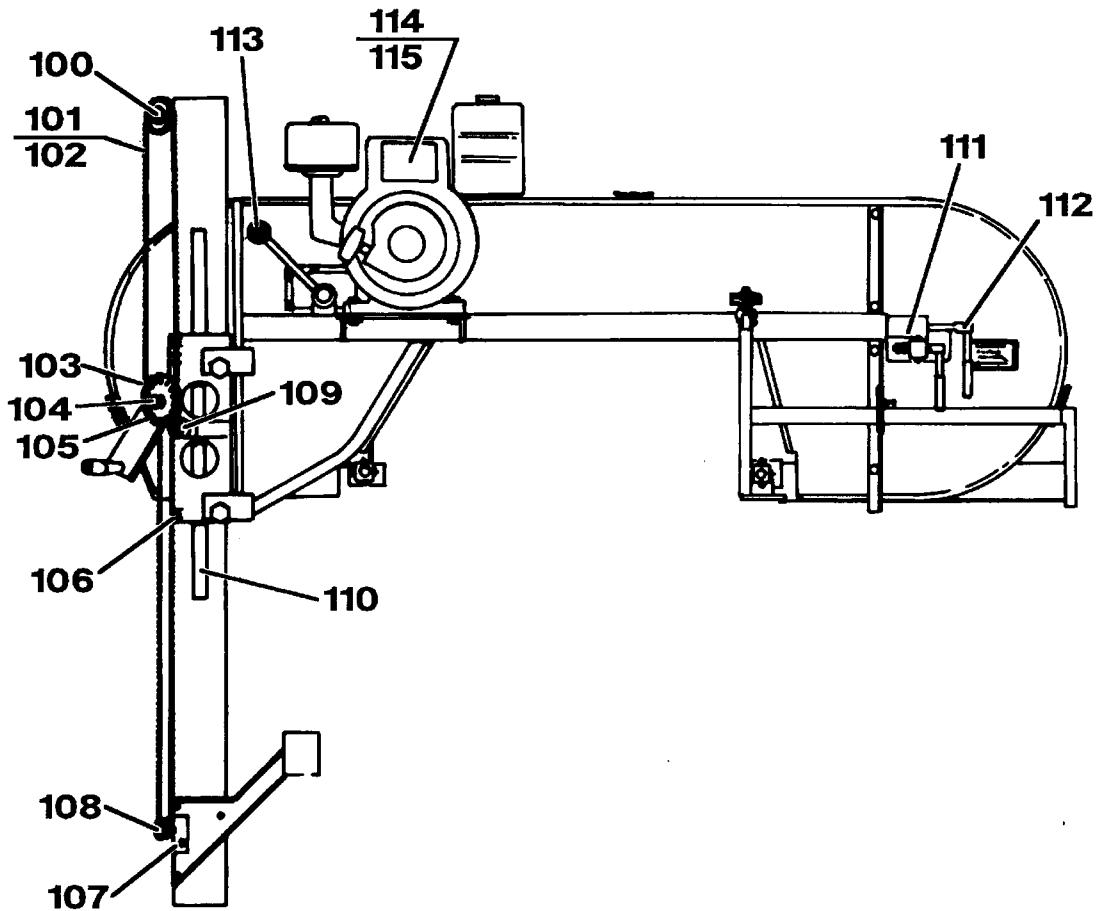


FIG 6-8 CUTTING ASSEMBLY AND MAST (FRONT VIEW)

Ref	Part #	Description
100.	P08068	Upper Idler Sprocket
101.	P08126	Up/Down Chain
102.	P08076	Up/Down Chain Master Link
103.	A08390	Up/Down Sprocket Assy
104.	W08346	Up/Down Dial Weldment
105.	A08477	Socket Head Bolt w/Locknut
106.	P08028	Slide Pad
107.	A08295	Chain Tensioner Assembly
108.	A08476	Tensioner Roller w/Snap Ring
109.	P06030-1	6203-10 Up/Down Bearing
110.	S08454-W	LT20D Inch Scale
111.	P04235	Tension Die Spring
112.	A08165	Tension Handle Assembly
113.	W08521	Clutch Handle Assembly
114.	A08602	8HP Electric Start Engine Assy
115.	A08584	8HP Manual Start Engine Assy

SECTION 6-2: PARTS LIST & ILLUSTRATIONS - cont'd

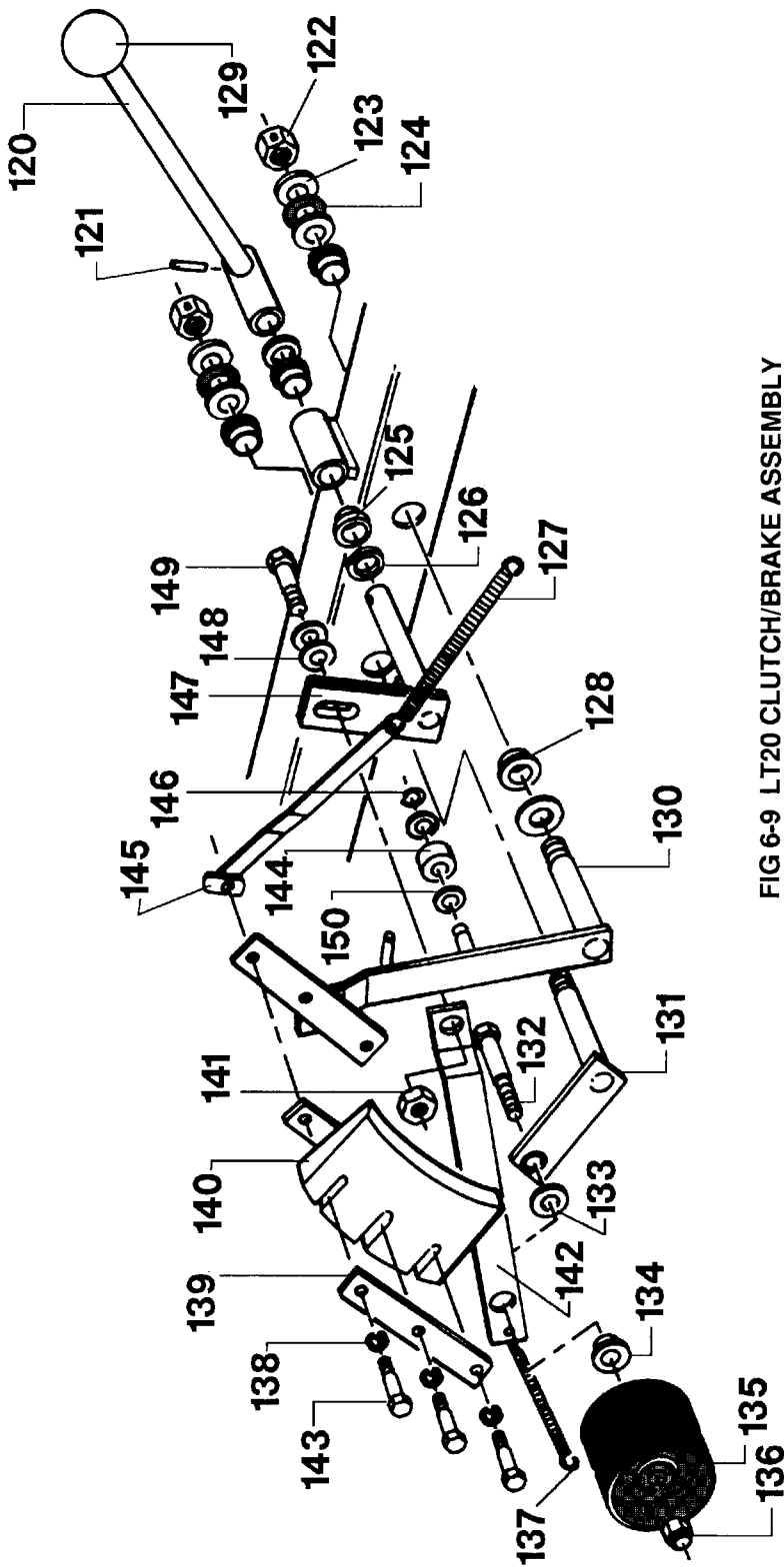


FIG 6-9 LT20 CLUTCH/BRAKE ASSEMBLY

Ref	Part #	Description	Ref	Part #	Description
120.	W08522	Clutch Handle Weldment	135.	S08585	Idle Roller, LT20
121.	F05012-11	3/16 x 1 Roll Pin	136.	F05010-10	3/8-16 Nylon Locknut
122.	F05010-3	1/2-13 Locknut	137.	P08539	Idle Roller Return Spring
123.	F05011-2	1/2 Flat Washer	138.	F05011-14	1/4 Split Lockwasher
124.	F05011-24	1/2 Spring Washer	139.	S08551	Brake Clamp Plate
125.	P05135	5/8 I.D. Bronze Bushing	140.	S08548	Brake Pad
126.	S09090	Nylon Washer	141.	S08535-W	Clutch Arm Nut
127.	P08538	Brake Arm Return Spring	142.	S08534	Clutch Link Arm
128.	P08060	SF1620-6 Bronze Bearing	143.	F05005-5	1/4-20 x 1 1/2 Hex Head Bolt
129.	P04211	Plastic Ball Knob	144.	S08586	Nylon Roller
130.	W08520	Brake Arm Weldment	145.	W08583	Brake Spring Link Arm
131.	W08529	Idle Arm Weldment	146.	F04254-3	3/8 Ext. Retaining Ring
132.	F05007-29	3/8-16 x 2 3/4 Hex Head Bolt	147.	W08526	Clutch Arm Weldment
133.	F05011-3	3/8 Flat Washer	148.	F05011-3	3/8 Flat Washer
134.	S08532-W	Idle Roller Spacer	149.	F05007-7	3/8-16 x 1 Hex Head Bolt
			150.	F05011-17	5/16 Flat Washer

SECTION 7-1: WATER LUBE

The Water Lube System is primarily a system to keep the blade clean. Water is routed from a 4-gallon bottle to a blade guide bracket. The water flow is controlled from a valve on the cap of the bottle.

To install the Water Lube System, simply fill the jug with water and slide the support bracket onto the vertical mast (See Figure 7-1).

Route the hose from the bottle valve between the cutting head and the mast of the carriage assembly, then down to the tube that is welded to the drive-side blade guide bracket (See Figure 7-2).

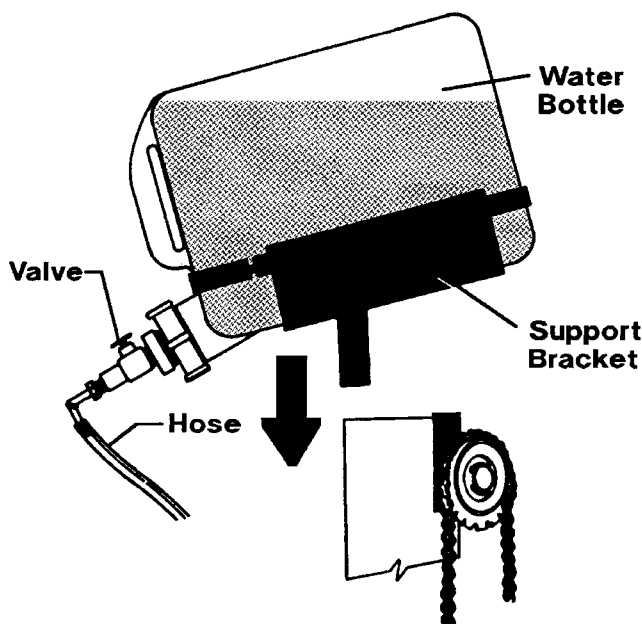


FIG 7-1

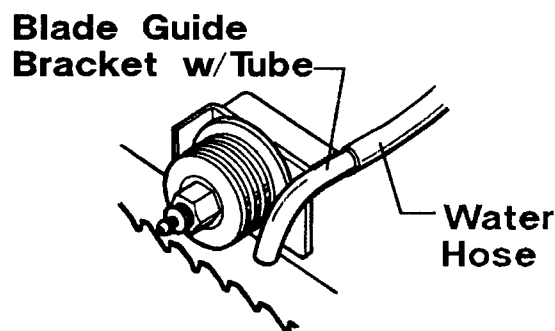


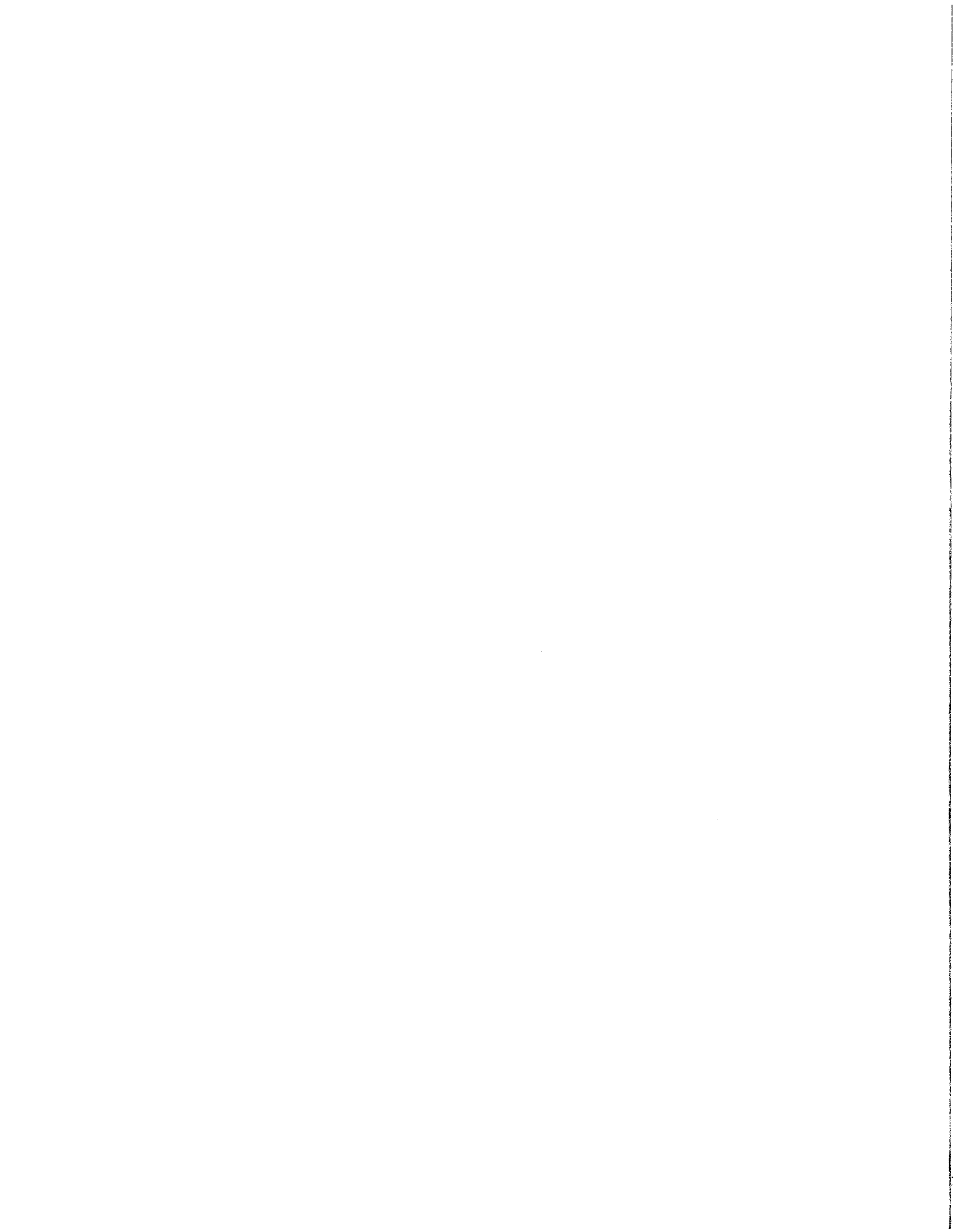
FIG 7-2

Not all types of wood require the use of the Water Lube System, but when it is necessary, use only enough water to keep the blade clean. This conserves water and reduces the risk of water staining the boards.

Average flow rate will be one to two gallons per hour.

CAUTION: NEVER USE FLAMMABLE FUELS OR LIQUIDS INSTEAD OF WATER WITH THIS OPTION. IF BLADE REQUIRES CLEANING WITH THESE TYPES OF MATERIALS, TAKE THE BLADE OFF AND HAND CLEAN WITH A RAG.

Before removing the blade, engage the clutch lever and allow the blade to spin with the water running on it for about 15 seconds. This will clean the blade, leaving it free of sap build-up. Wipe the blade with a dry rag before storing or sharpening.



SECTION 8-1: TROUBLE SHOOTING

PROBLEM	CAUSE	SOLUTION
Battery will not stay charged	Key switch left on	Turn switch off when not in use
	Short in system	Visually check for bare wires and/or have checked
	Charging system not functioning	Have system checked by authorized Briggs & Stratton dealer
	Bad cells	Check fluid levels and add proper solution
Blades Dull Quickly	Idle improper	Adjust to proper amps while idling
	Dirty logs	Clean or debark logs, especially on entry side of the cut
	When grinding teeth, heating too much and causing teeth to soften	Grind just enough metal to restore sharpness to the teeth. Use Wet-Grind while sharpening blade
Blades Break Prematurely	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Section 2-3)
	Rubber tires on blade pulleys worn to a point that blade contacts metal pulley - look for shiny spots on edge of pulleys	Change Belts (B-57 & B-67)
	Poor sharpening techniques	See Section 2-3 & 2-4
Blade Doesn't Track Right on Drive Wheel	Tension too tight	See Section 2-7
	Cant adjustment is not correct	Re-adjust (See Section 5)
	Flat/worn belts	Replace B57 & B67 belts
	Possible bearing problem	See Section 4-1

SECTION 8-1: TROUBLE SHOOTING - cont'd

PROBLEM	CAUSE	SOLUTION
Blade Guides Don't Spin While Cutting	Frozen Bearings	Replace Bearings
	Stiff Bearings	Grease Bearings
Blade Doesn't Stop Immediately After Disengaging	Brake shoe worn loose	Adjust (See Section 4-5)
Boards Thick or Thin on Ends or Middle of Board	Stress in log which causes log to not lay flat on the bed	After log has been squared, take equal cuts off opposing sides. i.e., Take a board off the top, then turn the log 180 and take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut
	Set in teeth	Reset and sharpen
	Bed adjustments out	Re-adjust (See Section 5)
	Vertical side supports not square to bed	Adjust side supports (See Section 5-4)
Lumber is Not Square	Blade not parallel to bed rails	Adjust bed rails parallel to blade (Section 5)
	Sawdust or bark between cant and bed rails	Remove particles
	Tooth set problems	Re-set and sharpen
	Feed belt between feed motor and 8" pulley is loose	Re-tension belt using bolt behind the motor. Belt should be loose as possible with no slippage.
Power Feed Slows or is Jerky in Cut	Rail cam followers too tight	Re-adjust (Section 5)
	Bad seam on feed belt	Replace belt
	Excessive oiling	Do not oil track
Sawdust Builds Up On Track	Track wipers worn	Adjust wipers to firmly contact track
	Track is sticky	Clean track with solvent and apply silicone spray

SECTION 8-1: TROUBLE SHOOTING - cont'd

PROBLEM	CAUSE	SOLUTION
Power Feed Slows or is Jerky in Cut	Feed belt between feed motor and 8" pulley is loose	Re-tension belt using bolt behind the motor. Belt should be loose as possible with no slippage.
	Rail cam followers too tight	Re-adjust (Section 5-2)
	Bad seam on feed belt	Replace belt
Sawdust Builds Up On Track	Excessive oiling	Do not oil track
	Track wipers worn	Adjust wipers to firmly contact track
	Track is sticky	Clean track with solvent and apply silicone spray
Up/Down Elevator Excessively Slow	Vertical wear pads too tight	Adjust pads (Section 4-1)
	Up/Down belt loose	Adjust belt to be as loose as possible with no slippage
	Low battery	Recharge
Wavy Cuts	Excessive feed	Slow feed rate
	Improperly sharpened blade This will be the problem 99% of the time!	Resharpen blade (See Section 2 - read entire section!)
	Blade guides improperly adjusted	Adjust guides (See Section 5-4)
	Sap build-up on blade	Use waterlube (See Section 7-1)
	Tooth set problem	Re-set, equalize and sharpen
Up/Down or Power Feed Motors Don't Work	Worn contacts in drum switch	Replace switch or remove cover and clean contacts
	Burned out motor	Replace motor
	Bad connection on battery post or loose wire	Check for loose wire or terminal connections