

Wood-Mizer[®] Sawmill

Safety, Setup, Operation & Maintenance Manual

LT25
LT25L/LT27

rev. C2.00 - E3.02
rev. C2.00 - E3.02



Safety is our #1 concern! Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

October 2004

Form #765

Table of Contents

Section-Page

SECTION 1	INTRODUCTION	1-1
1.1	About This Manual.....	1-1
1.2	Customer and Sawmill Identification.....	1-2
1.3	Getting Service.....	1-4
	<i>General Contact Information.....</i>	<i>1-4</i>
	<i>Branches & Authorized Sales Centers.....</i>	<i>1-5</i>
1.4	Specifications.....	1-7
SECTION 2	SAFETY	2-1
2.1	Safety Symbols.....	2-1
2.2	Safety Instructions.....	2-2
SECTION 3	SAWMILL SETUP	3-1
3.1	Stationary Sawmill Setup.....	3-1
3.2	Portable Sawmill Setup.....	3-3
3.3	Replacing The Blade.....	3-7
3.4	Tensioning The Blade.....	3-8
3.5	Tracking The Blade.....	3-9
3.6	Starting The Engine.....	3-11
SECTION 4	SAWMILL OPERATION	4-1
4.1	Loading, Turning And Clamping Logs.....	4-1
4.2	Up/Down Operation.....	4-3
4.3	Blade Guide Arm Operation.....	4-4
4.4	Clutch/Brake Operation.....	4-5
4.5	Feed Operation.....	4-7
4.6	Cutting The Log.....	4-9
4.7	Edging.....	4-11
4.8	Blade Height Scale.....	4-12
4.9	Water Lube Operation.....	4-15
4.10	Preparing The Sawmill For Towing.....	4-17
SECTION 5	MAINTENANCE	5-1
5.1	Wear Life.....	5-1
5.2	Blade Guides.....	5-2
5.3	Sawdust Removal.....	5-4
5.4	Carriage Track, Wiper & Scrapers.....	5-5
5.5	Vertical Mast Rails.....	5-7
5.6	Miscellaneous.....	5-8
5.7	Blade Tensioner.....	5-9
5.8	Blade Wheel Belts.....	5-11
5.9	Brake Strap Adjustment.....	5-12
5.10	Drive Belt Adjustment.....	5-14
5.11	Drive Bearing.....	5-18
5.12	Up/Down System.....	5-20
5.13	Feed Rope.....	5-22

Table of Contents

Section-Page

5.14	Charging The Battery (G20/G15-E Only).....	5-23
	MAINTENANCE LOG	5-25
SECTION 6	TROUBLESHOOTING GUIDE	6-1
6.1	Sawing Problems.....	6-1
6.2	Engine/Motor and Drive Pulleys Alignment.....	6-3
SECTION 7	SAWMILL ALIGNMENT	7-1
7.1	Routine Alignment Procedure.....	7-1
	<i>Blade Installation.....</i>	<i>7-1</i>
	<i>Saw Head Tilt.....</i>	<i>7-2</i>
	<i>Blade Guide Arm Alignment.....</i>	<i>7-4</i>
	<i>Blade Guide Vertical Tilt Alignment.....</i>	<i>7-9</i>
	<i>Blade Guide Horizontal Tilt Adjustment.....</i>	<i>7-11</i>
	<i>Blade Guide Flange Spacing.....</i>	<i>7-13</i>
	<i>Side Support Alignment.....</i>	<i>7-14</i>
	<i>Blade Height Scale Adjustment.....</i>	<i>7-16</i>
7.2	Complete Alignment Procedure.....	7-17
	<i>Frame Setup.....</i>	<i>7-17</i>
	<i>Blade Installation.....</i>	<i>7-18</i>
	<i>Saw Head Slide Pad Adjustment.....</i>	<i>7-19</i>
	<i>Blade Wheel Alignment.....</i>	<i>7-21</i>
	<i>Track Roller Adjustment.....</i>	<i>7-27</i>
	<i>Bed Rail Adjustment.....</i>	<i>7-31</i>
	<i>Blade Guide Installation.....</i>	<i>7-34</i>
	<i>Blade Guide Arm Alignment.....</i>	<i>7-35</i>
	<i>Blade Guide Deflection.....</i>	<i>7-40</i>
	<i>Blade Guide Vertical Tilt Alignment.....</i>	<i>7-41</i>
	<i>Blade Guide Horizontal Tilt Adjustment.....</i>	<i>7-43</i>
	<i>Blade Guide Flange Spacing.....</i>	<i>7-45</i>
	<i>Side Support Alignment.....</i>	<i>7-46</i>
	<i>Clamp Stop/Stop Bolt Adjustment.....</i>	<i>7-48</i>
	<i>Saw Head Tilt.....</i>	<i>7-49</i>
	<i>Blade Height Scale Adjustment.....</i>	<i>7-51</i>
	INDEX	I

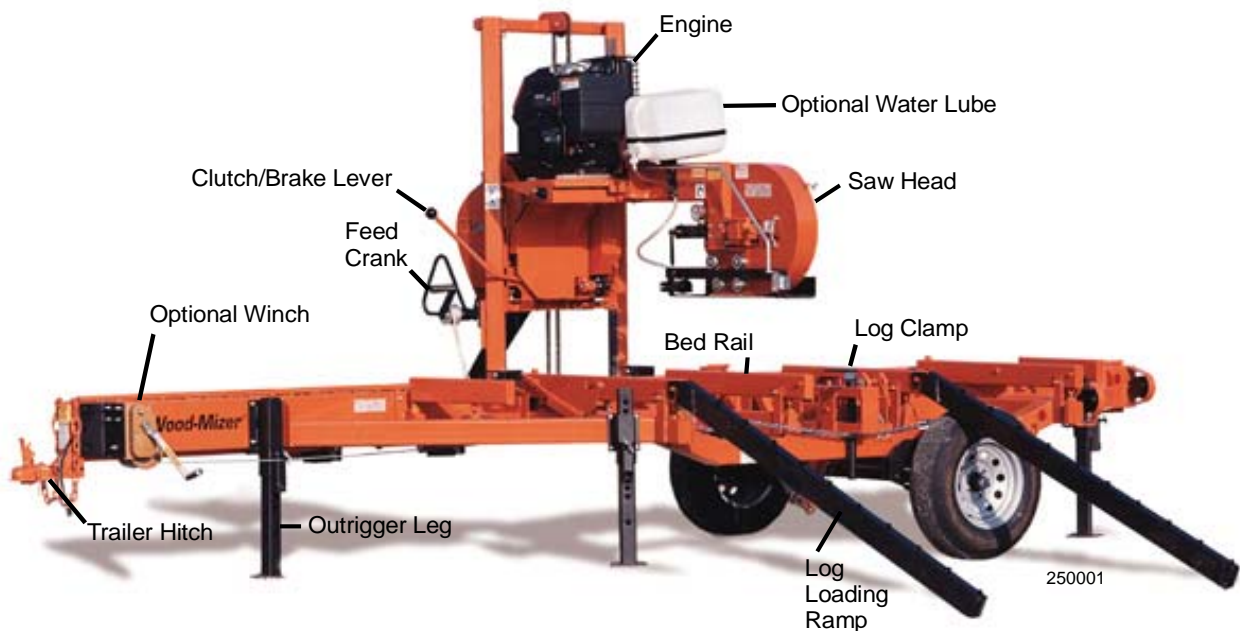
SECTION 1 INTRODUCTION

1.1 About This Manual

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

The information and instructions given in this manual do not amend or extend the limited warranties for the equipment given at the time of purchase.

For general information regarding Wood-Mizer and our “Forest to Final Form” products, please refer to the All Products Catalog in your support package.



MILL COMPONENTS

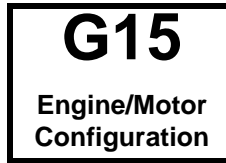
*Wood-Mizer® is a registered trademark of Wood-Mizer Products, Inc.
Sawmill U.S. Patent Nos.: 4,878,411

1.2 Customer and Sawmill Identification

Each Wood-Mizer sawmill has a model number and a 17-digit Vehicle Identification Number (VIN). In addition, when you pick up your mill, you will receive a customer number. These three numbers will help expedite our service to you. Please locate them now and write them below so you have quick, easy access to them. See the following figures for model number and V.I.N. descriptions and locations.

(To be filled in by purchaser)

Mill Model _____
 Mill VIN _____
 Customer No. _____



MODEL NUMBER DESCRIPTION

See below for a description of the V.I.N.

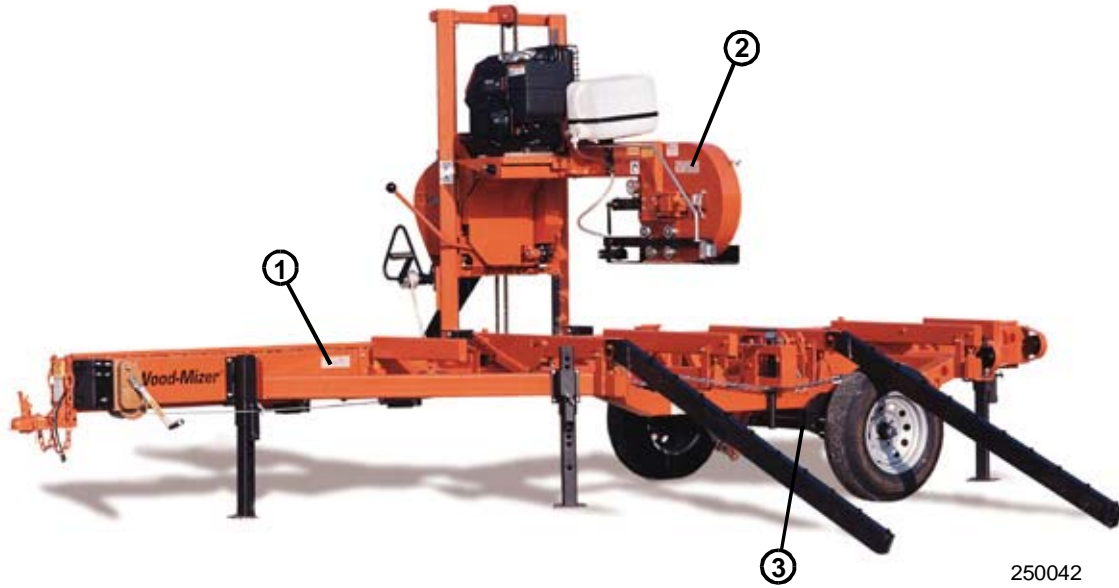
Company Identification Number 456=Wood-Mizer Indiana	Weight Class; A=Under 3,000 lbs B=3,001-4,000 lbs C=4,001-5,000 lbs D=5,001-6,000 lbs	Product No.; 2=LT20/25/27, 3=LT30/40, 4=LT30HD/40HD, 5=LT30/40 Super, 6=LT30HD/40HD Super, 7=LT60/70/80	Length of the Trailer; 20=20 Ft., 24=24', 35=35'	Number of axles on the trailer	Check Digit Add all the numbers and divide by 11	Year of Manufacture; X=1999, Y=2000, 1=2001, 2=2002, 3=2003, etc...	State of Manufacture N=Indiana, P=Poland	Month of Manufacture A=January, B=February, C=March, etc...	Revision Level	Sequence Number Ranging from 000-999	End of 17-Digit VIN	Revision Level (Repeated)	Two-Digit Minor Revision Level
456	A	5	24	1	X	S	N	A	F9	017		F9	.01

V.I.N. DESCRIPTION.

1 Introduction

Customer and Sawmill Identification

The model number and V.I.N. can be found in the following locations.



MODEL NUMBER AND V.I.N. LOCATIONS.

1.3 Getting Service

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

General Contact Information

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

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

Office Hours: All times are Eastern Standard Time.

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

Please have your vehicle identification number and your customer number ready when you call.

Wood-Mizer will accept these methods of payment:

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

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

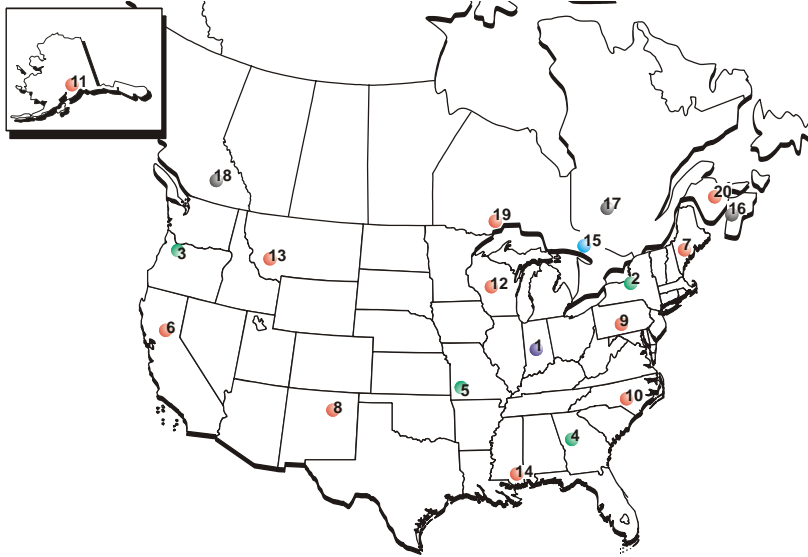
If your sawmill was purchased outside the United States or Canada, contact the distributor for service.

1

Introduction

Branches & Authorized Sales Centers

Branches & Authorized Sales Centers



UNITED STATES

1 World Headquarters
 8180 W. 10th Street
 Indianapolis, IN 46214-2400
 Phone (317) 271-1542
 Fax (317) 273-1011

Wood-Mizer Branches

2 Wood-Mizer Northeast
 8604 State Route 104
 Hannibal, NY 13074
 Phone (315) 564-5722
 Fax (315) 564-7160

3 Wood-Mizer Portland
 24435 N.E. Sandy Blvd.
 Wood Village, OR 97060
 Phone (503) 661-1939
 Fax (503) 667-2961

4 Wood-Mizer South
 74 Pine Road
 Newnan, GA 30263-5141
 Phone (770) 251-4894
 Fax (770) 251-4896

Authorized Sales Centers*

6 California
 6980 Camp Far West Road
 Sheridan, CA 95681
 Phone (530) 633-4316
 Fax (530) 533-2818
 E-mail fwfp@psyber.com

7 Maine
 541 Borough Road
 Chesterville, ME 04938
 Phone (207) 645-2072
 Fax (207) 645-3786
 E-mail woodmzer@megalink.net

8 New Mexico
 425 Bibb Industrial Drive
 Las Vegas, NM 87701
 Phone (888) 545-9663
 Fax (505) 454-6008
 E-mail djold@earthlink.net

CANADA

15 Canadian Headquarters
 217 Salem Road
 Manilla, ON KOM 2J0
 Phone (705) 357-3373
 Fax (705) 357-3443

Wood-Mizer Canada Branches

16 Wood-Mizer Canada East
 Box 173, 1082 #1 Hwy
 Aylesford, NS B0P 1C0
 Phone/Fax (902) 847-9369

17 Wood-Mizer Canada Quebec
 422 Rte. du Canton (Rte. 148)
 Chatham, QC J8G 1R1
 Phone (450) 562-2414
 Fax (450) 562-0314

18 Wood-Mizer Canada West
 4770 46th Avenue S.E.
 Salmon Arm, BC V1E 2W1
 Phone (250) 833-1944
 Fax (250) 833-1945

5 Wood-Mizer Missouri

9664 Lawrence 2130
N.Mt. Vernon, MO 65712
Phone (417) 466-9500
Fax (417) 471-1327

9 Pennsylvania

HCR 75 (Off Old Road 522)
Shade Gap, PA 17255
Phone (814) 259-9976
Fax (814) 259-3016
E-mail parsons@innernet.net

10 North Carolina

28002 Canton Road
Albemarle, NC 28001
Phone (704) 982-1673
Fax (704) 982-1619
E-mail carolina@woodmizer.com

11 Alaska

HCO5 9821
Palmer, AK 99645
Phone (907) 746-3030
Fax (907) 745-0508
E-mail mvmiling@mtaonline.net

12 Wisconsin

2201 Highway O
Mosinee, WI 54455
Phone (715) 693-1929
E-mail dsclass@dwave.net

13 Montana

51 Basin Creek Road
Basin, MT 59631
Phone (406) 225-4362
Fax (207) 645-3786
E-mail rockymountainwoodmizer@yahoo.com

14 Mississippi

123 Cable Bridge Road
Perkinston, MS 39573
Phone (601) 928-3022

 **Authorized Sales Centers*****19 Ontario North**

41 Rubin Drive
Murillo, ON P0T 2T0
Phone (807) 683-9243
Fax (807) 767-1123

20 East New Brunswick

161 Ave. De L'Eglise
St. Antoine, NB E4V 1M2
Phone (506) 525-1007
Fax (506) 525-2913

*Authorized Sales Centers offer limited services such as sawmill demos and training, routine service and sales of blades and common replacement parts

1.4 Specifications

Model: **LT25 Rev. E1.00+**

Dimensions:

Length: 21'-11"
 Width: 6'-6"
 Height (Ground To Mast): 7'-8"
 Height (Max Head Position): 8'-5"
 Bed Height (Ground To Bed): 30"

Weights:	G18	G15-E
Basic Unit (Wet):		
With Trailer:		
Tongue Weight:		

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1870 lbs
 Tire Size: ST215/75R14
 Weight: 322 lbs

Log Capacity:

Length: 16'-8"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G18	G15-E
Manufacturer:	Kohler	Kohler
Fuel:	Gas	Gas
Horsepower Rating:	18	15
Weight:		
Idle Speed:	1800 RPM	1800 RPM
High Throttle Speed (No Load):	3750 RPM	3750 RPM
Noise Level (@ High Throttle, No Blade) @ operator position: 20 feet away:		
Blade Speed (No Load):		
Fuel Consumption (per hour):		
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley O.D.:		4"
Drive Belt:	2BXF71	2BX71
Blade Braking:	1 Second	1 Second
Oil Capacity w/Filter:	2.1 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
 Manual Turner: 44 lbs
 Manual Toeboards: 17 lbs

Model: LT27 Rev. E1.00+

Dimensions:

Length: 26'-2"
 Width: 6'-6"
 Height (Ground To Mast): 7'-8"
 Height (Max Head Position): 8'-3"
 Bed Height (Ground To Bed): 30"

Weights:	G18	G15-E
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Basic Unit (Wet):
 With Trailer:
 Tongue Weight:

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1870 lbs
 Tire Size: ST215/75R14
 Weight: 322 lbs

Log Capacity:

Length: 21'-0"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G18	G15-E
----------------	------------	--------------

	Manufacturer: Kohler	Kohler
	Fuel: Gas	Gas
	Horsepower Rating: 18	15
	Weight:	
	Idle Speed: 1800 RPM	1800 RPM
	High Throttle Speed (No Load): 3750 RPM	3750 RPM
	Noise Level (@ High Throttle, No Blade) @ operator position: 20 feet away:	
	Blade Speed (No Load):	
	Fuel Consumption (per hour):	
	Cooling System: Air	Air
	Drive Shaft O.D.: 1"	1"
	Drive Pulley:	4"
	Drive Belt: 2BXF71	2BX71
	Blade Braking: 1 Second	1 Second
	Oil Capacity w/Filter: 2.1 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
 Manual Turner: 44 lbs
 Manual Toeboards: 17 lbs
 Manual Winch: 33 lbs

1 Introduction

Specifications

Model: **LT25 Rev. D5.00-D9.00**

Dimensions:

Length: 21'-11"
 Width: 6'-6"
 Height (Ground To Mast): 7'-8"
 Height (Max Head Position): 8'-5"
 Bed Height (Ground To Bed): 30"

Weights:	G20	G15-E
Basic Unit (Wet):	2098 lbs	
With Trailer:	2420 lbs	
Tongue Weight:	114 lbs	

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1870 lbs
 Tire Size: ST215/75R14
 Weight: 322 lbs

Log Capacity:

Length: 16'-8"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G20	G15-E
Manufacturer:	Kohler	Kohler
Fuel:	Gas	Gas
Horsepower Rating:	20	15
Weight:	162	
Idle Speed:	1800 RPM	1800 RPM
High Throttle Speed (No Load):	3750 RPM	3750 RPM
Noise Level (@ High Throttle, No Blade)		
@ operator position:	98 dBA	
20 feet away:	82 dBA	
Blade Speed (No Load):	5520 sfpm	
Fuel Consumption (per hour):	0.75	
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley O.D.:	3.75"	4"
Drive Belt:	2BX72	2BX71
Blade Braking:	1 Second	1 Second
Oil Capacity w/Filter:	2.1 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced)

Model: LT27 Rev. D5.00-D9.00

Dimensions:

Length: 26'-2"
 Width: 6'-6"
 Height (Ground To Mast): 7'-8"
 Height (Max Head Position): 8'-3"
 Bed Height (Ground To Bed): 30"

Weights:	G20	G15-E
Basic Unit (Wet):	2318 lbs	
With Trailer:	2420 lbs	
Tongue Weight:		

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1870 lbs
 Tire Size: ST215/75R14
 Weight: 322 lbs

Log Capacity:

Length: 21'-0"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G20	G15-E
Manufacturer:	Kohler	Kohler
Fuel:	Gas	Gas
Horsepower Rating:	20	15
Weight:	162	0
Idle Speed:	1800 RPM	1800 RPM
High Throttle Speed (No Load):	3750 RPM	3750 RPM
Noise Level (@ High Throttle, No Blade)	0	0
@ operator position:	98 dBA	0
20 feet away:	82 dBA	0
Blade Speed (No Load):	5520 sfpm	0
Fuel Consumption (per hour):	0.75	0
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley:	3.75"	4"
Drive Belt:	2BX72	2BX71
Blade Braking:	1 Second	1 Second
Oil Capacity w/Filter:	2.1 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced)

1**Introduction***Specifications*

Model: LT25 Rev. C6.00-D4.01

Dimensions:

Length: 21'-11"
Width: 6'-6"
Height (Ground To Mast): 7'-8"
Height (Max Head Position): 8'-3"
Bed Height (Ground To Bed): 30"

Weights:

Basic Unit (Wet): 2051 lbs
With Trailer: 2373 lbs
Tongue Weight: 114 lbs

Trailer:

Axle Capacity: 3500 lbs
Tire Capacity: 1870 lbs
Tire Size: ST215/75R14
Weight: 322 lbs

Log Capacity:

Length: 16'-8"
Diameter: 32"
Weight: 4400 lbs
Max Clamp Width (from stop block): 33"
Max Throat Width (guide to guide): 28"
Max Cant Width (outer guide to stop block): 25"

Engine:**G15**

Manufacturer: Kohler
Fuel: Gas
Horsepower Rating: 15
Weight: 112
Idle Speed: 1800 RPM
High Throttle Speed (No Load): 3750 RPM
Noise Level (@ High Throttle, No Blade) 0
 @ operator position: 95 dBA
 20 feet away: 80 dBA
Blade Speed (No Load): 4620 sfpm
Fuel Consumption (per hour): 0
Cooling System: Air
Drive Shaft O.D.: 1"
 Drive Pulley: 2BK36H
 Drive Belt: 2BX72
Blade Braking: 1 Second
Oil Capacity w/Filter: 2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
Manual Turner: 44 lbs
Manual Toeboards: 17 lbs
Manual Winch: 33 lbs

Model: LT25L Rev. C6.00-D4.01

Dimensions:

Length: 26'-2"
Width: 6'-6"
Height (Ground To Mast): 7'-8"
Height (Max Head Position): 8'-3"
Bed Height (Ground To Bed): 30"

Weights:

Basic Unit (Wet): 2243 lbs
With Trailer: 2565 lbs
Tongue Weight:

Trailer:

Axle Capacity: 3500 lbs
Tire Capacity: 1870 lbs
Tire Size: ST215/75R14
Weight: 322 lbs

Log Capacity:

Length: 21'-0"
Diameter: 32"
Weight: 4400 lbs
Max Clamp Width (from stop block): 33"
Max Throat Width (guide to guide): 28"
Max Cant Width (outer guide to stop block): 25"

Engine:

G15

Manufacturer: Kohler
Fuel: Gas
Horsepower Rating: 15
Weight: 112
Idle Speed: 1800 RPM
High Throttle Speed (No Load): 3750 RPM
Noise Level (@ High Throttle, No Blade)
 @ operator position: 95 dBA
 20 feet away: 80 dBA
Blade Speed (No Load): 4620 sfpm
Fuel Consumption (per hour):
 Cooling System: Air
 Drive Shaft O.D.: 1"
 Drive Pulley: 2BK36H
 Drive Belt: 2BX72
 Blade Braking: 1 Second
 Oil Capacity w/Filter: 2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
Manual Turner: 44 lbs
Manual Toeboards: 17 lbs
Manual Winch: 33 lbs

1 Introduction

Specifications

Model: LT25 Rev. C2.00-C5.01

Dimensions:

Length: 21'-11"
 Width: 6'-6"
 Height (Ground To Mast): 7'-8"
 Height (Max Head Position): 8'-3"
 Bed Height (Ground To Bed): 30"

Weights:	G11	G15
Basic Unit (Wet):	1825 lbs	1934 lbs
With Trailer:	2125 lbs	2234 lbs
Tongue Weight:	145 lbs	154 lbs

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1760 lbs
 Tire Size: F78x14-C
 Weight: 300 lbs

Log Capacity:

Length: 16'-8"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G11	G15
Manufacturer:	Briggs	Kohler
Fuel:	Gas	Gas
Horsepower Rating:	11	15
Weight:		112
Idle Speed:	1800 RPM	1800 RPM
High Throttle Speed (No Load):	3600 RPM	3750 RPM
Noise Level (@ High Throttle, No Blade)		
@ operator position:	98 dBA	95 dBA
20 feet away:	80 dBA	80 dBA
Blade Speed (No Load):	4620 sfpm	4620 sfpm
Fuel Consumption (per hour):		
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley:	BK36	2BK36H
Drive Belt:	BX72	2BX72
Blade Braking:	1 Second	1 Second
Oil Capacity w/Filter:	2 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
 Manual Turner: 44 lbs
 Manual Toeboards: 17 lbs
 Manual Winch: 33 lbs

Model: LT25L Rev. C2.00-C5.01

Dimensions:

Length: 26'-2"
 Width: 32"
 Height (Ground To Mast): 33"
 Height (Max Head Position): 28"
 Bed Height (Ground To Bed): 25"

Weights:	G11	G15
Basic Unit (Wet):	2067 lbs	2176 lbs
With Trailer:	2367 lbs	2476 lbs
Tongue Weight:		

Trailer:

Axle Capacity: 3500 lbs
 Tire Capacity: 1760 lbs
 Tire Size: F78x14-C
 Weight: 300 lbs

Log Capacity:

Length: 21'-0"
 Diameter: 32"
 Weight: 4400 lbs
 Max Clamp Width (from stop block): 33"
 Max Throat Width (guide to guide): 28"
 Max Cant Width (outer guide to stop block): 25"

Engine:	G11	G15
Manufacturer:	Briggs	Kohler
Fuel:	Gas	Gas
Horsepower Rating:	11	15
Weight:	112	112
Idle Speed:	1800 RPM	1800 RPM
High Throttle Speed (No Load):	3600 RPM	3750 RPM
Noise Level (@ High Throttle, No Blade)		
@ operator position:	98 dBA	95 dBA
20 feet away:	80 dBA	80 dBA
Blade Speed (No Load):	4620 sfpm	4620 sfpm
Fuel Consumption (per hour):		
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley:	BK36	2BK36H
Drive Belt:	BX72	2BX72
Blade Braking:	1 Second	1 Second
Oil Capacity w/Filter:	2 qts.	2 qts.

Rates:

Hourly Production (Average range w/experienced operators/average size logs):

Options:

Single/Lap Siding Option: 143 lbs
 Manual Turner: 44 lbs
 Manual Toeboards: 17 lbs
 Manual Winch: 33 lbs

SECTION 2 SAFETY

2.1 Safety Symbols

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



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



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



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



IMPORTANT! indicates vital information.

NOTE: gives helpful information.



Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

2.2 Safety Instructions

NOTE: ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding only equipment damage appear where applicable throughout the manual.

OBSERVE SAFETY INSTRUCTIONS



IMPORTANT! Read the entire Operator's Manual before operating the sawmill. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

Only persons who have read and understood the entire operator's manual should operate the sawmill. The sawmill is not intended for use by or around children.

IMPORTANT! It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership, operation and towing of your Wood-Mizer sawmill. All Wood-Mizer mill owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using or towing the mill.



WEAR SAFETY CLOTHING



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

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



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



KEEP SAWMILL AND AREA AROUND SAWMILL CLEAN



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

HANDLE FUEL/LUBRICANTS SAFELY



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

DANGER! Never allow fuel to spill on a hot engine during fueling operations or otherwise. The hot temperature of your engine could induce a fire or explosion.



WARNING! Store gasoline away from sawdust and other flammable materials. Failure to do so may result in serious injury.



WARNING! Use ONLY water with the water lube accessory. Never use flammable fuels or liquids. If these types of liquids are necessary to clean the blade, remove it and clean with a rag. Failure to do so may result in serious injury or death.

DISPOSE OF SAWING BY-PRODUCTS PROPERLY



IMPORTANT! Always properly dispose of all sawing by-products, including sawdust and other debris, coolant, oil, fuel, oil filters and fuel filters.

USE CAUTION WHEN WORKING WITH BATTERIES

DANGER! Batteries expel explosive gases. Keep sparks, flames, burning cigarettes, or other ignition sources away at all times. Always wear safety goggles and a face shield when working near batteries. Failure to do so will cause serious injury. ¹



WARNING! Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and reproductive harm. Wash hands after handling.



WARNING! Charge the battery in a well ventilated area. Do not attempt to charge a frozen battery.

Use extreme care to avoid spilling or splashing electrolyte (which is dilute sulfuric acid) as it can destroy clothing and burn the skin. If electrolyte is spilled or splashed on clothing or the body, it should be neutralized immediately and then rinsed with clean water. A solution of baking soda, or household ammonia, and water may be used as a neutralizer.

Electrolyte splashed into the eyes is extremely dangerous. If this should happen, force the eye open and flood it with cool, clean water for approximately fifteen minutes. A doctor should be called immediately when the accident occurs and “on-the-spot” medical attention given if possible. If a doctor cannot come to the scene of the accident immediately, follow his instructions concerning actions to take. Do not add eye drops or other medication unless advised to do so by the doctor. Do not place a battery or acid within the reach of children. If acid (electrolyte) is taken internally drink large quantities of water or milk. Follow with milk of magnesia, beaten egg or vegetable oil. Call a physician immediately.

If electrolyte is spilled or splashed on any surface of the machine, it should be neutralized and rinsed with clean water.



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

CAUTION! Be sure the battery is fully charged before transporting the sawmill. If the battery is not fully charged, excessive vibration could reduce the overall service life of the battery.

¹ Battery Council International, copyright 1987

CAUTIONS FOR SAWMILL SETUP



WARNING! Do not set up the mill on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the mill or dig out areas for the outrigger legs to keep mill level. Setting up the mill on an incline could cause it to tip over, resulting in serious personal injury.

WARNING! Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

WARNING! Put front outrigger down before moving saw head from the rest position. Failure to do so may result in serious injury.

WARNING! Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

WARNING! The adjustable outriggers supplied with portable sawmills are not intended for setup on concrete or other hard surfaces. Long-term use of the adjustable outriggers on hard surfaces may cause the outriggers to fail, causing the sawmill to drop. This could result in possible serious injury or death.

If setting the sawmill up on concrete or other hard surface, replace the adjustable outrigger legs with stationary legs.

WARNING! Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

CHECK SAWMILL BEFORE OPERATION

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

Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

**KEEP PERSONS AWAY**

DANGER! Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.



DANGER! Keep all persons out of the path of moving equipment and logs when operating sawmill or loading and turning logs. Failure to do so will result in serious injury.

DANGER! Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine or motor. Failure to do so will result in serious injury.

KEEP HANDS AWAY



DANGER! Always disengage the blade and shut off the sawmill engine before changing the blade. Failure to do so will result in serious injury.

DANGER! Engine components can become very hot during operation. Avoid contact with any part of a hot engine. The exhaust components of your engine are especially hot during and following operation. Contact with hot engine components can cause serious burns. Therefore, never touch or perform service functions on a hot engine. Allow the engine to cool sufficiently before beginning any service function.

DANGER! Always keep hands away from moving bandsaw blade. Failure to do so will result in serious injury.

DANGER! Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.



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

WARNING! Always disengage the clutch/brake mechanism whenever the sawmill is not cutting. Failure to do so may result in serious injury.

WARNING! Do not for any reason adjust the engine drive belts or belt support bracket with the engine running. Doing so may result in serious injury.

WARNING! Always keep clear of exiting sawdust. Keep hands, feet and any other objects away from the sawdust chute when operating sawmill. Failure to do so may result in serious injury.

CAUTIONS FOR GAS OR DIESEL ENGINE OPERATION

DANGER! Operate your engine/machine only in well ventilated areas. The exhaust gases of your engine can cause nausea, delirium and potentially death unless adequate ventilation is present.

DANGER! Never operate an engine with a fuel or oil leak. The leaking fuel or oil could potentially come in contact with hot surfaces and ignite into flames.

WARNING! Do not operate engine without proper and operational spark arrester/muffler. Sparks emitted from the engine exhaust could ignite surrounding materials, causing serious injury or death.

USE PROPER PROCEDURE WHEN CONDUCTING ELECTRICAL SAFETY CHECKS AND MAINTENANCE



DANGER! Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.



DANGER! ARC FLASH AND SHOCK HAZARD! Hazardous voltage inside the electric sawmill disconnect box, starter box, and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during mill operation. Wear appropriate Personal Protection Equipment.



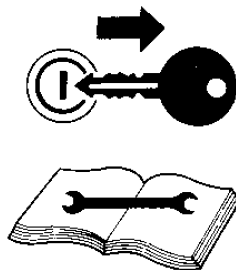
WARNING! Consider all electrical circuits energized and dangerous.

WARNING! Never assume or take the word of another person that the power is off; check it out and lock it out.

WARNING! Do not wear rings, watches, or other jewelry while working around an open electrical circuit.

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

WARNING! Remove the blade before performing any service to the engine or sawmill. Failure to do so may result in serious injury.



DANGER! Lockout procedures must be used during:

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

Maintenance hazards include:

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

Failure to lockout may result in:

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

To control maintenance dangers:

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

Never rely on machine stop control for maintenance safety (emergency stops, on/off buttons, interlocks).

Do not reach into moving blades or feed systems. Allow all coasting parts to come to a complete stop.

Electrical power supply and air supply must both be locked out.

Where established lockout procedures cannot be used (electrical troubleshooting or mechanical dynamic troubleshooting), alternative effective protective techniques shall be employed which may require special skills and planning.

Always follow safe operations practices in the workplace.

SAWMILL LOCKOUT PROCEDURE

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

Purpose:

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

Responsibility:

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

Preparation For Lockout:

Sawmill must be locked out both electrically and pneumatically (lockout air valve).

Sequence of Lockout Procedure:

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

Restoring Equipment to Service

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

Procedure Involving More Than One Person

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

Rules for Using Lockout Procedure

The Sawmill shall be locked out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch or valve bearing a lock.

Owner's Responsibility

The procedures listed in this manual may not include all ANSI, OSHA, or locally required safety procedures. It is the owner/operator's responsibility and not Wood-Mizer Products to ensure all operators are properly trained and informed of all safety protocols. Owner/Operators are responsible for following all safety procedures when operating and performing maintenance to the Sawmill.

KEEP SAFETY LABELS IN GOOD CONDITION



IMPORTANT! Always be sure that all safety decals are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the equipment. Contact your local distributor, or call your Customer Service Representative to order more decals.



IMPORTANT! If replacing a component which has a safety decal affixed to it, make sure the new component also has the safety decal affixed.

USE CAUTION WHEN WORKING WITH HEAVY LOGS



WARNING! Always make sure log is clamped securely before sawing. Failure to do so may result in serious injury or death.

UP/DOWN SYSTEM SAFETY



WARNING! Always secure the saw head with a 5/16" chain with at least 1900 lbs. working load capacity before adjusting the up/down chain. The saw head may fall, causing severe injury or death.

WARNING! Always secure the saw head with a 5/16" chain with at least 1900 lbs. working load capacity before adjusting the mast pads. The saw head may fall, causing severe injury or death.

GENERAL TRAILER SAFETY



DANGER! Make sure your hitch has adequate safety chain hook-ups. Do not use eyebolts for safety chain hook-up. Safety chains should be hooked to bumper of vehicle so that each chain would pull the trailer equally in the event the hitch became disengaged. Failure to do so may result in serious personal injury and/or severe machine damage.

DANGER! Be sure that the hitch and safety chains are secure before towing the sawmill. Failure to do so may result in serious personal injury and/or severe machine damage.

DANGER! Make sure all light connections have been made and are working properly before towing the sawmill. Failure to do so may result in serious personal injury and/or severe machine damage.

SECTION 3 SAWMILL SETUP

3.1 Stationary Sawmill Setup

Prepare a firm, level area where the sawmill can be anchored. There should be enough room around the sawmill for operators, sawdust removal, log loading and board removal. A cement pad with 5/8" diameter anchor bolts is recommended. The cement pad should be rated to support 6350 lbs./sq.ft. at each sawmill foot position.

[See Form #847](#) for stationary sawmill foot anchor locations.

NOTE: Make sure the unit is level before securing. It IS possible to twist the mill frame by jacking one foot higher than the others.



WARNING! Securely fasten the feet of a stationary sawmill to the floor before operating the sawmill. Failure to do so may result in serious injury or death.

3. Unhook the carriage safety chain, located at the bottom of the vertical mast.
4. Use the up/down crank to raise the cutting head from the carriage rest pin. Swing the rest pin down below bed level.
5. Use the feed handle to move the cutting head toward the front end of the mill.
6. Raise the side supports to prevent a log from falling off the side of the mill when loaded.

3 Sawmill Setup
Stationary Sawmill Setup

See Figure 3-1.

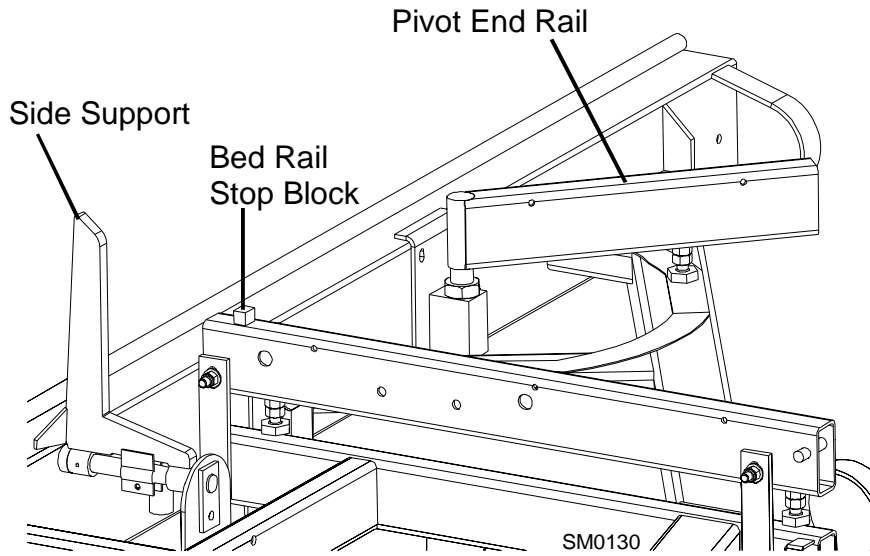


FIG. 3-1

3.2 Portable Sawmill Setup



WARNING! Do not set up the mill on ground with more than a 10 degree incline. If setup on an incline is necessary, put blocks under one side of the mill or dig out areas for outrigger legs to keep mill level. Setting up the mill on an incline could cause it to tip over, resulting in serious personal injury.

WARNING! Chock the trailer wheels to prevent movement before unhitching it from the towing vehicle. Failure to do so may result in serious injury or death.

WARNING! Always make sure the trailer is supporting the sawmill frame when operating a sawmill with adjustable outriggers. Failure to do so may result in serious injury or death. The adjustable outriggers are intended to support the saw frame with assistance from the trailer.

WARNING! The adjustable outriggers supplied with portable sawmills are not intended for setup on concrete or other hard surfaces. Long-term use of the adjustable outriggers on hard surfaces may cause the outriggers to fail, causing the sawmill to drop. This could result in possible serious injury or death.

If setting the sawmill up on concrete or other hard surface, replace the adjustable outrigger legs with stationary legs.

3

Sawmill Setup

Portable Sawmill Setup

1. Unhitch the mill from the vehicle.
2. Lower and set the front three outriggers. To lower, use the provided jack handle to lift the weight from the locking pin. If necessary, rotate the locking pin counterclockwise so that the inner roll pin is free from the outrigger channel notch, then pull the locking pin out to release the outrigger. Lower the outrigger as necessary. Push the locking pin back in and turn clockwise until the inner roll pin is behind the outrigger channel notch to “lock” the outrigger in place.



WARNING! Put front outrigger down before moving cutting head from the rest position. Failure to do so may result in serious injury.

NOTE: Mills prior to LT25 C4.02 do not have a notch in the outrigger channel.

See Figure 3-2.

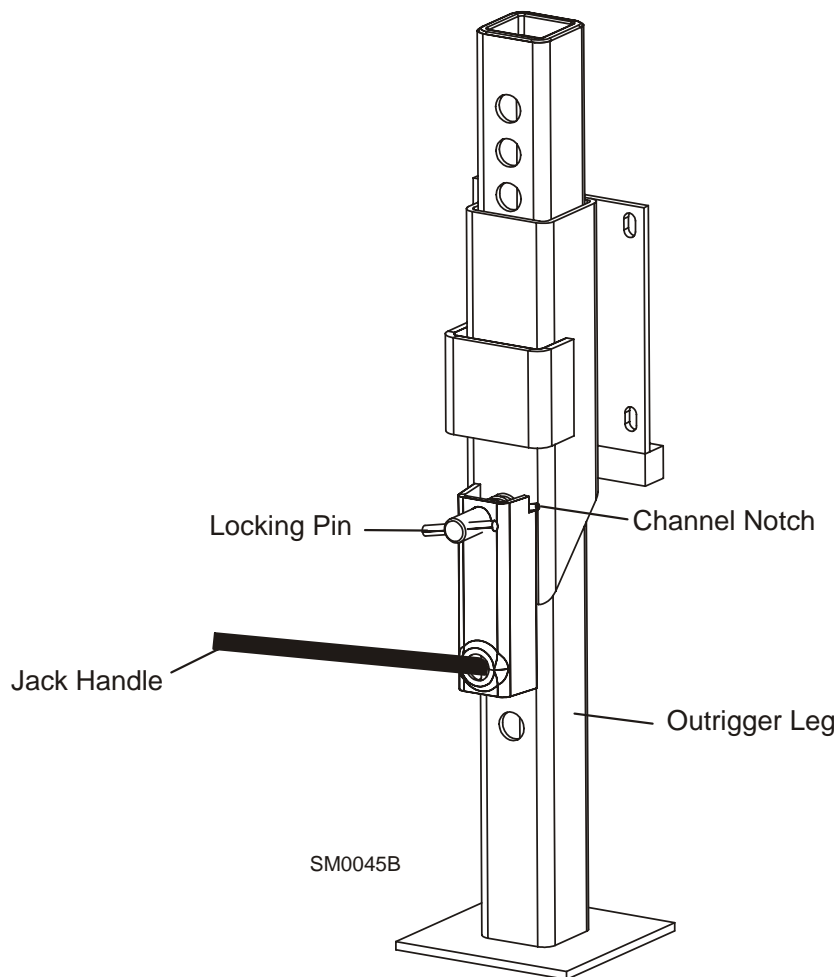


FIG. 3-2. OUTRIGGER ADJUSTMENT.

See Figure 3-3. For Fine Adjust Outriggers (FAOs), lower the outrigger as close to the ground as possible, then secure in place with the locking pin. Adjust the outrigger base so that it contacts the ground. To adjust, use the provided wrench to turn the height adjustment nut. Turn clockwise to lower. Turn counterclockwise to raise. Maximum adjustment available is 1 1/2" (3.8 cm).

CAUTION! Do not adjust the FAO outrigger base height while there is weight on the FAO. Damage to the FAO may result.

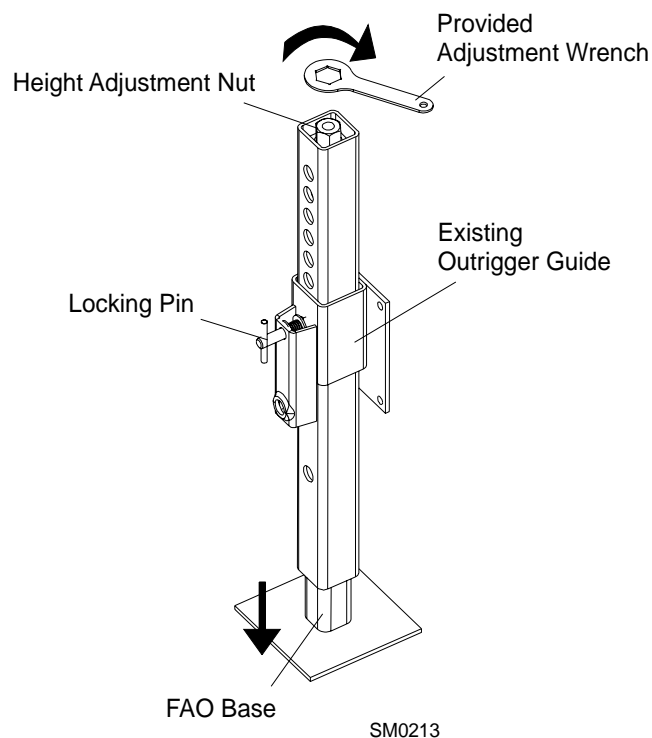


FIG. 3-3. BASE HEIGHT ADJUSTMENT (FOR FINE ADJUST OUTRIGGER ONLY).

1. Unhook the carriage safety chain, located at the bottom of the vertical mast.
2. Use the up/down crank to raise the cutting head from the carriage rest pin. Swing the rest pin down below bed level.

3

Sawmill Setup

Portable Sawmill Setup

3. Remove the fenders by lifting them out of the slots.



CAUTION! To prevent fender damage, remove fenders before operating sawmill or loading logs.

4. Use the feed handle to move the cutting head toward the front end of the mill.
5. Lower and set the remaining rear outriggers. Level the sawmill by adjusting the outriggers to raise or lower each end of the sawmill. Adjust all outriggers evenly to avoid twisting the mill frame by jacking one outrigger higher than the others.

For FAO(s), fine tune the outrigger base height as necessary. Move the cutting head to the opposite end of the mill from the outrigger. Raise the entire outrigger (to remove the sawmill weight from it) and adjust the outrigger base as necessary. Lower the entire outrigger and use the locking pin to secure in position.



CAUTION! Do not adjust the FAO outrigger base height while there is weight on the FAO. Damage to the FAO may result.

6. Raise the two side supports to prevent the log from falling off the side of the mill when loaded.

See Figure 3-4.

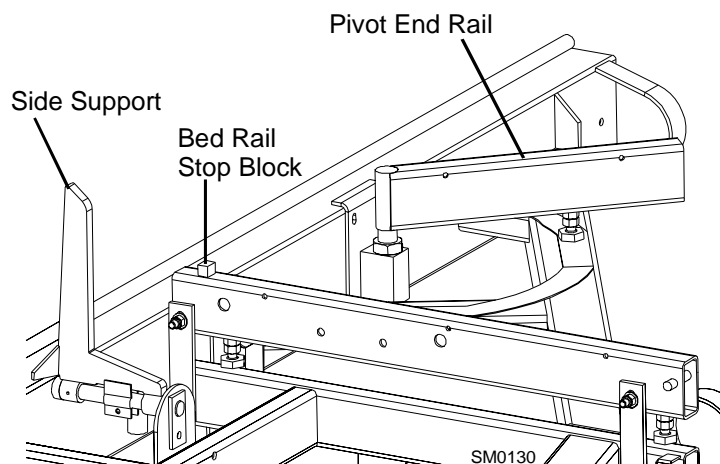


FIG. 3-4

3.3 Replacing The Blade



DANGER! Always disengage the blade and shut off the sawmill engine before changing the blade. Failure to do so will result in serious injury.



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

Adjust the blade guide arm all the way open.

Remove the two blade housing covers that cover the blade wheels. Lower the hinged middle blade housing cover. Turn the blade tension handle to release the blade tension until the wheel is pulled in and the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

When installing a blade, make sure the teeth are pointing the correct direction. The teeth should be pointing toward the operator side of the mill when you are looking at the blade below the blade guides. Install the blade so it is lying around the wheels.

Position 1 1/4" wide blades on the wheels so the gullet is 1/8" (3.0 mm) out from the edge of the wheel. Position 1 1/2" wide blades on the wheels so the gullet is 3/16" (4.5 mm) out from the edge of the wheel.

Close the middle blade housing cover.

Next, turn the tension handle until the blade is tensioned correctly.

3.4 Tensioning The Blade

See **Figure 3-5**. Tension the blade by turning the hydraulic tensioning handle clockwise until the tension gauge indicates the recommended tension.

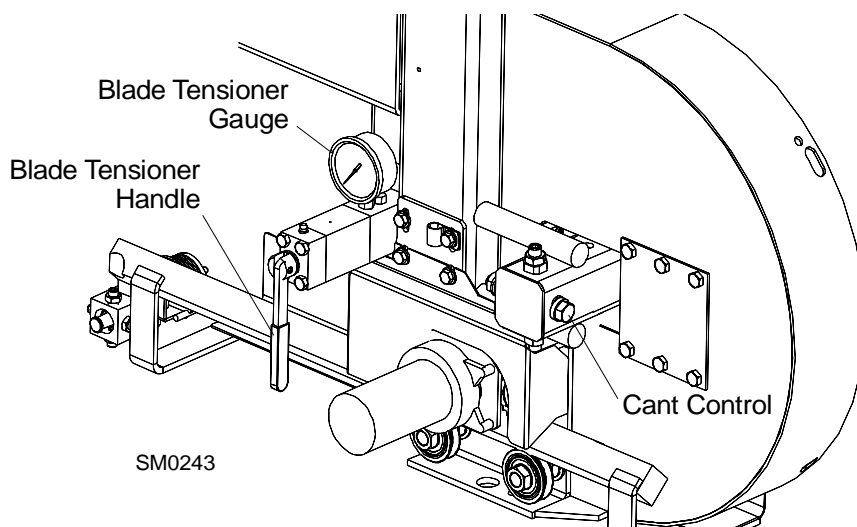


FIG. 3-5

See **Table 3-1**. The recommended tension for different blades is shown below.

Blade Type	Acceptable Range	Ideal Tension
.035" x 7/8" x 1 1/4"	1800 - 2100 psi	2000 psi
.042" x 7/8" x 1 1/4"	2100 - 2400 psi	2300 psi
.045" x 7/8" x 1 1/2"	2100 - 2400 psi	2300 psi

TABLE 3-1

The tension gauge should be checked occasionally when adjusting the cant control or while cutting. Ambient temperature changes will cause tension to change. Adjust the tension handle as necessary to maintain the recommended tension level.



CAUTION! Changes in temperature could cause increased pressure in the blade tensioner and loss of fluid from the gauge. Release the blade tension when the mill is not in use to avoid damage to the tensioner.

3.5 Tracking The Blade

1. Make sure the middle blade housing cover is closed and all persons are clear of the open side of the saw head.
2. Start the engine.
3. Engage the blade, rotating the blade until the blade positions itself on the wheels.



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

4. Disengage the blade. Turn off the engine, remove the key and check the position of the blade on the blade wheels.

See Figure 3-6. Position 1 1/4" wide blades so the gullet is 1/8" (3.0 mm) out from the edge of the blade wheel ($\pm 1/16$ " [1.5 mm]). Position 1 1/2" blades so the gullet is 3/16" (4.5 mm) out from the edge of the blade wheel ($\pm 1/16$ " [1.5 mm]).

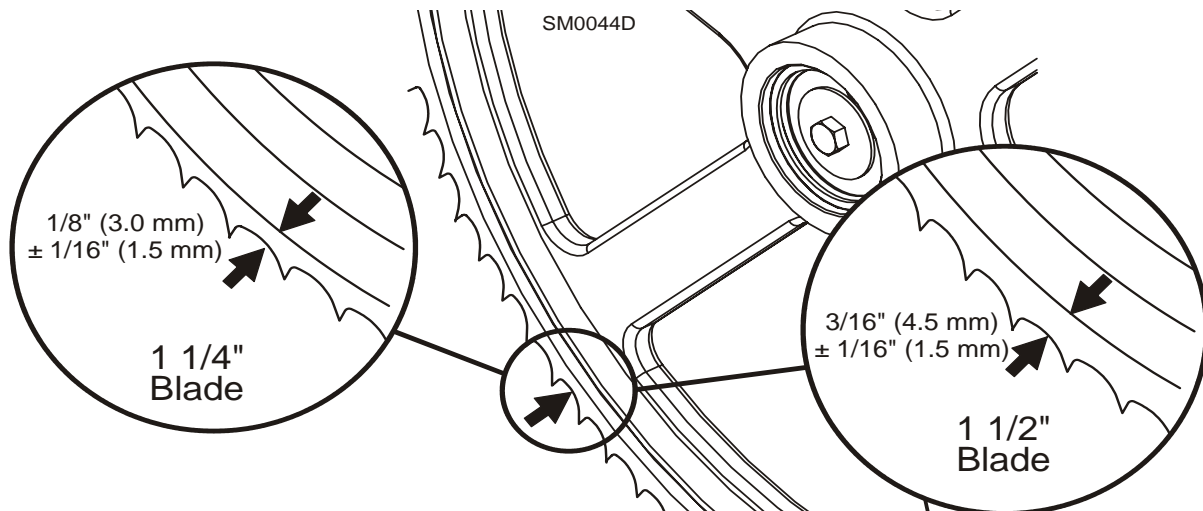


FIG. 3-6

5. To adjust where the blade travels on the blade wheels, use the cant control shown in **Figure 3-5**.

NOTE: On LT25 models prior to revision C7.00, the cant control handle is secured with a spring to prevent it from interfering with the blade guide arm. Remove the handle from behind the spring and return after adjustment is complete.

If the blade is too far out, back the blade onto the wheel by turning the cant control coun-

3

Sawmill Setup

Tracking The Blade

terclockwise. If the blade is too far in, turn the cant control clockwise until the gullet of the blade is the correct distance from the front edge of the wheel.

6. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.
7. Close the middle blade housing cover and replace the large blade housing covers.



DANGER! Make sure all guards and covers are in place and secured before operating or towing the sawmill. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.



IMPORTANT! After aligning the blade on the wheels, always double-check the blade guide spacing and location. ([See Section 7](#) for more information.)

3.6 Starting The Engine

See the appropriate manual supplied with your specific engine/motor configuration for starting and operating instructions.



DANGER! Make sure all guards and covers are in place and secured before operating or towing the sawmill. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

DANGER! Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine or motor. Failure to do so will result in serious injury.



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

SECTION 4 SAWMILL OPERATION

4.1 Loading, Turning And Clamping Logs

To Load Logs

1. Move the saw carriage to the front end of the frame.



CAUTION! Before loading a log, be sure the cutting head is moved far enough forward so the log does not hit it. Failure to do so may result in machine damage.



CAUTION! Be sure the log clamp, pivot rails, turning arm and toe boards are adjusted out of the path of the log before loading a log onto the bed. Failure to do so may result in machine damage or cause misalignment.

2. Raise the side supports on the sawmill bed to prevent the log from falling off the side of the bed.
3. Place the loading ramps on the two bed rails that will support the length of the log. **NOTE:** The loading ramps cannot be fastened securely to the bed rail located directly above the tire. Do not use this rail.
4. Position the log at the foot of the ramps.
5. Remove the winch cable from the log turner (if applicable) and route the cable over the top of the log. Wrap the cable around and underneath the log. Hook the cable to the third hole in the log clamp bracket. See *Winch Operation Manual*.



DANGER! Keep all persons out of the path of moving equipment and logs when operating sawmill or loading and turning logs. Failure to do so will result in serious injury.

6. Crank the winch to begin rolling the log up the ramps and onto the sawmill bed. Keep the log centered on the ramps as it rolls up.
7. Once the log is on the sawmill bed, place the log clamp in the clamp bracket. This will stop the log from rolling back off the side of the mill when you remove the winch cable.

NOTE: Logs also may be loaded onto the mill with a tractor or other equipment specifically designed for that purpose.

To Turn Logs

1. Use cant hooks or the optional log turner to rotate the log on the sawmill bed. See *Log Turner Manual*.
2. Spin the log against the side supports until it is turned the way you want it for the first cut.

To Clamp Logs

1. Position the log clamp in the bracket in the hole closest to the log.
2. Move the clamp down far enough so that it is below your first few cuts. Pivot the clamp so that it moves the log firmly against the side supports. Lock the clamp in position with the locking chain.

See Figure 4-1.

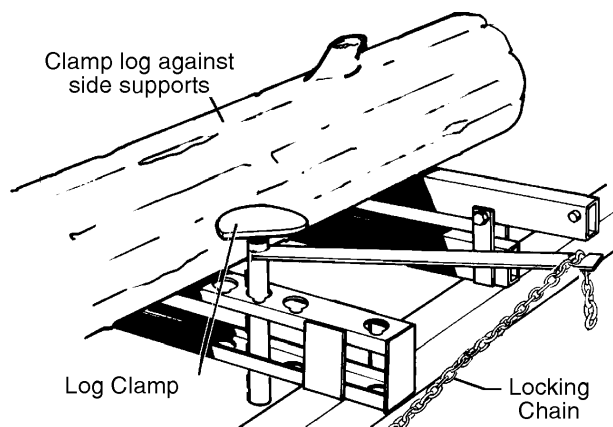


FIG. 4-1

3. Make sure the side supports are positioned low enough for the blade to pass over them. If they are not, back the clamp off slightly and push the side supports down until they are positioned below the level of your first few cuts.
4. Use the optional toe boards to level the log if desired. See the manual supplied with the manual toe boards for details concerning toe board operation.

To Level A Tapered Log

Use the optional toe boards to raise either end of a tapered log, if desired. See the Toe Board Option Manual for operating instructions.

4.2 Up/Down Operation

1. Install a blade, if needed, and check for correct blade tension. ([See Section 3.3](#)).
2. Set the cutting head to the desired height. (The blade height scale shows the height of the blade above the bed rails.)

See Figure 4-2. Use the up/down crank to raise or lower the cutting head.

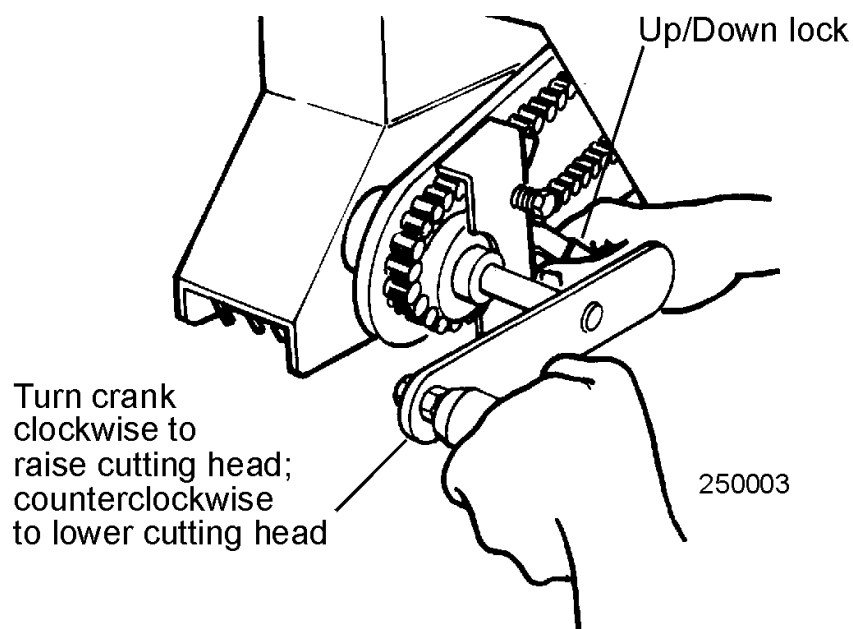



FIG. 4-2

3. To raise the cutting head, turn the up/down crank clockwise until the desired blade height is reached.
4. To lower the cutting head, lift the up/down lock. Turn the up/down crank counterclockwise as desired. Lower the lock until it seats firmly between the teeth of the up/down sprocket.

 **CAUTION!** DO NOT try to force the carriage above the 35" (88 cm) mark or below the 1" (2.54 cm) mark. Damage to the up/down system may result.

4.3 Blade Guide Arm Operation

1. Look down the length of the log to see its maximum width. The outer blade guide should be adjusted to clear the widest section of the log by less than 1" (25.4 mm).
2. Use the blade guide arm knob to adjust the outer blade guide as necessary. Pull the blade guide arm knob out away from the mill to move the arm in. Push the knob in toward the mill to move the arm out.

See Figure 4-3.

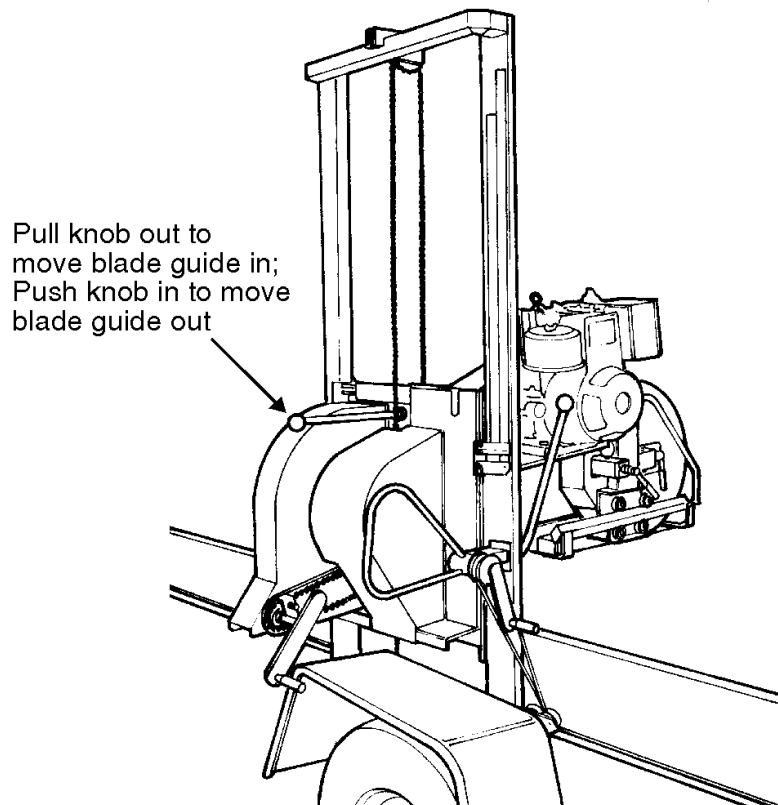



FIG. 4-3

4.4 Clutch/Brake Operation

1. Clear any loose objects from the area of the blade, motor, and drive belt.
2. Make sure the clamp and side supports are adjusted below the level of your first few cuts.
3. Start the engine as instructed in the option manual.

 **DANGER!** Keep all persons out of the path of moving equipment and logs when operating sawmill or loading and turning logs. Failure to do so will result in serious injury.

Be sure the blade housing and pulley covers are in place and secure before starting the engine or motor. Use the safety retainer pin and cable to fasten the blade housing covers shut.

See **Figure 4-4**. The clutch/brake lever is located next to the engine.

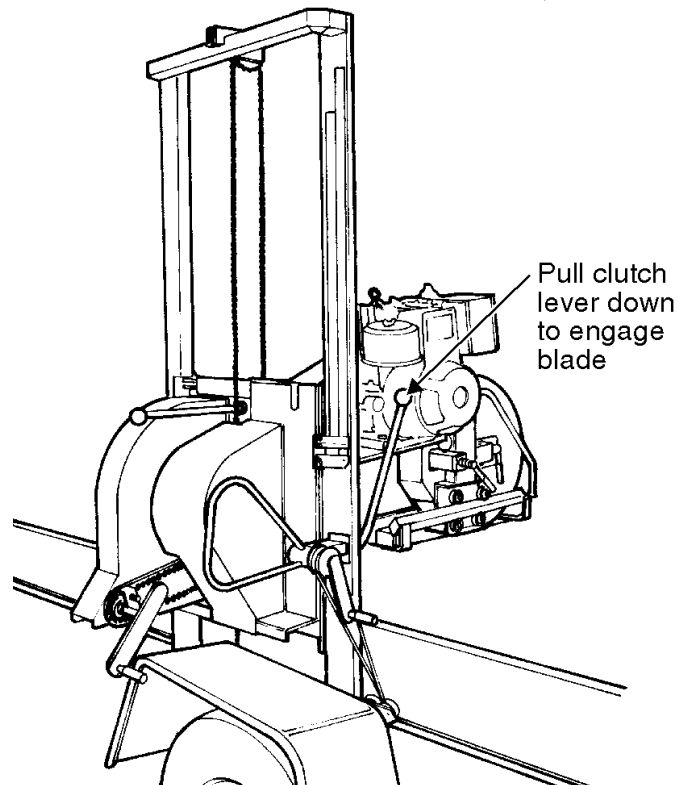


FIG. 4-4

4

Sawmill Operation

Clutch/Brake Operation

4. To engage the blade, pull the clutch/brake lever down until it locks in the down position. This engages the drive mechanism, releases the blade brake, and increases the engine speed to full throttle.
5. To disengage the blade, raise the clutch/brake lever to the up position. This disengages the drive belt, engages the blade brake, and returns the engine to idle.

4.5 Feed Operation

The feed system includes a hand crank to move the carriage forward or backward. The speed at which the carriage travels forward depends on how fast you turn the feed crank.

The height of the feed crank is adjustable. There are two sets of mounting holes, one higher and one lower. To change the height of the feed crank, unbolt the crank assembly from the carriage and reinstall to the desired set of mounting holes.

1. To move the carriage forward, rotate the feed crank clockwise.

See Figure 4-5.

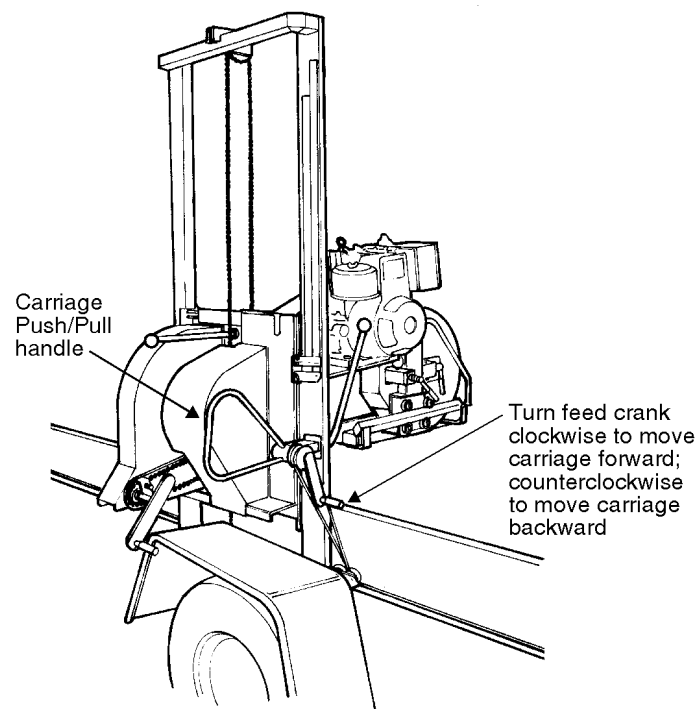


FIG. 4-5

HINT: To get a straight cut in the first part of the board, feed the blade into the log at a slow speed. This stops the blade from flexing and dipping up or down. Use a slow speed until the whole width of the blade has entered the cut. Then increase the feed rate as desired. Maximum feed rate varies with width and hardness of the wood. Over-feeding results in engine and blade wear, and also produces a wavy cut.

2. Stop the carriage at the end of the cut. Throw the clutch/brake lever up to stop the blade and drop the engine to idle. Remove the board from the top of the log. **Always disengage the blade before returning the carriage for the next cut.**



CAUTION! Be sure to stop the blade when returning the carriage. This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.

3. Make sure that the blade does not catch on the end of the log. Raise the carriage slightly to make sure the blade clears the log when returned.
4. To move the carriage backward, rotate the feed crank counterclockwise or pull the saw head back using the carriage push/pull handle.



CAUTION! Do not use the blade guide arm knob to move the carriage head forward and backward. Damage to the blade guide arm may result.

HINT: Try to stop the blade while the heel of the blade is still on the log. Then bring the carriage back without adjusting the blade up. This lets you keep the blade at the current height setting so you can make the next blade height adjustment more quickly.



DANGER! Stay clear of the area between the trailer axle and saw carriage. Failure to do so will result in serious injury.

4.6 Cutting The Log

The following steps guide you through normal operation of the Wood-Mizer sawmill.

1. Once the log is placed where you want it and clamped firmly, position the blade close to the end of the log.
2. Use the blade height scale to determine where to make your first cut ([See Section 4.8](#)). The blade height scale will help you to do this. Set the blade to the desired height with the up/down crank. Make sure that the blade will clear all side supports and the clamp. Adjust the outer blade guide to clear the widest section of the log by moving the blade guide arm knob.
3. Make sure all covers and guards are in place. Start the engine. Engage the clutch/brakelever to start the blade spinning.
4. Start the water lube if necessary to prevent sap buildup on the blade. [See Section 4.9](#).
5. Feed the blade into the log slowly ([See Section 4.5](#)). Once the blade completely enters the log, increase the feed rate as desired. Always try to cut at the fastest speed you can while keeping an accurate cut. Cutting too slowly will waste blade life and lower production!
6. As you get to the end of the log, slow down the feed rate. When the teeth exit the end of the log, disengage the clutch/brake lever. Remove the slab that you have just cut from the log.
7. Use the feed crank or the carriage push/pull handle to return the carriage to the front of the mill. Always disengage the blade before returning the carriage for the next cut.
8. Repeat until the first side of the log is cut as desired. Set aside the usable flitches (boards with bark on one or both sides). You can edge them on the mill later.

4

Sawmill Operation

Cutting The Log

9. Lower the toe boards, if they were used. Remove the clamp and turn the log 90 or 180 degrees. Make sure the flat on the log is placed flat against side supports if turned 90 degrees. Make sure it is placed on bed rails if turned 180 degrees. If the log was turned 90 degrees and you are using toe boards to compensate for taper in the log, raise the front or rear toe board again on the second side of the log until the heart is parallel with the bed.

10. Repeat the steps used to cut the first side of the log until the log is square. Cut boards from the remaining cant by adjusting the blade height for the thickness of boards that you want.

Example: Remember that the blade cuts a $1/16 - 1/8$ " (1.6-3.2 mm) wide kerf. If you want 1" (25.4 mm) thick boards, lower the carriage $1 \frac{1}{16} - 1 \frac{1}{8}$ " (27-28.6 mm) for each board.

4.7 Edging

The following steps guide you through edging boards on the Wood-Mizer sawmill.

1. Raise the side supports to 1/2 the height of the flitches, or the boards that need to be edged.
2. Stack the flitches on edge against the side supports.
3. Clamp the flitches against the side supports halfway up the flitch height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other flitches or without having to pull them from the middle of the stack).
4. Adjust the blade height to edge a few of the widest boards.
5. Loosen the clamp and turn the edged boards over to edge the other side.
6. Repeat steps 2-4.
7. Loosen the clamp and remove the boards that have good clean edges on both sides. Clamp the remaining flitches and repeat steps 2-5.

4.8 Blade Height Scale

See Figure 4-6. The blade height scale is attached to the carriage head frame. It includes:

- two blade height indicators
- an inch scale
- a quarter scale

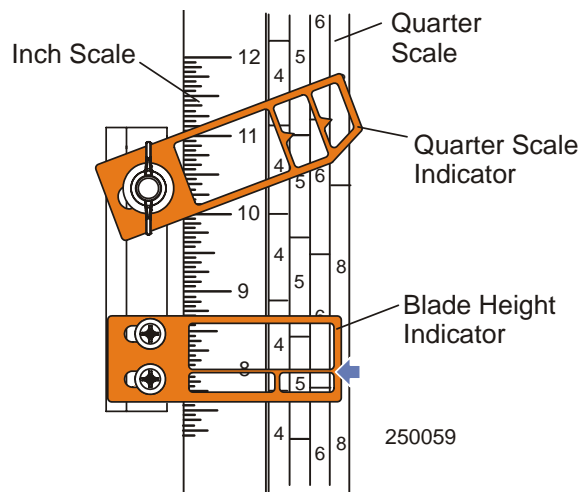


FIG. 4-6 STEEL INDICATORS

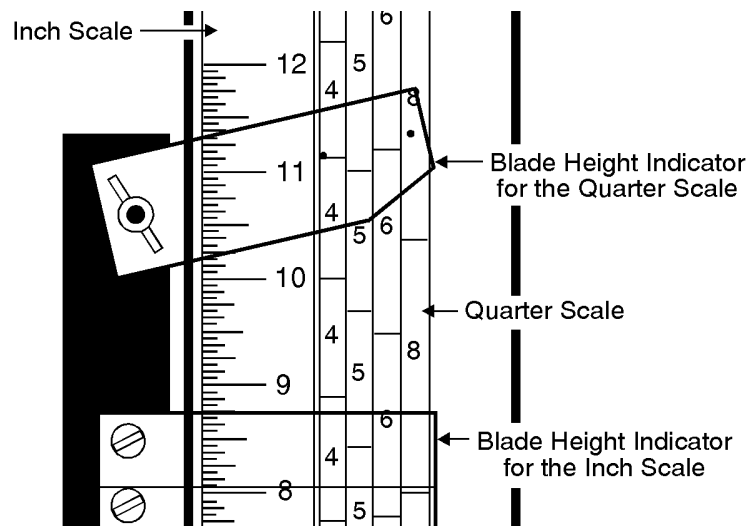


FIG. 4-6 CLEAR PLASTIC INDICATORS

The two indicators move up and down with the cutting head. The lower indicator is used to read the inch scale, and the upper indicator is used to read the quarter scale.

The Inch Scale

The horizontal line on the blade height indicator shows how many inches the bottom of the blade is above the bed of the mill. If you know the height of your blade at each cut, you can determine the thickness of lumber you are sawing.

Example: You want to cut 1" (25 mm) random width boards from a log. Position the blade for the first cut. Move the carriage to an even measurement on the inch scale. Make a trim cut. Return the carriage for the second cut and lower it 1 1/8" (29 mm) below the original measurement. (The extra 1/8" (3 mm) allows for saw kerf and shrinkage of the lumber.)

The yellow area on the scale identifies where the blade could encounter a side support or log clamp. Check that these items are below the blade level before sawing.

The Quarter Scale

See Table 4-1. The quarter scale has four sets of marks. Each set represents a specific lumber thickness. Saw kerf and shrinkage allowance are included, but actual board thickness will vary slightly depending on blade thickness and tooth set.

An optional Grade Hardwood Quarter Scale is also available. To choose which scale to use, determine what finished thickness you want to end up with. The Grade Hardwood Quarter Scale provides thicker finished boards usually required by commercial buyers. The Standard Quarter Scale allows for kerf and shrinkage of finished boards suitable for most custom applications. Always check with your customer before you saw to determine what actual finished thickness is required.

Standard Quarter Scale		Grade Hardwood Quarter Scale	
Scale	Actual Board Thickness	Scale	Actual Board Thickness
4/4	1" (25 mm)	4/4	1 1/8" (29 mm)
5/4	1 1/4" (32 mm)	5/4	1 3/8" (35 mm)
6/4	1 1/2" (38 mm)	6/4	1 5/8" (41 mm)
8/4	2" (51 mm)	8/4	2 1/8" (54 mm)

TABLE 4-1

To use the quarter scale, look at the upper blade height indicator. It has two points (red dots on clear plastic style). Loosen the wing nut and angle the indicator until one of the points is on the nearest mark of the desired lumber thickness scale.

When you return the carriage for a second cut, you can lower the carriage to the next mark on the lumber thickness scale you chose, without having to measure on the inch scale.

Example: You want to cut 1" (25 mm) (4/4) random width boards from a log. Position the blade for the first cut. Loosen the wing nut on the left end of the indicator. Move the indicator until one of the points is on the nearest 4/4 mark. Make a trim cut. Return the carriage for the second cut. Now, instead of having to measure down 1 1/8" (29 mm) on the inch scale, you can simply lower the blade so the indicator is aligned with the next 4/4 mark on the quarter scale. Turn the log 90 degrees and repeat.

4.9 Water Lube Operation

The Water Lube System keeps the blade clean. Water flows from a 5-gallon (18.9 liter) bottle through a hose to the blade guide where the blade enters the log. A valve in the bottle cap controls the amount of water flow.

See Figure 4-7.

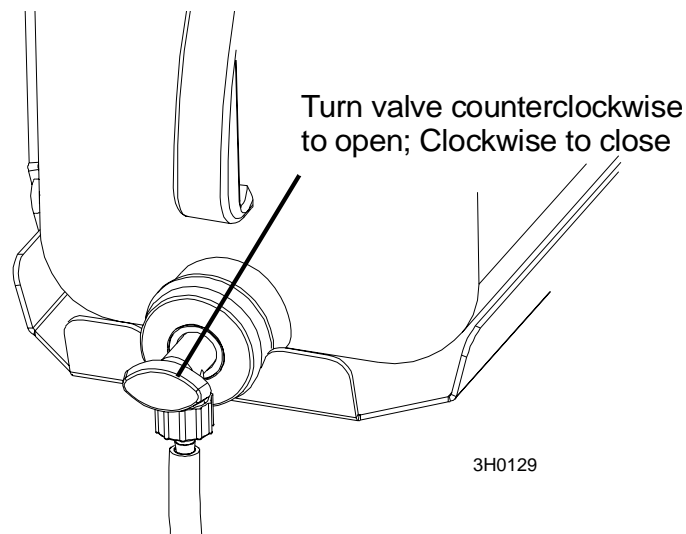



FIG. 4-7

Not all types of wood require the use of the Water Lube System. When it is needed, use just enough water to keep the blade clean. This saves water, and lowers the risk of staining the boards with water. Usual flow will be 1-2 gallons (3.8-7.6 liters) per hour.

Before removing the blade, engage the blade. Let the blade spin with water running on it for about 15 seconds. This will clean the blade of sap buildup. Wipe the blade dry with a rag before storing or sharpening.

For further lubrication benefits, add one 12oz. bottle of Wood-Mizer Lube Additive to 5 gallons of water. Wood-Mizer Lube Additive enables some previously impossible timbers to be cut by significantly reducing resin buildup on the blade. It helps to reduce heat buildup, wavy cuts, and blade noise. This biodegradable and environmentally friendly pre-mix includes a water softener additive, so it works with hard water.

 **WARNING!** Use ONLY water and Wood-Mizer Lube Additive with the water lube accessory. Never use flammable fuels or liquids such as diesel fuel. If these types of liquids are necessary to clean the blade, remove it and clean with

4**Sawmill Operation***Water Lube Operation*

a rag. Failure to do so can damage the equipment and may result in serious injury or death.

If you are sawing in freezing temperatures, remove the water lube bottle from the sawmill when done sawing and store it in a warm place. Blow any remaining water from the water lube hose.

4.10 Preparing The Sawmill For Towing

The Wood-Mizer trailer package makes transporting your sawmill easy and convenient. To get your sawmill ready for towing, follow these instructions.

1. Move the saw carriage to the front end of the sawmill. Raise the rear outriggers.

See Figure 4-8. For Fine Adjust Outriggers (FAOs), make sure the outrigger base is adjusted so that the grease fitting is just below the lowest outrigger hole before securing the FAO in position with the lock pin. This provides maximum ground clearance while preventing the lock pin from hitting the grease fitting.



CAUTION! Be sure the outrigger base is adjusted properly before securing the FAO in position with the lock pin. Failure to do so will cause damage to the outrigger grease fitting.



CAUTION! Do not adjust the FAO outrigger base height while there is weight on the FAO. Damage to the FAO may result.

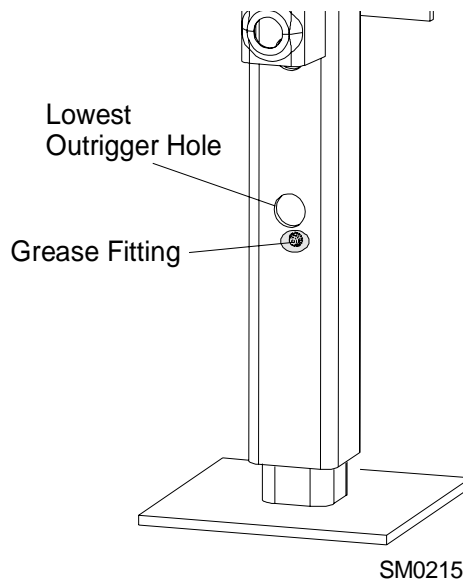


FIG. 4-8. FINE ADJUST OUTRIGGER ONLY.

2. Release the blade tension.



CAUTION! Changes in temperature could cause increased pressure in the blade tensioner and loss of fluid from the gauge. Release the blade tension when the mill is not in

use to avoid damage to the tensioner.

3. Move the carriage forward to the travel position over the rear bed rail.
4. Position the hole in the saw head over the travel rest pin.
5. Lower the saw head until it is seated firmly on the rest pin.

See Figure 4-9.

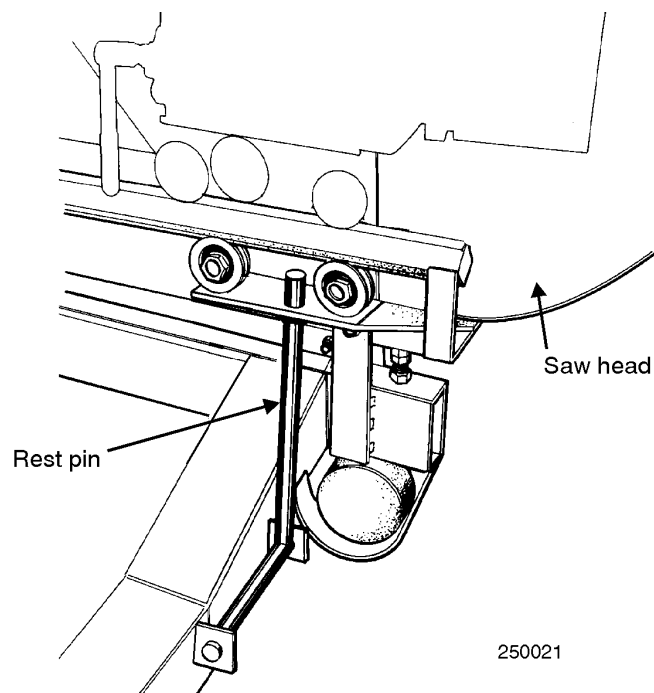


FIG. 4-9

6. Continue lowering the head $\frac{3}{4}$ " (19mm) until it contacts the stop blocks on the mast rails.



CAUTION! It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

7. If necessary, adjust the two stops located at the bottom of the mast so the saw head contacts them after it is lowered $3/4$ " (19mm) past where it contacts the rest pin.

See Figure 4-10.

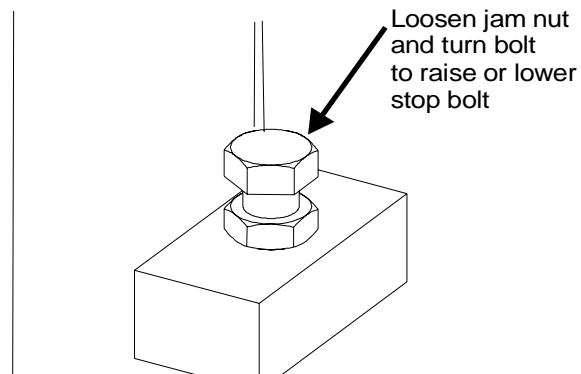


FIG. 4-10

8. Engage the clutch/brake lever. This keeps the drive belt tight and the motor from bouncing while traveling. Be sure to disengage the clutch/brake handle after reaching the destination to avoid deformation of the drive belt.

4

Sawmill Operation

Preparing The Sawmill For Towing

9. Hook the carriage safety chain located at the bottom of the carriage to the bracket at the bottom of the mast.

See Figure 4-11.

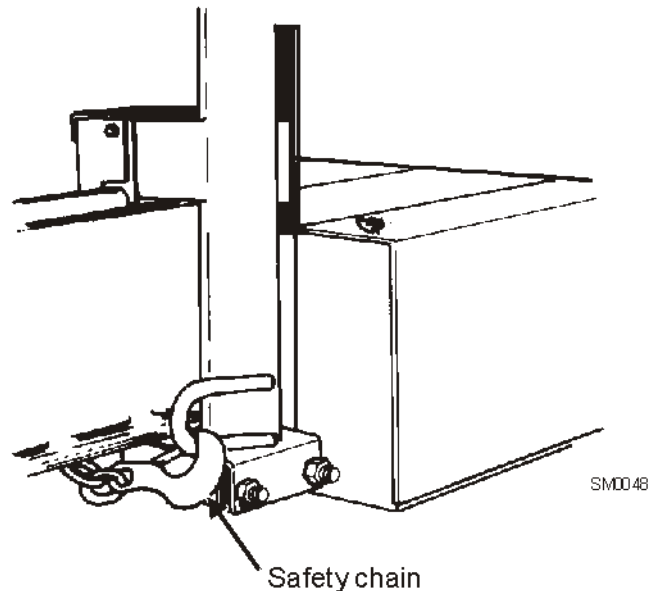


FIG. 4-11

10. Store the loading ramps on the bed rails. Secure to the bed with the two retaining brackets.



CAUTION! Check to be sure the saw head safety chain is secured before towing the sawmill. Failure to properly secure the saw head can result in severe machine damage. Be sure the blade housing and pulley covers are in place and secure. Use the safety retainer pin and cable to fasten blade housing covers.

11. Remove all loose objects from the bed of the mill. Store the outrigger jack handle in the bracket provided on the rear/loading-side outrigger guide. Reel in the winch cable and remove the winch handle if applicable.
12. Store the loading ramps on the bed rails. Secure to the bed with the two retaining brackets.

13. Place both fenders in the slots located behind the trailer tires and secure with retaining pins (prior to 6/00) or rubber straps (6/00+). Raise all but the very front outrigger.

For Fine Adjust Outriggers (FAOs), be sure to adjust the outrigger base height so that the grease fitting is just below the lowest outrigger hole before securing the FAO in position with the lock pin.



CAUTION! Be sure the outrigger base is adjusted properly before securing the FAO in position with the lock pin. Failure to do so will cause damage to the outrigger grease fitting.



CAUTION! Do not adjust the FAO outrigger base height while there is weight on the FAO. Damage to the FAO may result.

See the trailer operator's manual for specific information regarding hitch operation and towing the sawmill.

SECTION 5 MAINTENANCE

This section lists the maintenance procedures that need to be performed.

See the [Maintenance Log](#) located after this section for a complete list of maintenance procedures and intervals. Keep track of machine maintenance by filling in the machine hours and the date you perform each procedure.



This symbol identifies the interval (hours of operation) at which each maintenance procedure should be performed.

Be sure to refer to option and engine manuals for other maintenance procedures.

5.1 Wear Life

See Table 5-1. This chart lists estimated life expectancy of common replacement parts if proper maintenance and operation procedures are followed. Due to the many variables which exist during sawmill operation, actual part life may vary significantly. This information is provided so that you may plan ahead in ordering replacement parts.

Part Description	Estimated Life
B57 Blade Wheel Belts	400 hours
Blade Guide Rollers	1000 hours
Drive Belt	1250 hours

TABLE 5-1

5.2 Blade Guides



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

1. For mills equipped with greaseable blade guides, lubricate the blade guide rollers every four hours of operation. Use one squeeze of a NLGI No. 2 grade lithium grease from a grease gun to lubricate the bearings and remove any sawdust.

See Figure 5-1.

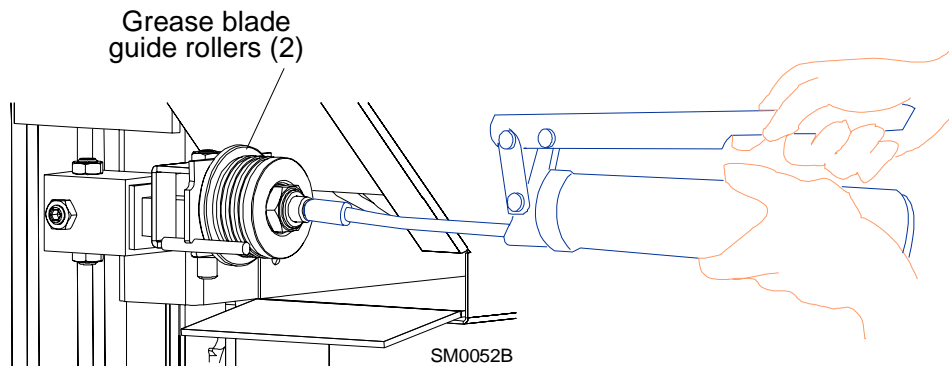


FIG. 5-1



CAUTION! Do not over-grease the blade guide bearings. Over-greasing will push the seals out of the bearings causing premature failure.

2. Check the rollers for performance and wear every blade change. Make sure the rollers are clean and spinning freely. If not, replace them. Replace any rollers which have worn smooth or have become cone shaped.

5 Maintenance

Blade Guides

3. Make sure the blade screw in the top center of the C-frame is $1/16"$ (1.5 mm) away from the blade. If not, loosen the nut and adjust the screw as necessary. Check the screw every 500 hours of operation. Failing to maintain this adjustment will lead to early blade breakage.

See Figure 5-2.

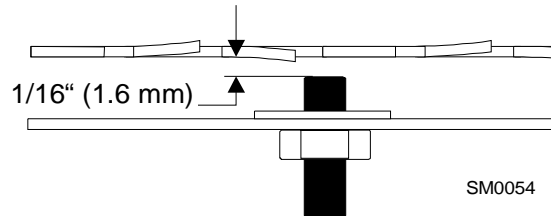


FIG. 5-2

5.3 Sawdust Removal



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



Remove the excess sawdust from the blade wheel housings and sawdust chute every blade change.

WARNING! Always keep clear of exiting sawdust. Keep hands, feet and any other objects away from the sawdust chute when operating sawmill. Failure to do so may result in serious injury.

WARNING! Always check to ensure the steel fingers inside the sawdust chute are in place before operating the sawmill. The steel fingers have been designed to help prevent a broken blade or some other object from becoming a projectile and exiting the sawdust chute. Failure to have these fingers in place may result in serious injury.

5.4 Carriage Track, Wiper & Scrapers



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

Properly maintaining the sawmill carriage track is critical in preventing corrosion that can cause pitting and scaling on the rail surfaces. Pitted and scaled surfaces can, in turn, cause rough cuts or jerky feed movement.

See Figure 5-3.

1. Clean track rails to remove any sawdust and sap buildup every eight hours of operation.

8

Use a light-grade sandpaper or emery cloth to sand off any rust or other adhering particles from the rails.



CAUTION! Keep track rails free of rust. Formation of rust on the track rail in the areas where the cam bearings roll can cause rapid deterioration of the track rail's surface.

Lubricate the rails by wiping them with Dexron III ATF transmission fluid. Lubrication will help protect the rails from corrosive elements such as acid rain and/or moisture from nearby bodies of saltwater (if applicable). This lubrication is essential to maintain the integrity of the track rails and track rollers and to achieve long service life.

2. Remove sawdust from the track roller housings and lubricate the felt track wiper every twenty-five hours of operation.

25

Remove the track roller housing covers and brush any sawdust buildup from the housings.

Clean and lubricate the felt track wiper. Unbolt the middle track cover, remove from the sawmill and remove any sawdust buildup. Soak the felt wiper with Dexron III transmission fluid.

Rev. D6.00+ only: Soak the lower felt wipers with Dexron III transmission fluid. Apply oil to both wipers through the access holes in the wiper housings.

- 3.** Check the track scrapers as needed. Make sure the scrapers fit firmly against the rail. If a track scraper needs to be adjusted, loosen the screw, push the scraper downward until it fits firmly against the rail, and retighten the thumb screw.

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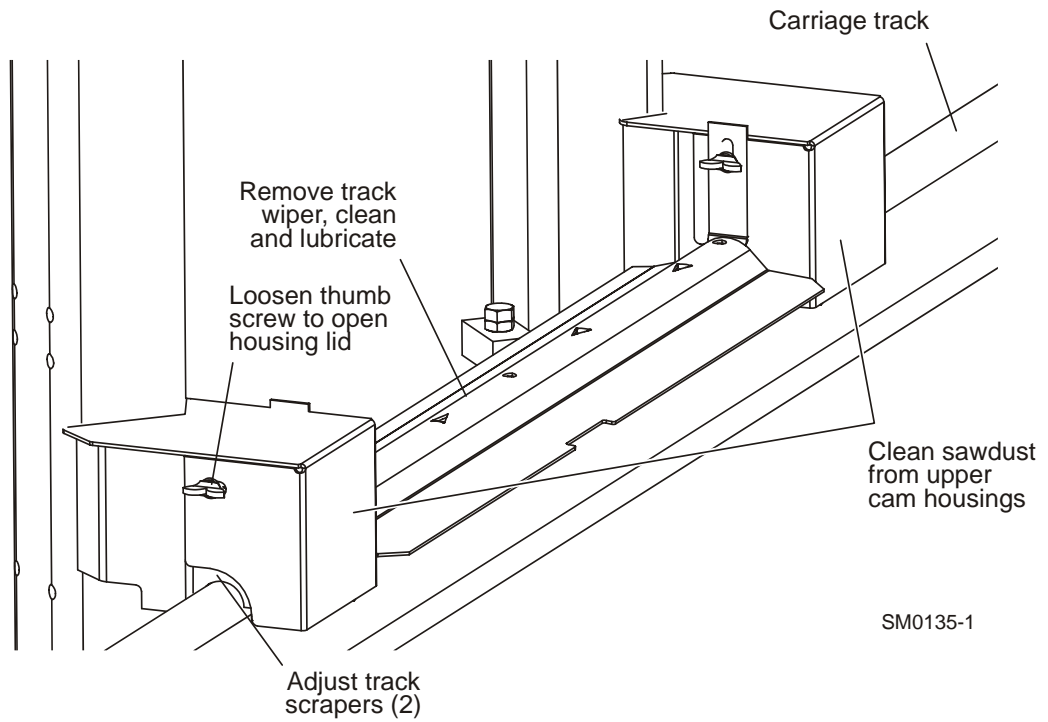


FIG. 5-3

5.5 Vertical Mast Rails



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



Clean and lubricate the vertical mast rails every 50 hours of operation. Clean with solvent and remove any rust with a light-grade sand paper or emery cloth. Lubricate the mast with motor oil or automatic transmission fluid (ATF).



CAUTION! Never use grease on the mast rails as it will collect sawdust.

5.6 Miscellaneous

1. Oil all chains with Dexron III ATF every fifty hours of operation.

50



CAUTION! Do not use chain lube. It causes sawdust buildup in chain links.

2. Apply a thin film of a NLGI No. 2 grade lithium grease to the blade guide arm every fifty hours of operation to help prevent it from rusting.

50

3. Lubricate the log turner (if equipped) with a NLGI No. 2 grade lithium grease every fifty hours of operation. Lubricate the turner pivot pins with WD-40 or a dry lube.

50

4. Grease the clutch handle pivot and side support pivots with a NLGI No. 2 grade lithium grease every fifty hours of operation.

50

5. Check the mill alignment every setup ([See Section 7](#)).

6. Make sure all safety warning decals are readable. Remove sawdust and dirt. Replace any damaged or unreadable decals immediately. Order decals from your Customer Service Representative.

5.7 Blade Tensioner



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

1. Lubricate the chrome rods of the tensioner system with a heavy duty teflon spray lubricant, such as Gunk L508, every fifty hours of operation.
2. Lubricate the tensioner screw handle with a NLGI No. 2 grade lithium grease as needed.

See Figure 5-4.

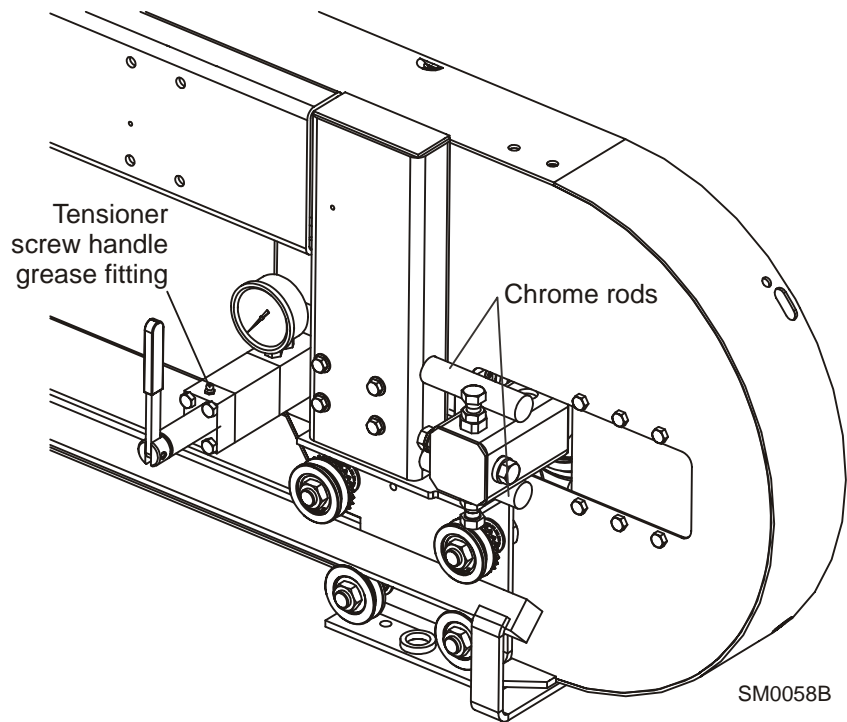


FIG. 5-4

See Figure 5-5. Add an Automatic Transmission Fluid (ATF) such as Dexron III ATF to the hydraulic blade tensioner as needed. To add enough fluid to completely fill the tensioner block:

1. Unscrew the tensioner handle to reveal 2" of thread. Remove the sawmill blade housing covers and blade.
2. Push the idle-side blade wheel/shaft housing all the way in to collapse the rear tensioner piston. Pull the idle-side blade wheel/shaft housing away from the tensioner.
3. There are two fill plugs provided on the tensioner. For easiest access, it is recommended to use the hole behind the gauge to refill the tensioner. Clean any dirt and debris from the plug area. Use a 7/16" wrench to remove the plug, making sure to keep the plug o-ring with the plug.
4. Use a small funnel, cup or squirt can to add hydraulic fluid through the fill plug hole until a puddle of fluid forms and is maintained over the fill hole. As you maintain the puddle, manually extend the rear piston. Be careful not to draw air into the tensioner. Use pliers to pull the rear piston if necessary, but only grip the outer 1/4" of the rear piston. Gripping or marring the surface beyond this point could result in seal damage and prevent the system from holding tension. Continue pulling out the piston as far as it will travel.
5. Reinsert the plug and thread 2-3 turns. Turn the tension handle clockwise until 6 or 7 threads show beyond the front piston block. Tighten the plug all the way.
6. Push the idle-side blade wheel/shaft housing all the way in to collapse the rear tensioner piston. If the piston does not extend at least 2" from the end of the tensioner block, repeat Steps 1-5.
7. Reinstall the blade and blade housing covers. If you have trouble installing a blade, it may be necessary to remove some fluid. Open the plug one turn and turn the tension handle in until some fluid is pushed out. Tighten the plug and retry.

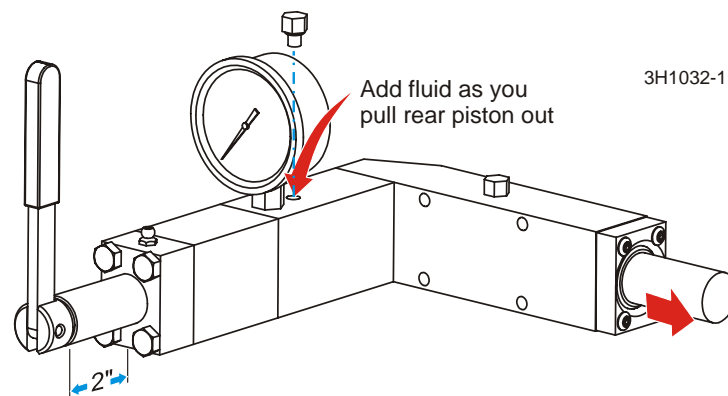


FIG. 5-5

5.8 Blade Wheel Belts



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



Rotate the blade wheel belts and check them for wear. Rotating the belts every 50 hours will provide longer belt life. Replace belts as necessary. Use only B57 belts manufactured by Goodyear or Browning.

5.9 Brake Strap Adjustment



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



Check the brake strap for wear every 200 hours of operation. Replace if damaged or worn.

Also check and adjust the brake strap after each drive belt adjustment, if the blade does not stop quickly, or unusual sounds occur when the brake is applied, or a sudden change is noticed in the clutch handle position when the clutch is disengaged. Adjust the brake strap if the drive belt jumps from the drive pulley when the clutch handle is disengaged.

1. To access the brake strap, remove the belt cover located underneath the engine.
2. Engage the clutch/brake lever.

See Figure 5-6.

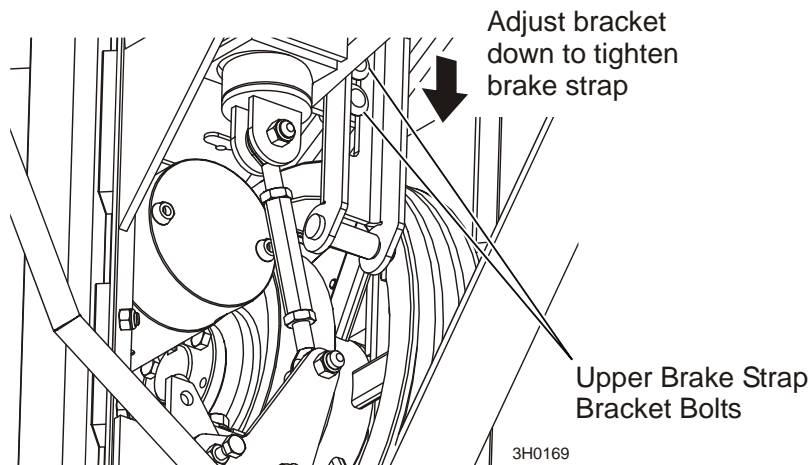


FIG. 5-6

3. Loosen the two nuts on the upper brake strap bracket. Slide the bracket and brake strap down 1/8" and retighten the bracket nuts.
4. Disengage the clutch. Check the drive belt fit in the drive pulley. You should just be able to pull the belt from the pulley. If the belt is still too loose, engage the clutch and repeat brake strap adjustments in 1/8" increments until the drive belt properly fits in the drive pulley with the clutch disengaged.

NOTE: Be careful to not overtighten. Overtightening will cause the drive belt to “grab” the pulley and can prevent the engine from starting properly.

5. Replace the belt cover.

5.10 Drive Belt Adjustment



WARNING! Disconnect and lockout power before performing any service to the electrical system. For battery-powered equipment, disconnect the negative battery terminal cable. Failure to do so may result in injury and/or electrical system damage.



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



WARNING! Do not for any reason adjust the engine drive belts or belt support bracket with the engine running. Doing so may result in serious injury.



See Table 5-2. See the table below for drive belt tension specifications for your model sawmill.

Engine/Motor	After First	Then Every	Belt Tension
G11	20 hrs	50 hrs	7/16" (11mm) deflection with 5 lbs. of deflection force
G15/G18/G20	20 hrs	50 hrs	7/16" (11mm) deflection with 8 lbs. of deflection force

TABLE 5-2

1. Remove the two belt covers located underneath the engine.
2. Loosen the drive belt turnbuckle jam nuts. Turn the turnbuckle counterclockwise (as viewed from the top) to tighten the belt, clockwise to loosen the belt.

See Figure 5-7.

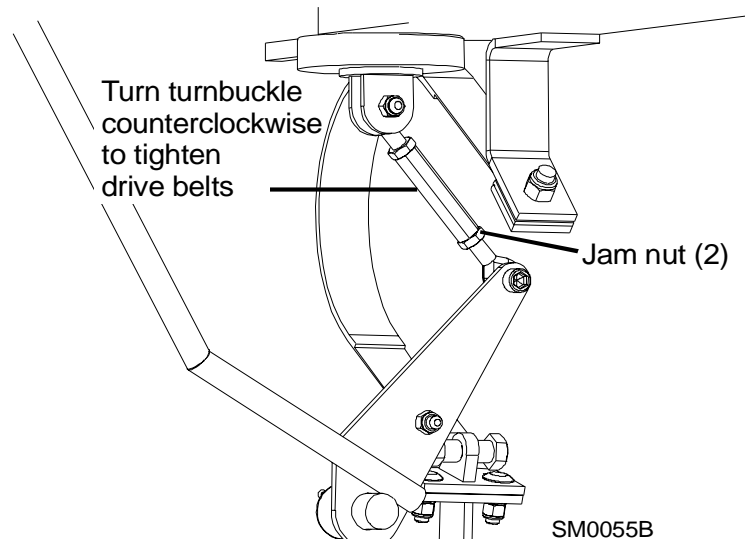


FIG. 5-7

3. After tensioning the drive belt, disengage the clutch/brake lever and check the fit of the belt in the drive pulley. You should just be able to pull the belt from the drive pulley. If the belt is too loose, it may jump from the drive pulley when the belt is disengaged. Adjusting the brake strap controls the drive belt fit in the drive pulley when the clutch/brake lever is disengaged ([See Section 5.9](#)).
4. After tensioning the drive belt, check throttle cable tension and adjust if necessary. The throttle cable should be tensioned just enough so that the engine revs as soon as the clutch/brake handle is engaged. The throttle linkage should NOT affect engine RPM while the clutch/brake handle is disengaged. **NOTE:** A properly adjusted throttle will extend the cable spring 1/4" to 3/8" (6.4 - 9.5 mm) when running and have a slight amount of slack in the cable when idling. Always be sure to check the drive belt support after adjusting drive belt tension.
5. After making adjustments to the drive belt, always check the brake adjustment ([See Section 5.9](#)).



Periodically check the drive belt for wear. Replace any damaged or worn belts as needed.



Adjust the drive belt support as needed. The drive belt support is designed to extend belt life. The bracket should be adjusted to NOT touch the drive belt when the clutch handle is engaged (down position), AND to hold the drive belt away from the engine pulley when the clutch handle is disengaged (up position).

See Figure 5-8. To adjust the drive belt support:

1. Make sure the motor is not running. Loosen the adjustment nuts (Rev. C2.00 - C4.00) or

bolts (Rev. C5.00+).

2. Position the bracket so that the prong is close to, but does not touch, the drive belt with the clutch handle engaged.
3. Retighten the adjustment bolts or nuts 25-27 pound feet (34-37 newton meters).

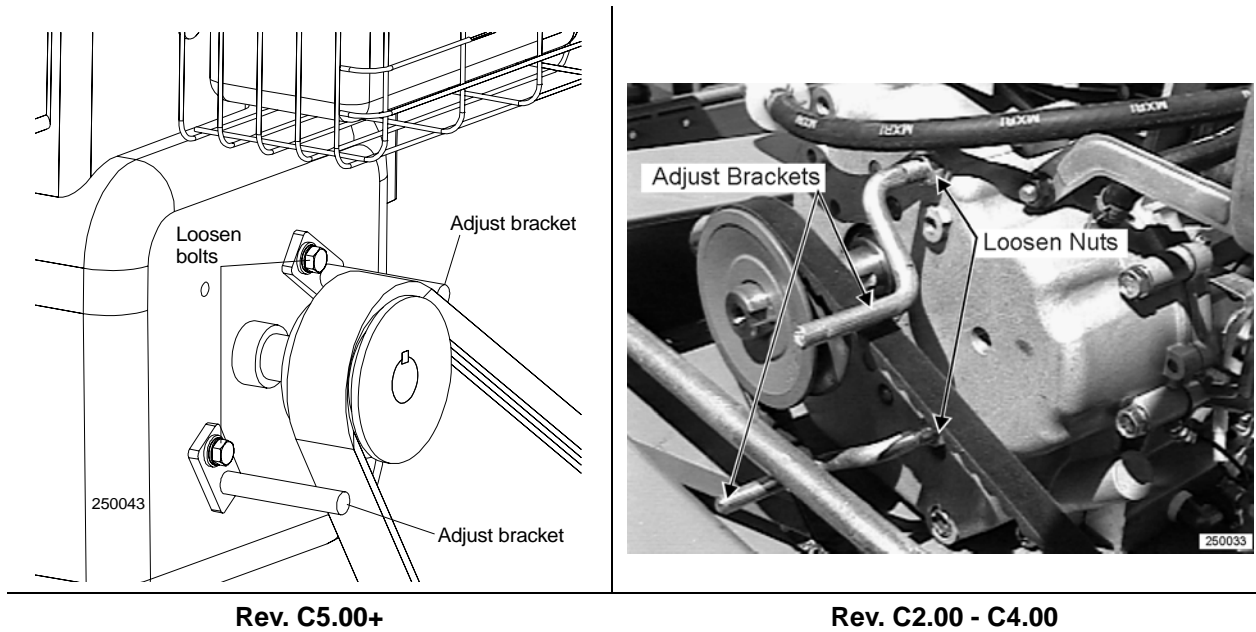


FIG. 5-8



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

5.11 Drive Bearing



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



Drain and refill the fluid in the drive-side cylinder bearing housing every 500 hours of operation.

For LT25 rev. D2.00 and later, disconnect the oil level view hose from the fitting at the top of the bearing housing. With the fitting at the bottom of the bearing housing still connected, allow oil to drain from the oil level view hose. Once drained, pour fresh Automatic Transmission Fluid (ATF) such as Dexron III ATF into the hose until the oil level is in the acceptable range as indicated on the gauge decal. Reconnect the hose to the top fitting.

See Figure 5-9.

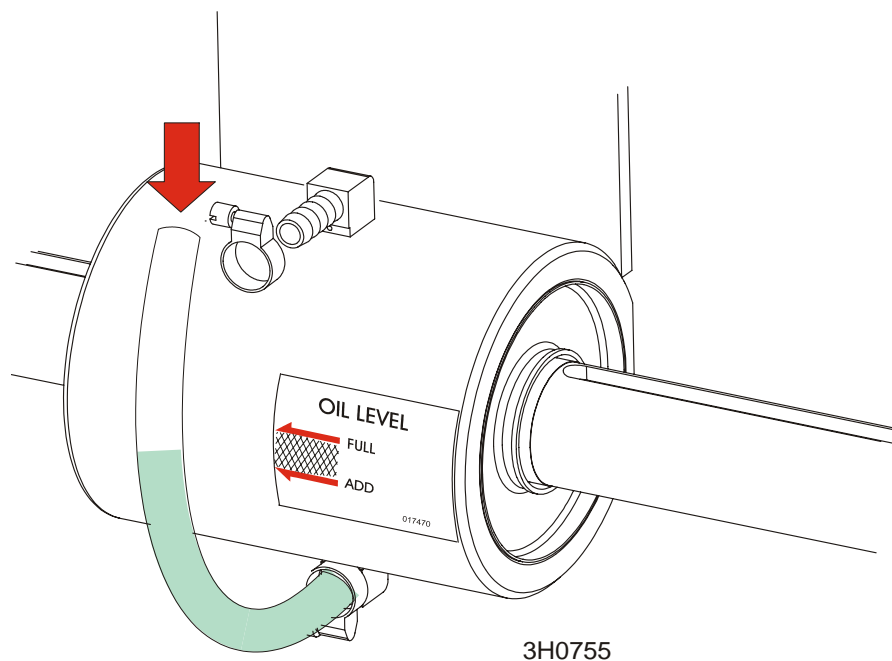


FIG. 5-9

5 Maintenance

Drive Bearing

For mills prior to D2.00, remove the top and bottom oil plugs. Pour an Automatic Transmission Fluid (ATF) such as Dexron III ATF into the top hole until it begins to flow from the bottom hole. Reinstall the square oil plug to the bottom hole and the vented oil plug to the top hole.

See Figure 5-10.

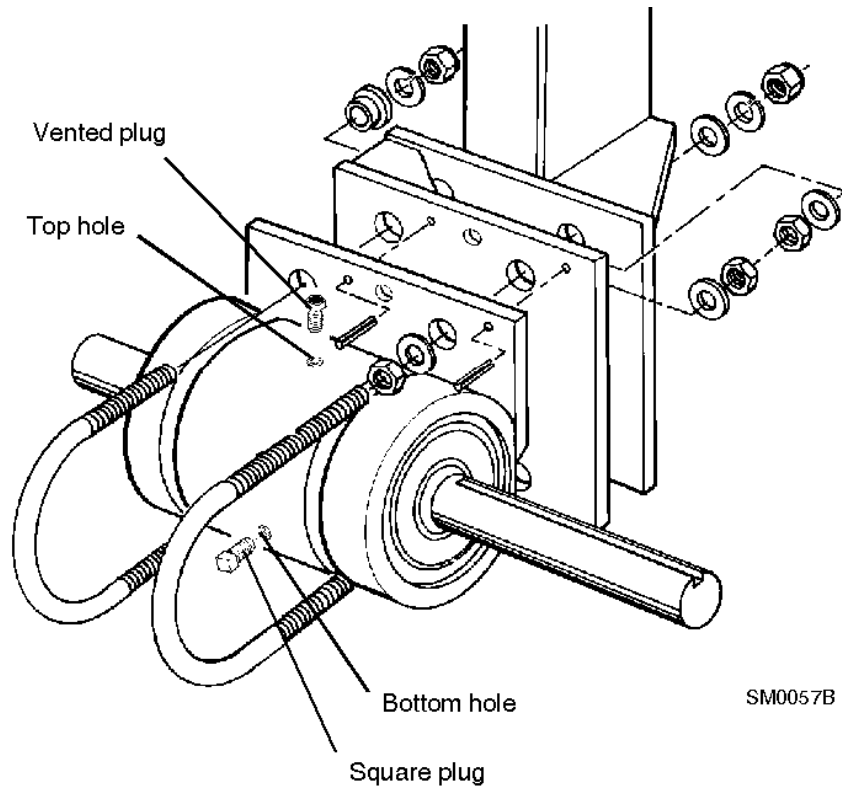


FIG. 5-10

5.12 Up/Down System



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

Adjust the up/down chain tension as needed. Measure chain tension with the head all the way to the top of the vertical mast. Secure the carriage with a chain at the top. Find the chain adjusting bolt at the bottom of the mast. Loosen the nut on the sprocket bolt and move the sprocket down until there is about 1" (2.5 cm) total deflection in the center of the chain with a 5 lb. (2.3 Kg) deflection force. **Rev. D6.00+ Only:** Loosen the nut and turn the adjustment bolt clockwise to move the sprocket down.



WARNING! Always secure the saw head with a 5/16" chain with at least 1900 lbs. working load capacity before adjusting the up/down chain. The cutting head may fall, causing severe injury or death.

See Figure 5-11.

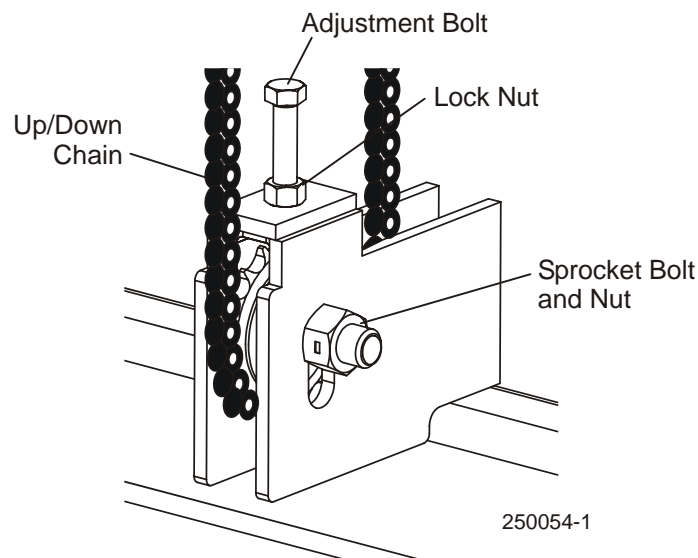


FIG. 5-11



Maintenance

Up/Down System

5.13 Feed Rope



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

Adjust the feed rope as needed. Measure the feed rope tension with the saw head all the way toward the front of the mill. The middle of the rope should have 6-8" deflection. To tighten, pull on the feed rope adjustment handle.

See Figure 5-12.

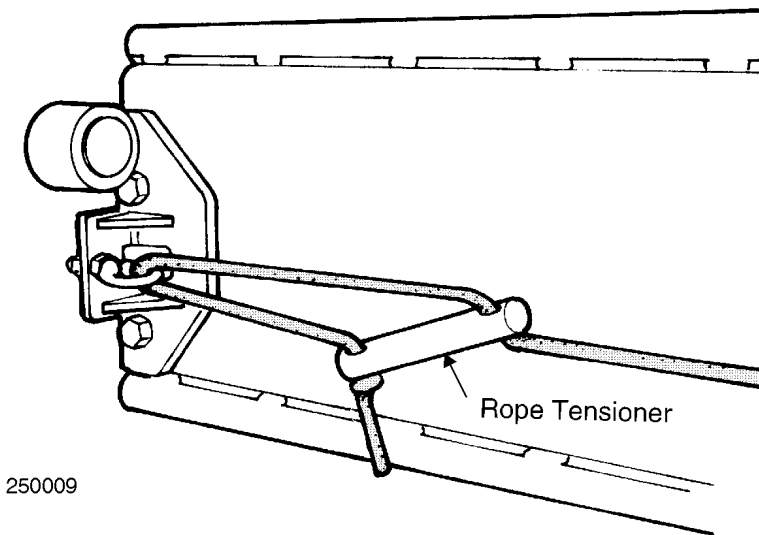


FIG. 5-12

5.14 Charging The Battery (G20/G15-E Only)



DANGER! Batteries expel explosive gases. Keep sparks, flames, burning cigarettes, or other ignition sources away at all times. Always wear safety goggles and a face shield when working near batteries. Failure to do so will cause serious injury.¹



WARNING! Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and reproductive harm. Wash hands after handling.



WARNING! Charge the battery in a well ventilated area. Do not attempt to charge a frozen battery.

Use extreme care to avoid spilling or splashing electrolyte (which is dilute sulfuric acid) as it can destroy clothing and burn the skin. If electrolyte is spilled or splashed on clothing or the body, it should be neutralized immediately and then rinsed with clean water. A solution of baking soda, or household ammonia, and water may be used as a neutralizer.

Electrolyte splashed into the eyes is extremely dangerous. If this should happen, force the eye open and flood it with cool, clean water for approximately fifteen minutes. A doctor should be called immediately when the accident occurs and “on-the-spot” medical attention given if possible. If a doctor cannot come to the scene of the accident immediately, follow his instructions concerning actions to take. Do not add eye drops or other medication unless advised to do so by the doctor. Do not place a battery or acid within the reach of children. If acid (electrolyte) is taken internally drink large quantities of water or milk. Follow with milk of magnesia, beaten egg or vegetable oil. Call a physician immediately.

If electrolyte is spilled or splashed on any surface of the machine, it should be neutralized and rinsed with clean water.



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

¹ Battery Council International, copyright 1987

CAUTION! Be sure the battery is fully charged before transporting the sawmill. If the battery is not fully charged, excessive vibration could reduce the overall service life of the battery.

1. Turn the key to the OFF (#0) position and remove the key.
2. Remove the battery box lid.
3. Clean the battery terminals if necessary.
4. Connect the positive charger/jumper cable directly to the positive battery terminal.
5. Connect the negative charger/jumper cable to a grounded metal surface.
6. Follow the instructions supplied with your specific battery charger.



IMPORTANT: Be careful not to overcharge the battery, especially when using a high-rate or “boost” charger (40 amps or higher). These are intended to quickly charge a good battery that is discharged. They are not intended for unattended or long-term charging.

7. After the battery is completely recharged, remove the negative charger/jumper cable from ground.
8. Remove the positive charger/jumper cable from the battery.
9. Replace the battery box lid.

MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

Lubricate Blade Guide Rollers (If Applicable)	See Section 5.2	Daily - Every 4 Hours	DAILY MAINTENANCE PROCEDURES
Check Blade Guide Roller Wear	See Section 5.2	Daily - Every Blade Change	
Remove Excess Sawdust From Blade Wheel Housings And Sawdust Chute	See Section 5.3	Daily - Every Blade Change	
Inspect Fingers Inside Sawdust Chute	See Section 5.3	Daily - Every Blade Change	
Clean Sawdust From Battery Box Lid & Track Cover	See Section 5.3	Daily - Every 8 Hours	
Clean And Lubricate Track	See Section 5.4	Daily - Every 8 Hours	
Remove Sawdust From Upper Track Roller Housings	See Section 5.4	Bi-Weekly - Every 25 Hours	
Clean And Lubricate Upper Track Wiper	See Section 5.4	Bi-Weekly - Every 25 Hours	

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		50 HRS	100 HRS	150 HRS	200 HRS	250 HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		550 HRS	600 HRS	650 HRS	700 HRS	750 HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1050 HRS	1100 HRS	1150 HRS	1200 HRS	1250 HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		1550 HRS	1600 HRS	1650 HRS	1700 HRS	1750 HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2050 HRS	2100 HRS	2150 HRS	2200 HRS	2250 HRS	2300 HRS	2350 HRS	2400 HRS	2450 HRS	2500 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

MAINTENANCE LOG

PROCEDURE	REFERENCE	TOTAL HOURS OF OPERATION									
		FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.									
		2550 HRS	2600 HRS	2650 HRS	2700 HRS	2750 HRS	2800 HRS	2850 HRS	2900 HRS	2950 HRS	3000 HRS
Clean & lube mast rails	See Section 5.5										
Grease pivot points and bearings/Oil chains	See Section 5.6										
Lubricate blade tensioner handle and rods	See Section 5.7										
Rotate drive/idle blade wheel belts/Check for wear	See Section 5.8										
Check brake strap tension	See Section 5.9										
Check belt tensions	See Section 5.10										
Check blade throat screw	See Section 5.2										
Replace cylinder drive bearing fluid	See Section 5.11										
Check feed rope & up/down chain tensions	See Section 5.12 See Section 5.13										

SECTION 6 TROUBLESHOOTING GUIDE

6.1 Sawing Problems



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

PROBLEM	CAUSE	SOLUTION
Blades Dull Quickly	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 water/coolant while sharpening blade
	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Sharpener Manual)
Blades Break Prematurely	Poor sharpening techniques	See Sharpener Manual
	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edge of wheels	Change blade wheel belts (B-57)
	Tension too tight	Tension blade to recommended specifications
Blade Does Not Track Right on Drive Wheel	Cant adjustment is incorrect	Readjust
	Flat/worn belts	Replace B-57 belts
Blade Guides Do Not Spin While Cutting	Frozen bearings	Replace bearings
	Stiff bearings	Grease bearings
Blade Does Not Stop Immediately After Disengaging	Brake strap too loose	Adjust brake strap
Drive Belts Come Off Pulleys When Disengaging Blade	Brake strap too loose	Adjust brake strap
	Brake drum misaligned	Realign on drive shaft
	Brake strap tightened with one edge too loose and one edge too tight	Adjust brake strap
Drive Belts Wear Prematurely or Jump	Engine/motor and drive pulleys out of alignment	Align pulleys See Section 6.2.

PROBLEM	CAUSE	SOLUTION
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. Take a board off the top. Turn the log 180 degrees. Take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut.
	Set in teeth.	Resharpener and reset blade.
Height Adjustment Jumps or Stutters When Moving Up or Down.	Bed rails misaligned.	Realign sawmill.
	Up/down chain improperly adjusted.	Adjust up/down chain.
Lumber Is Not Square	Vertical wear pads are too tight.	Adjust pads.
	Vertical side supports not square to bed	Adjust side supports.
Sawdust Builds Up On Track	Blade not parallel to bed rails	Adjust bed rails parallel to blade.
	Sawdust or bark between cant and bed rails	Remove particles
	Tooth set problems	Resharpener and reset blade
Wavy Cuts	Excessive oiling	Do not oil track
	Track wipers worn	Adjust wipers to firmly contact track
Boards Thick Or Thin On Ends Or Middle Of Board.	Track is sticky	Clean track with solvent and apply silicone spray
	Excessive feed	Slow feed rate
Boards Thick Or Thin On Ends Or Middle Of Board.	Improperly sharpened blade (This will be the problem 99% of the time!)	Resharpener blade (See Sharpener Manual - read entire manual!)
	Blade guides improperly adjusted	Adjust blade guides.
Boards Thick Or Thin On Ends Or Middle Of Board.	Sap buildup on blade	Use Water Lube.
	Tooth set problem	Resharpener and reset blade

6.2 Engine/Motor and Drive Pulleys Alignment



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



WARNING! Do not for any reason adjust the engine drive belts or belt support bracket with the engine running. Doing so may result in serious injury.

1. Install and properly tension the drive belt ([See Section 5.10](#)).
2. With the clutch handle disengaged, use a straight edge to check the alignment of the engine pulley to the main drive pulley. Loosen the bushing on the drive pulley and adjust if necessary until it is aligned with the engine pulley.
3. Check that the engine pulley is also square with the drive pulley. If necessary, loosen the engine mounting bolts and cock the engine until the pulley is square with the drive pulley. Retighten the engine mounting bolts.
4. Check that all engine mounting bolts and pivot bushing clamps are tight.
5. Engage the clutch handle and recheck the pulley alignment. Adjust if necessary.
6. If any pulleys were adjusted, recheck the drive belt support(s) and adjust if necessary ([See Section 5.10](#)).

SECTION 7 SAWMILL ALIGNMENT

The Wood-Mizer sawmill is factory aligned. Two alignment procedures are available to realign the sawmill if necessary. The Routine Alignment instructions should be performed as necessary to solve sawing problems not related to blade performance. The Complete Alignment procedure should be performed approximately every 1500 hours of operation (sooner if you regularly transport the sawmill over rough terrain).

7.1 Routine Alignment Procedure

Blade Installation

1. Remove the blade and check the blade wheel belts. Remove any sawdust buildup from the surface of the belts. Replace worn belts if they do not keep the blade from contacting the blade wheel.
2. Install a clean blade and apply the appropriate tension ([See Section 3.4](#)).
3. Adjust the idle-side cant control to track the blade ([See Section 3.5](#)).
4. Close the middle blade housing cover and make sure all persons are clear of the open side of the saw head.
5. Start the engine.
6. Engage the blade, rotating the blade until the blade positions itself on the wheels.



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

7. Disengage the blade. Turn the engine off.

Saw Head Tilt

As the blade enters a wide log or cant, the outside of the saw head will drop down slightly. To compensate for the drop, the saw head is adjusted $1/16$ " (1.5 mm) higher at the outside.

1. Move the saw carriage so the blade is positioned over a bed rail. Adjust the blade guide arm to $1/2$ " (15 mm) from full open.
2. Raise the saw head so the bottom of the blade measures $14\ 3/4$ " (375 mm) from the top surface of the bed rail near the inner blade guide assembly.

See Figure 7-1.

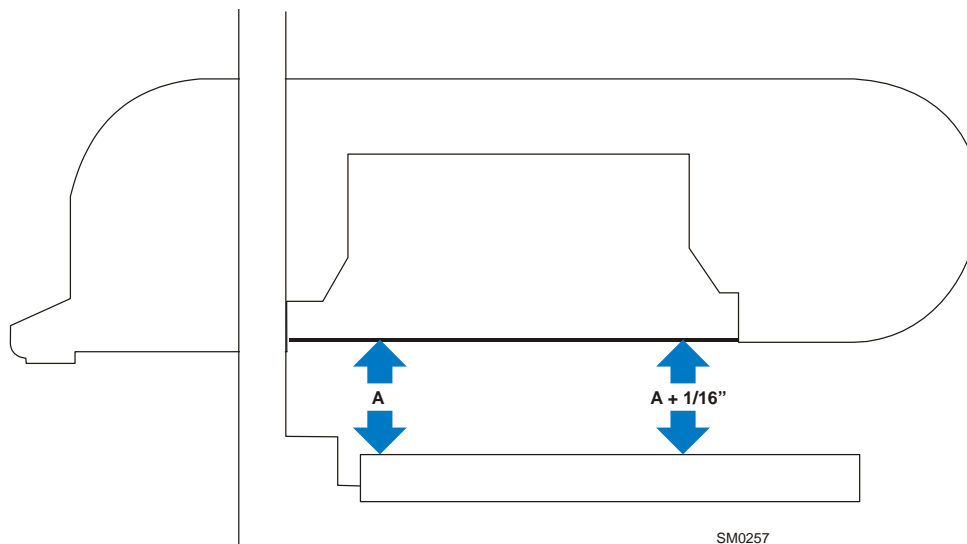
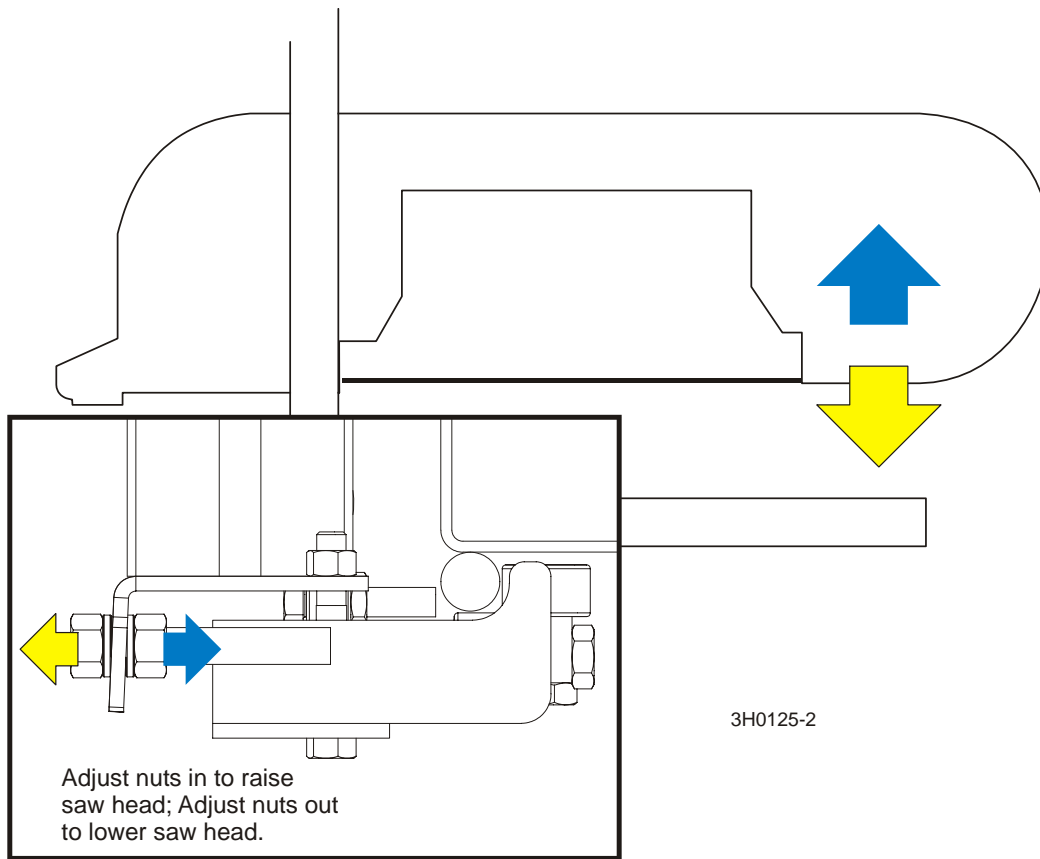


FIG. 7-1

3. Measure from the blade to the bed rail near the outer blade guide assembly. This measurement should be $1/16$ " (1.5 mm) higher than the inner measurement or $14\ 13/16$ " (376.5 mm).

See Figure 7-2. To adjust the saw head tilt, use the horizontal adjustment nuts. To raise the outside of the saw head, loosen the four inner adjustment nuts 1/4 turn and tighten the four outer nuts. Recheck the measurement from the blade to the bed rails and adjust the horizontal adjustment nuts until the outside of the saw head is 1/16" higher than the inside.



DETAIL OF LOWER TRACK ROLLER ASSEMBLY

FIG. 7-2

7 Sawmill Alignment

Routine Alignment Procedure

Blade Guide Arm Alignment

The blade guide arm moves the outer blade guide in and out. If the arm becomes loose, the blade guide will not deflect the blade properly, causing inaccurate cuts. A loose blade guide arm can also cause blade vibration.

1. Adjust the blade guide arm in to 1/2" (15 mm) from fully closed.
2. Manually try to move the arm up and down. If you can move the arm by hand, you will need to tighten the arm rollers.

See Figure 7-3. Remove the blade housing cover to access the blade guide arm roller mounting bolts. The blade guide arm rollers are mounted on cam-shaped bolts. Turning the bolts will cause each roller to move up or down. If the inner lower roller is loose, adjust the inner top roller down. If the outer lower roller is loose, adjust the outer lower roller up. Retighten the jam nuts and recheck the tightness of the bottom rollers.

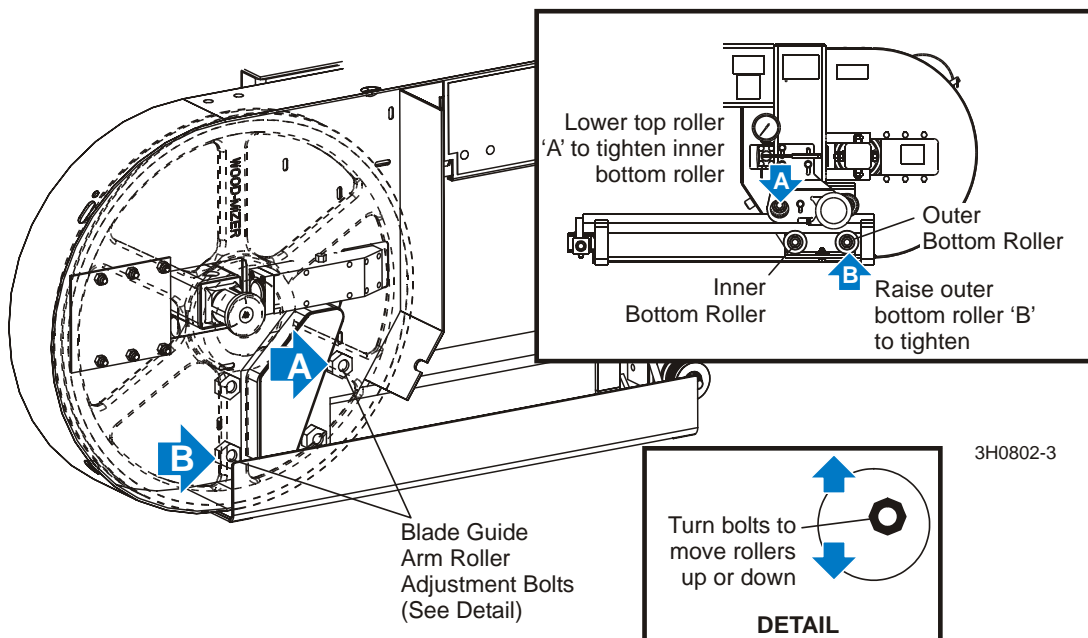


FIG. 7-3

After tightening the blade guide arm rollers, check that the arm is aligned properly.

3. With the arm adjusted 1/2" (15 mm) from fully closed, measure the distance between the blade guide roller flange and the back of the blade.

See Figure 7-4.

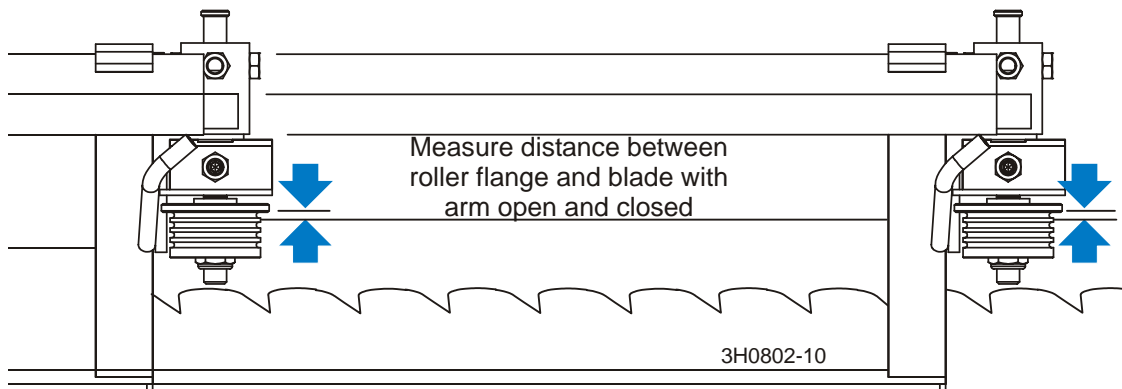


FIG. 7-4

4. Adjust the blade guide arm to 1/2" (15 mm) from fully open and remeasure the distance from the roller flange to the back of the blade. The two measurements should be the same. If not, adjust the outer rollers in or out to tilt the arm horizontally.

7 Sawmill Alignment

Routine Alignment Procedure

See Figure 7-5. To tilt the arm in toward the blade, loosen the front nuts on the outer rollers and tighten the rear nuts. To tilt the arm out away from the blade, loosen the rear nuts on the outer rollers and tighten the front nuts. Recheck the blade guide arm horizontal tilt.

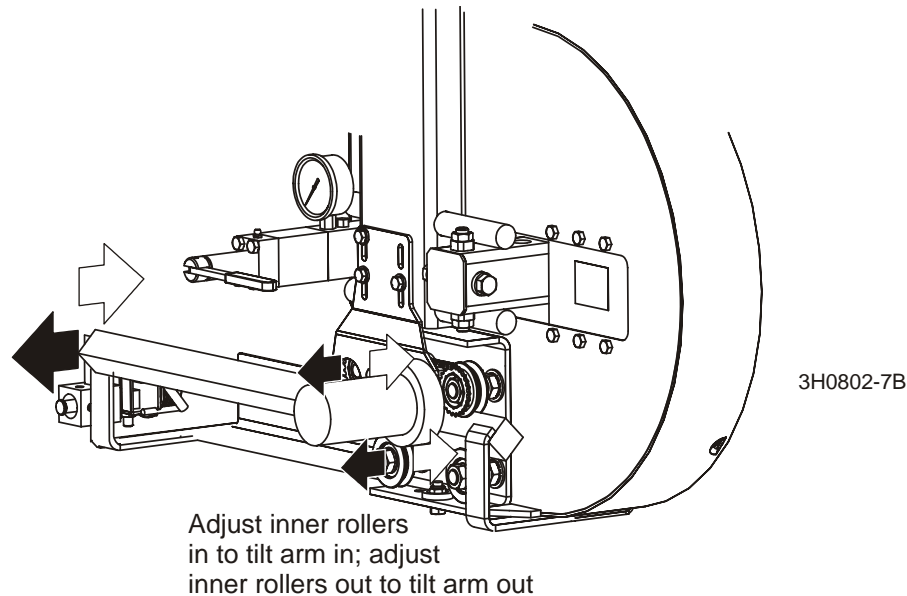


FIG. 7-5

5. Now check the vertical tilt of the blade guide arm. Move the saw carriage so the blade guide arm is positioned over a bed rail.
6. With the arm 1/2" (15 mm) from fully closed, raise or lower the saw head until the bottom of the blade guide block is 15" (375 mm) from the top of the bed rail.

See Figure 7-6.

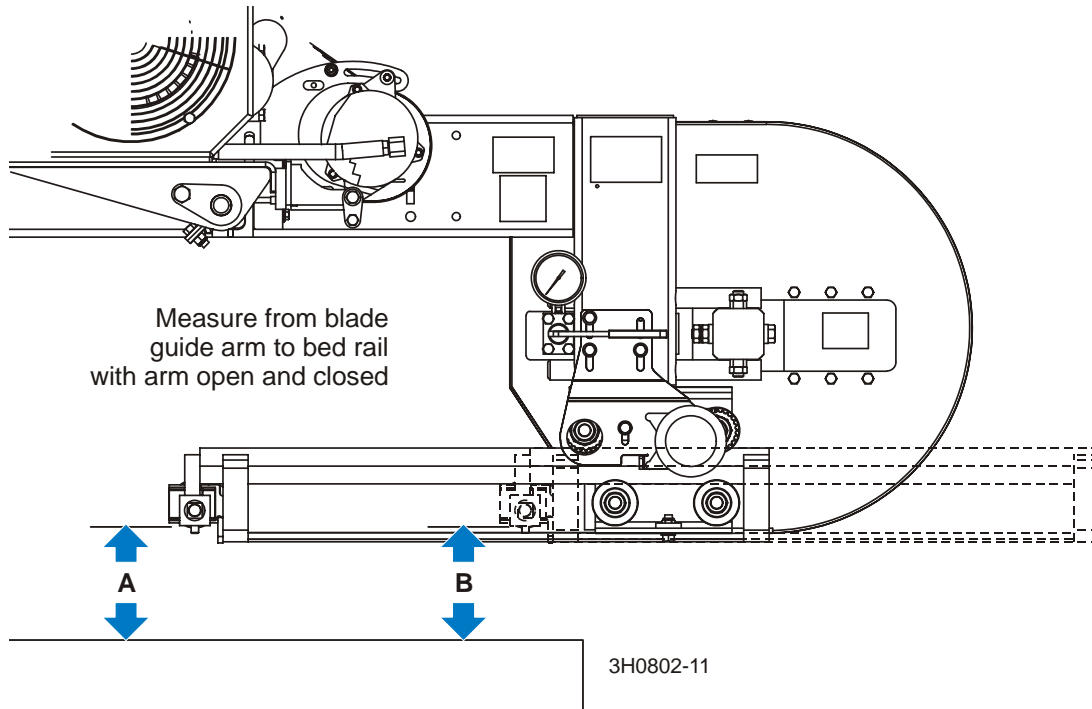


FIG. 7-6

7. Adjust the blade guide arm to 1/2" (15 mm) from fully open. Measure the distance from the bottom of the blade guide mounting block to the bed rail. This measurement should be 15" (376.5 mm) or slightly higher because the saw head is tilted up 1/16" (1.5 mm) on the outside ([See Saw Head Tilt](#)). If the blade guide is closer to the bed rail or more than 1/16" higher with the arm open, adjust the outer rollers up or down to tilt the blade guide arm vertically.

7 Sawmill Alignment

Routine Alignment Procedure

See Figure 7-7. Remove the blade housing cover to access the blade guide arm roller mounting bolts. To adjust the rollers, loosen the jam nuts on the other side of the blade housing and turn the mounting bolts. To tilt the blade guide arm down, adjust the outer top and bottom rollers up. To tilt the blade guide arm up, adjust the outer top and bottom rollers down. Retighten the jam nuts and recheck the blade guide arm vertical tilt.

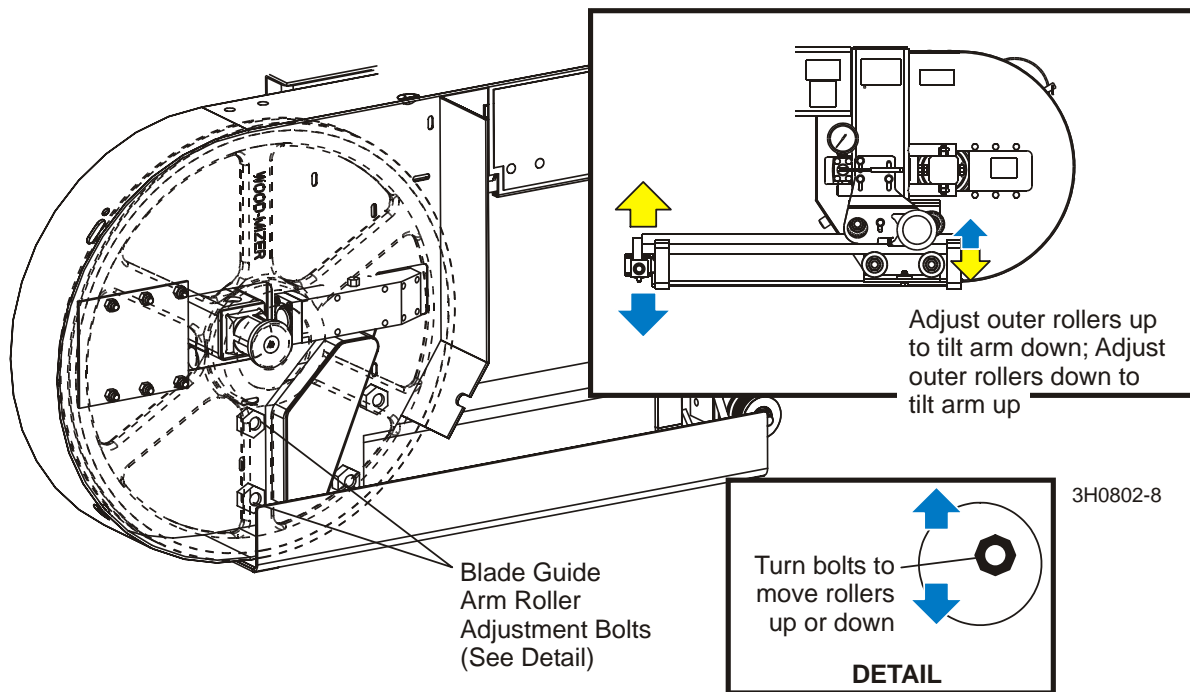


FIG. 7-7

Blade Guide Vertical Tilt Alignment

The blade guides should be adjusted properly in the vertical plane. If the blade guides are tilted vertically, the blade will try to travel in the tilted direction.

A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

1. Open the adjustable blade guide arm 1/2" (15 mm) from full open.
2. Clip the alignment tool on the blade. Position the tool close to the outer blade guide assembly. Be sure the tool does not rest on a tooth or burr, and is lying flat against the bottom of the blade.

See Figure 7-8.

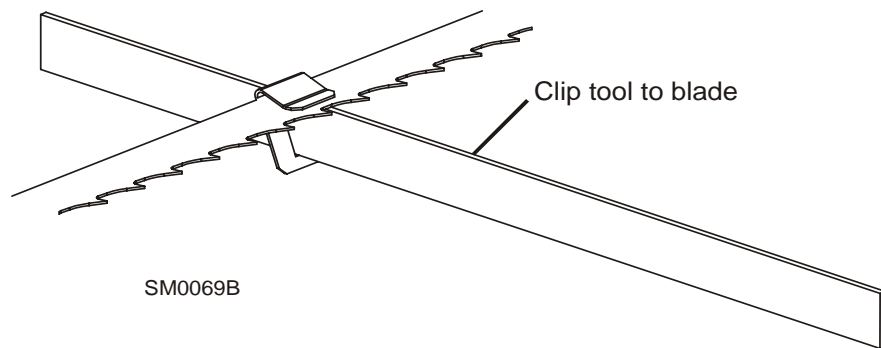


FIG. 7-8

3. Move the carriage so that the front end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.

NOTE: If the sawmill is equipped with stainless steel bed rail covers, be sure to measure from the blade guide alignment tool to the top surface of the cover rather than the bed rail tube.

4. Move the carriage so that the back end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
5. If the measurement from the tool to the bed rail is not equal within 1/32" (.75 mm), adjust the vertical tilt of the outer blade guide roller.
6. Loosen one set screw at the side of the blade guide assembly.

7

Sawmill Alignment

Routine Alignment Procedure

See **Figure 7-9**. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten top screw. To tilt the roller down, loosen the top screw and tighten the bottom screw. Tighten the jam nuts and recheck the tilt of the blade.

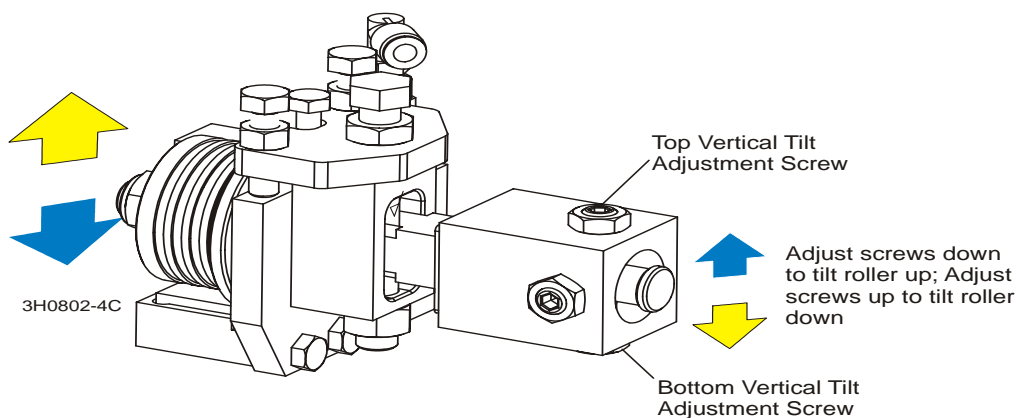


FIG. 7-9

7. Move the blade guide alignment tool close to the inner blade guide roller assembly and repeat the above steps. Adjust the vertical tilt of the inner blade guide if necessary.

Blade Guide Horizontal Tilt Adjustment

If the blade guides are tilted in the wrong direction horizontally, the back of the blade may contact the flange as the roller is spinning down, causing it to push the blade away from the guide roller.

8. Remove the blade guide alignment tool from the blade and adjust the blade guide arm halfway in.
9. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

See Figure 7-10.

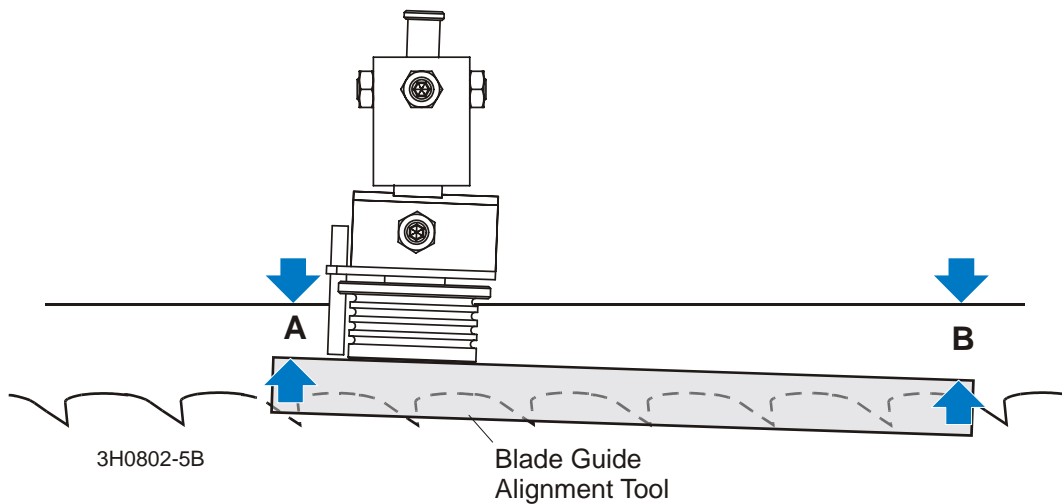


FIG. 7-10

10. Measure between the back edge of the blade and the tool at the end closest to the inner blade guide ("B").
11. Measure between the back edge of the blade and the other end of the tool ("A").

The roller should be tilted slightly to the left ('A' 1/8" [3 mm] less than 'B' ±1/8" [3 mm]).

7 Sawmill Alignment

Routine Alignment Procedure

See Figure 7-11. Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the right screw. Tighten the jam nuts and recheck the tilt of the blade.

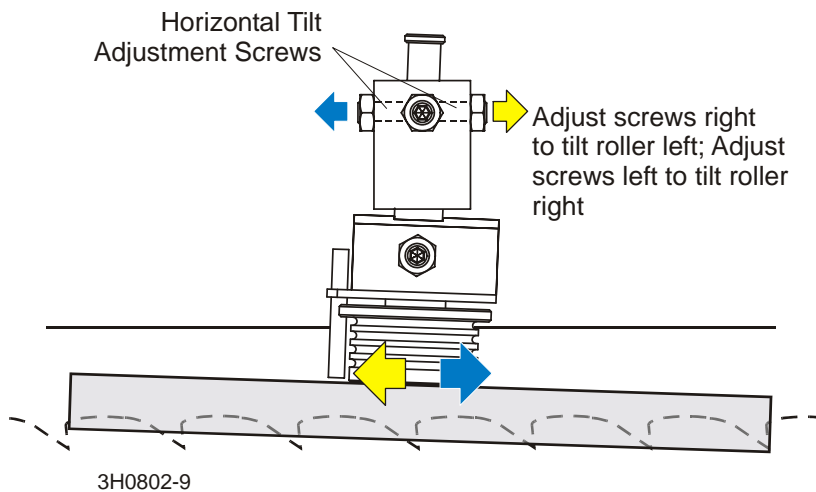


FIG. 7-11

12. Repeat the above steps for the inner blade guide roller assembly.

NOTE: Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. [See Blade Handbook, Form #600.](#)

Blade Guide Flange Spacing

Each blade guide must be adjusted so the roller flange is the correct distance from the back edge of the blade. If the flange is too close to or too far from the blade, the sawmill will not cut accurately.

HINT: When adjusting blade guide spacing, loosen the top set screw and one side set screw only. This will ensure horizontal and vertical tilt adjustments are maintained when the adjustment screws are retightened.

1. Measure the distance between the flange on the inner blade guide roller to the back edge of the blade. This distance should measure 1/16" (1.5 mm). Adjust the roller back or forward if necessary.

See Figure 7-12. Loosen the top and one side screw shown. Tap the blade guide forward or backward until properly positioned. Retighten the screws and jam nuts.

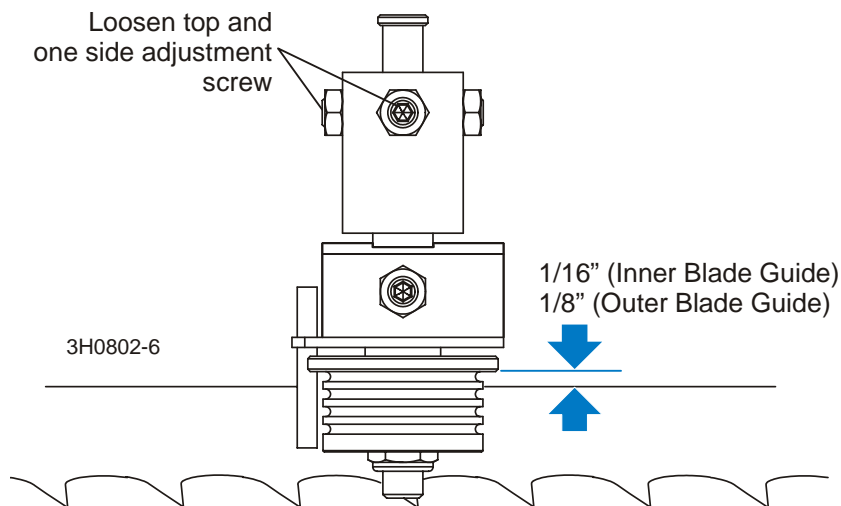


FIG. 7-12

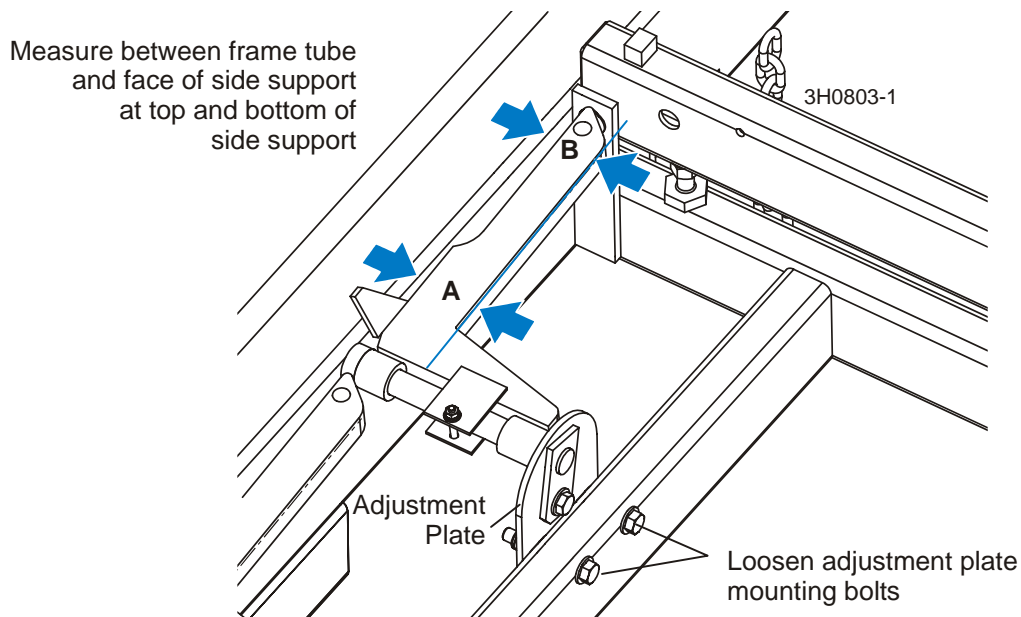
2. Measure the distance between the flange on the outer blade guide roller to the back edge of the blade. This distance should measure 1/8" (3.0 mm). Adjust the roller back or forward if necessary.

Side Support Alignment

Logs and boards are clamped against the side supports when sawing. The side supports must be square to the bed to ensure square lumber.

1. Swing a side support down and measure between the face of the support and the main bed tube. The distance at the top of the side support ('B') should be equal to or no more than 1/32" (0.8 mm) greater than the distance at the base of the side support ('A'). Adjust the horizontal tilt of the side support if necessary.

See Figure 7-13. Loosen the two adjustment plate mounting bolts. Use a mallet to move the plate until the side support is parallel to the bed tube in the horizontal position. Retighten the mounting bolts.

**FIG. 7-13**

2. Repeat the horizontal check for the remaining side supports. Adjust as necessary.
3. Place square alignment tubes (Part No. S12831 - 2 required) across the bed rails. Swing a side support up so that it is vertical.
4. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.
5. Place a square against the face of the side support. The side support should be square or slightly tilted forward 1/32" (0.8 mm). Adjust the vertical tilt of the side support if necessary.

See Figure 7-14. Loosen the side support mounting bolt. If the side support mounting pin is equipped with a square hole (after 6/00), use a 3/8" ratchet to rotate the pin until the side support is square to the bed. For previous side supports, use a mallet to move the side support.

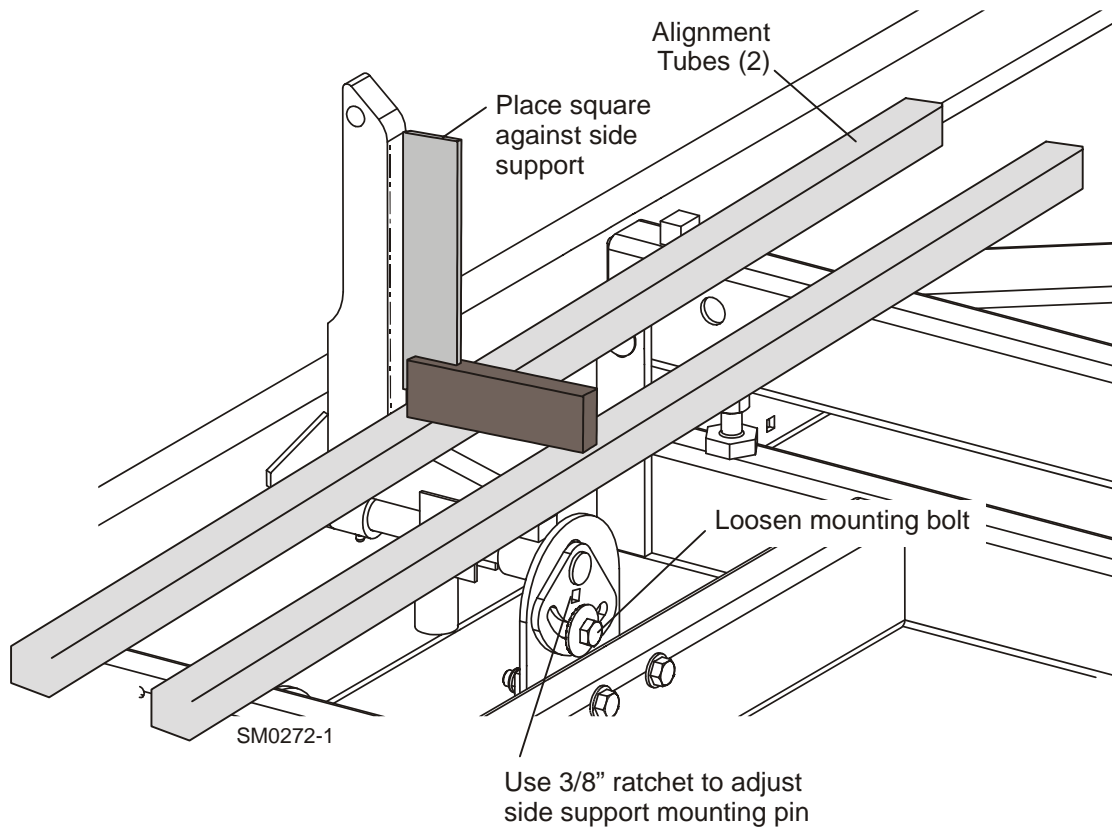


FIG. 7-14

6. Repeat the vertical check for the remaining side supports and adjust as necessary.

7

Sawmill Alignment

Routine Alignment Procedure

Blade Height Scale Adjustment

After the entire sawmill has been aligned and all adjustments made, check that the blade height scale indicates the true distance from the blade to the bed rails.

1. Move the saw head so the blade is positioned directly above one of the bed rails. Measure from the bottom edge on a down-set tooth of the blade to the top of the bed rail (or stainless steel sleeve if applicable), near the inner blade guide assembly.
2. View the blade height scale with eyes level with the indicator. The scale should indicate the actual distance from the blade to the bed rail. Adjust the indicator if necessary.

See Figure 7-15. Loosen the indicator bracket mounting bolts and adjust the bracket until the indicator is aligned with the correct mark on the scale (+0 -1/32 [0.8 mm]). Retighten the bracket mounting nut.

For example, if the measurement from the down-set tooth of the blade to the bed rail was 14 3/4" (375 mm), make sure the indicator reads 14 3/4" (375 mm) on the scale.

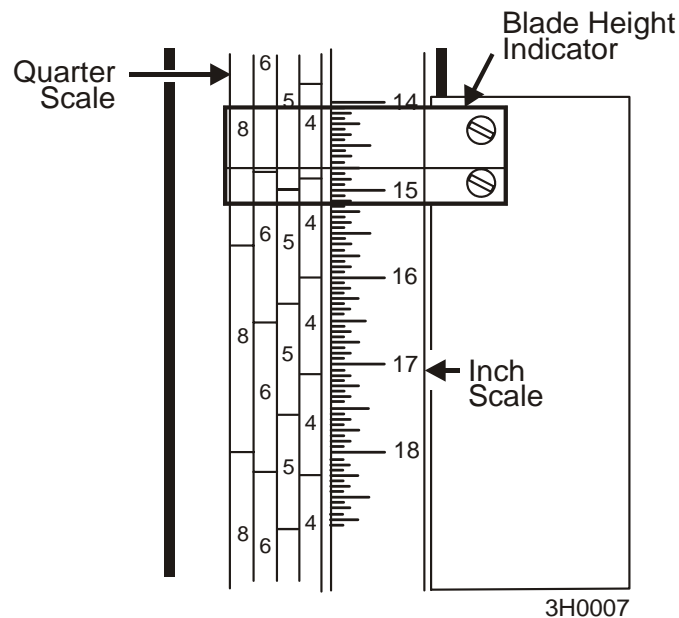


FIG. 7-15

7.2 Complete Alignment Procedure

Frame Setup

Before performing the following alignment procedures, setup the mill on firm, level ground.

If your sawmill is stationary, with no trailer axle, shim the feet so the weight of the sawmill is evenly supported.

If your sawmill has a trailer axle and adjustable outriggers, adjust the outriggers as follows:

LT25: Adjust the two outriggers on the main frame tube down just enough to lift weight from the trailer tire.

LT27/LT25L: Adjust the front and third outriggers on the main frame tube down just enough to lift weight from the trailer tire.

All Portable Sawmills: Adjust the two outer outriggers down just so they touch the ground but do not bear weight.

[See SECTION 3](#) for additional setup information.

Blade Installation

1. Remove the blade and replace the blade wheel belts. New blade wheel belts are required to perform the complete alignment procedure.
2. Blow sawdust off of the blade guide assemblies. Remove sawdust from the blade housings.
3. Remove the blade guide assemblies and the blade.

NOTE: To remove the blade guide assemblies and maintain the tilt adjustments, only loosen one side screw and the top screw. Leaving the other side screw and bottom screw in position will insure you will return the rollers to their original tilt adjustment.

4. Adjust the outer blade guide arm in or out until the outer blade guide is approximately 24" from the inner blade guide.
5. Install a new blade and apply the appropriate tension ([See Section 3.4](#)).
6. Close the middle blade housing cover and make sure all persons are clear of the open side of the saw head.
7. Start the engine.
8. Engage the blade, rotating the blade until the blade positions itself on the wheels.



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

9. Disengage the blade. Turn the engine off.

Saw Head Slide Pad Adjustment

There are eight nylon pads positioned between the saw head frame and vertical mast ¹. The spacing of the pads is factory set and rarely needs adjusting. To check the pad spacing, perform the following steps.

NOTE: The pads on the engine side of the mast are referred to as the “inner” pads. The pads on the control side of the mast are referred to as the “outer” pads.

NOTE: Shims are often used around the clamping bolts, between the C-frame support bracket and the mast v-brace. The shims align the v-brace to the mast so that the entire face of each slide pad makes contact with the mast. Be sure to keep these shims in place when performing the following adjustment.

See Figure 7-16.

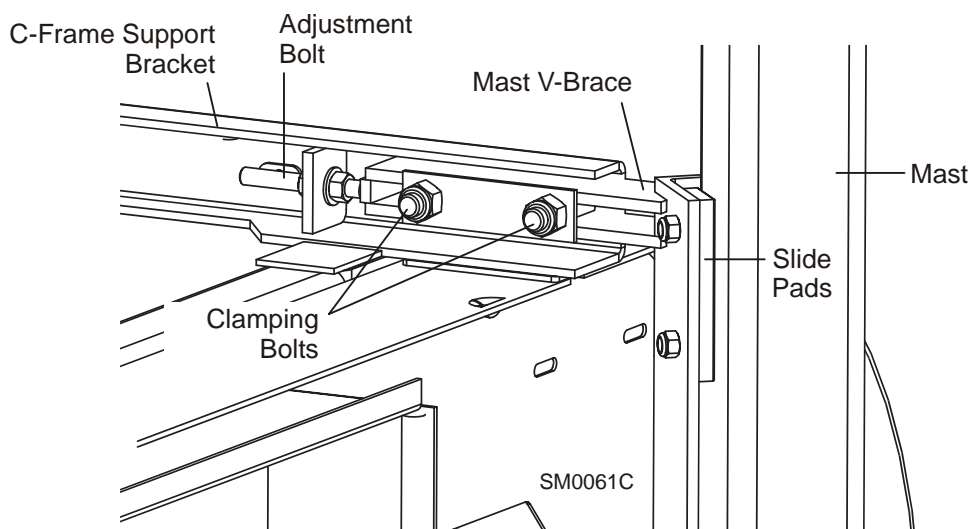


FIG. 7-16

1. Raise the saw head to the top of the vertical mast and secure the saw head with a chain at the top. Check the top set of four pads. The outer two pads should be touching the mast rails. There should be a small gap (just wide enough to slide a business card through) between one of the inner pads and the mast rail.



WARNING! Always secure the saw head with a 5/16" chain with at least 1900 lbs. working load capacity before adjusting the mast pads. The cutting head may fall, causing severe injury or death.

¹ Sawmills prior to Rev. D1.00 have sixteen pads. Only uppermost and lowermost pads are required. Middle pads do not provide any function and may be removed.

7

Sawmill Alignment

Complete Alignment Procedure

2. Make sure the saw head is adjusted up off the safety chain to ensure the chain is not affecting the alignment of the mast pads.
3. To adjust the spacing of the upper set of pads, lower the saw head until you can access the upper slide pad adjustment bolts.
4. Loosen the upper locking bolts and turn the adjusting bolt as necessary to provide the pad spacing described in Step 1.
5. Lower the saw head to the bottom of the vertical mast. Check the bottom set of four pads.

There should be a small gap between one of the outer pads and the mast rail. The gap should be just wide enough to slide a business card through. The inner two pads should be touching the mast rails. To adjust the spacing of the lower set of pads, raise the saw head until you can access the lower slide pad adjustment bolts.

6. Loosen the lower locking bolts and turn the adjusting bolt as necessary to provide the pad spacing described in Step 5.



CAUTION! Due to variations in the vertical mast, the pad spacing may vary throughout the travel of the saw head. Check the pad spacing at the top and bottom ends of the mast only. Pads adjusted too tight will cause premature up/down motor failure.

Blade Wheel Alignment

The blade wheels should be adjusted so they are level in the vertical and horizontal planes. If the blade wheels are tilted up or down, the blade will want to travel in the tilted direction. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels.

1. Use the blade guide alignment tool to check the vertical alignment of each blade wheel. Attach the tool to the blade near the inner blade guide mount. Be sure the tool does not rest on a tooth or burr, and is lying flat against the bottom of the blade.

See Figure 7-17.

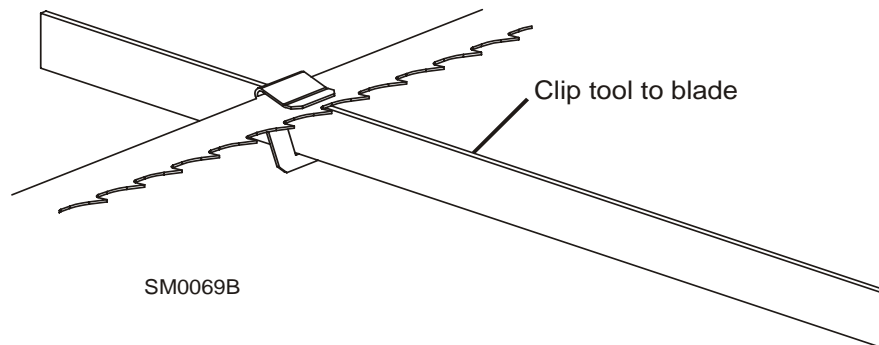


FIG. 7-17

2. Move the saw carriage so the front end of the tool is positioned over the first bed rail. Measure from the bottom of the tool to the top surface of the bed rail.
3. Move the saw carriage so the rear of the tool is positioned over the bed rail. Again, measure from the bottom of the tool to the bed rail.
4. If the two measurements differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the drive-side blade wheel.

7 Sawmill Alignment

Complete Alignment Procedure

LT25/LT27 rev. D4+:

See Figure 7-18. Use the vertical adjustment screws to adjust the drive-side blade wheel. To tilt the wheel up, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw to 30 ft.-lbs torque. Tighten the top and bottom jam nuts.

To tilt the wheel down, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw to 30 ft.-lbs torque. Tighten the top and bottom jam nuts.

NOTE: Sawmills prior to Rev. D6.00 are equipped with socket set screws rather than hex bolts. Adjustment of either type bolt is similar.

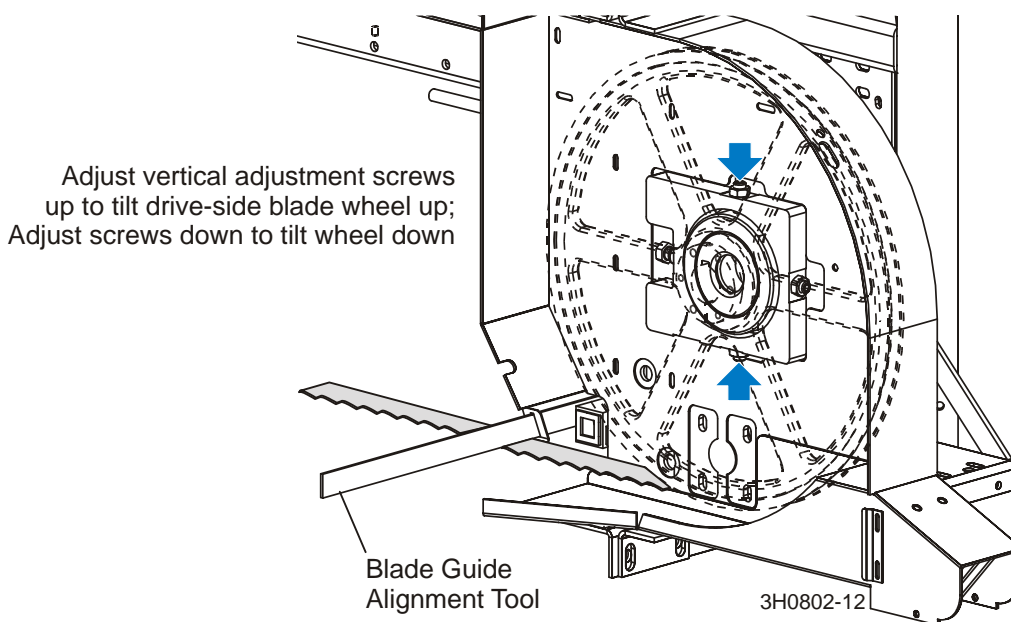


FIG. 7-18

5. Recheck the vertical tilt of the drive-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the bed rail (within 1/16" [1.5 mm]).
6. Remove the tool from the blade and reattach it near the outer blade guide assembly.
7. Measure from the tool to the bed rail at both ends of the tool. If the measurements at the front and rear ends of the tool differ by more than 1/16" (1.5 mm), adjust the vertical tilt of the idle-side blade wheel.

See Figure 7-19. Use the vertical adjustment screws to adjust the idle-side blade wheel. To tilt the wheel up, loosen the bottom adjustment screw one quarter turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel down, loosen the top adjustment screw one quarter turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

NOTE: Sawmills prior to Rev. D6.00 are equipped with socket set screws rather than hex bolts. Adjustment of either type bolt is similar.

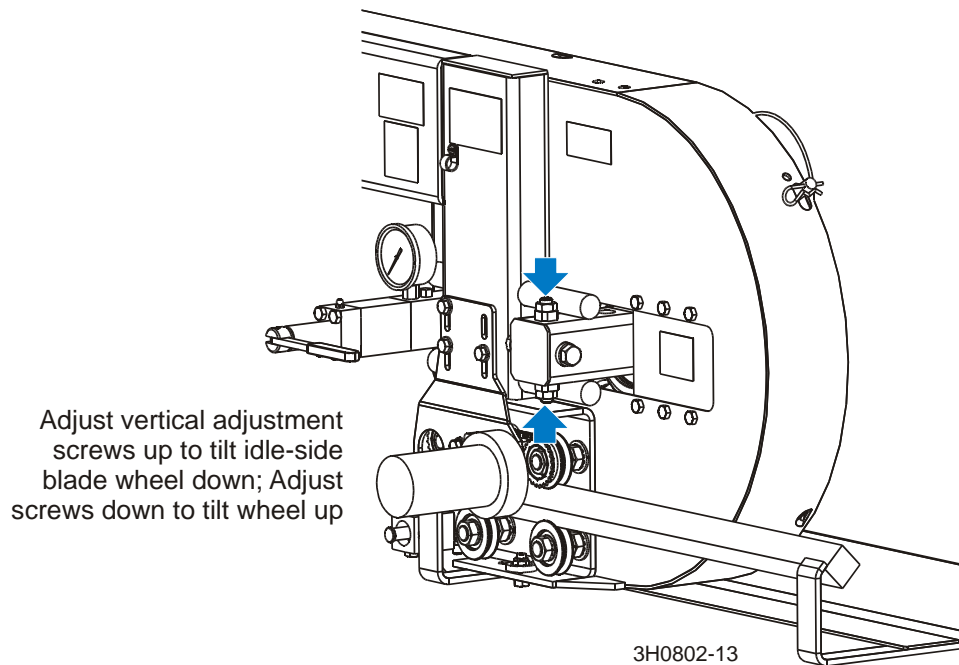


FIG. 7-19

8. Recheck the vertical tilt of the idle-side blade wheel with the blade guide alignment tool. Readjust the blade wheel as necessary until the front and rear of the tool are the same distance from the bed rail (within 1/16" [1.5 mm]).

7 Sawmill Alignment

Complete Alignment Procedure

9. Check the position of the blade on the idle-side blade wheel.

See Figure 7-20. The horizontal tilt of the blade wheel should be adjusted so that the gullet of a 1-1/4" blade is 1/8" (3 mm) out from the front edge of the wheel ($\pm 1/16$ [1.5 mm]). The gullet of a 1-1/2" blade should be 3/16" (4.5 mm) out from the front edge of the wheel ($\pm 1/16$ [1.5 mm]). Do not let the teeth ride on the wheels.

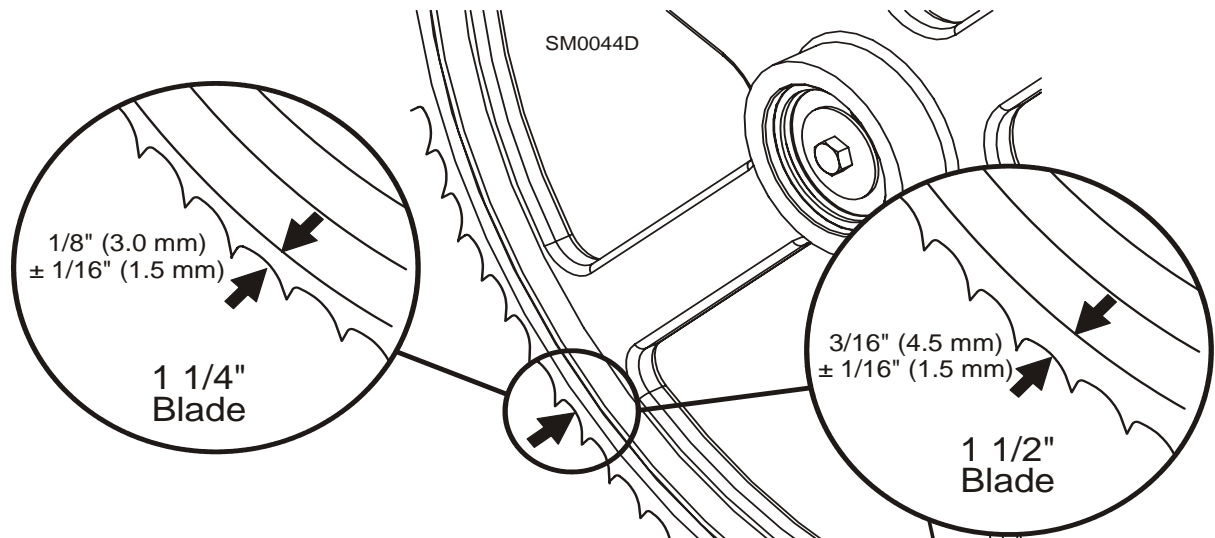
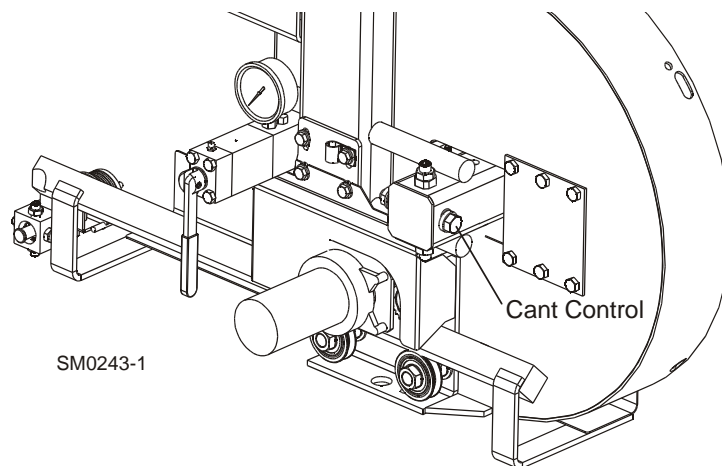


FIG. 7-20

See Figure 7-21. Use the cant control adjustment to adjust the idle-side blade wheel. If the blade is too far forward on the wheel, turn the cant control counterclockwise. If it is too far back on the wheel, turn the cant control clockwise.



Turn cant control clockwise to move blade out on wheel; counterclockwise to move blade back on wheel

FIG. 7-21

10. Check the position of the blade on the drive-side blade wheel. The blade should be positioned on the wheel as described for the idle-side blade wheel. Adjust the drive-side blade wheel if necessary.

LT25/LT27 rev. D4+:

See Figure 7-22. Use the horizontal adjustment screws to adjust the drive-side blade wheel. To move the blade back on the wheel, loosen the right adjustment screw one quarter turn. Loosen the jam nut on the left adjustment screw and tighten the screw to 30 ft.-lbs torque. Tighten the left and right jam nuts.

To move the blade out on the wheel, loosen the left adjustment screw one quarter turn. Loosen the jam nut on the right adjustment screw and tighten the screw to 30 ft.-lbs torque. Tighten the left and right jam nuts.

NOTE: Sawmills prior to Rev. D6.00 are equipped with socket set screws rather than hex bolts. Adjustment of either type bolt is similar.

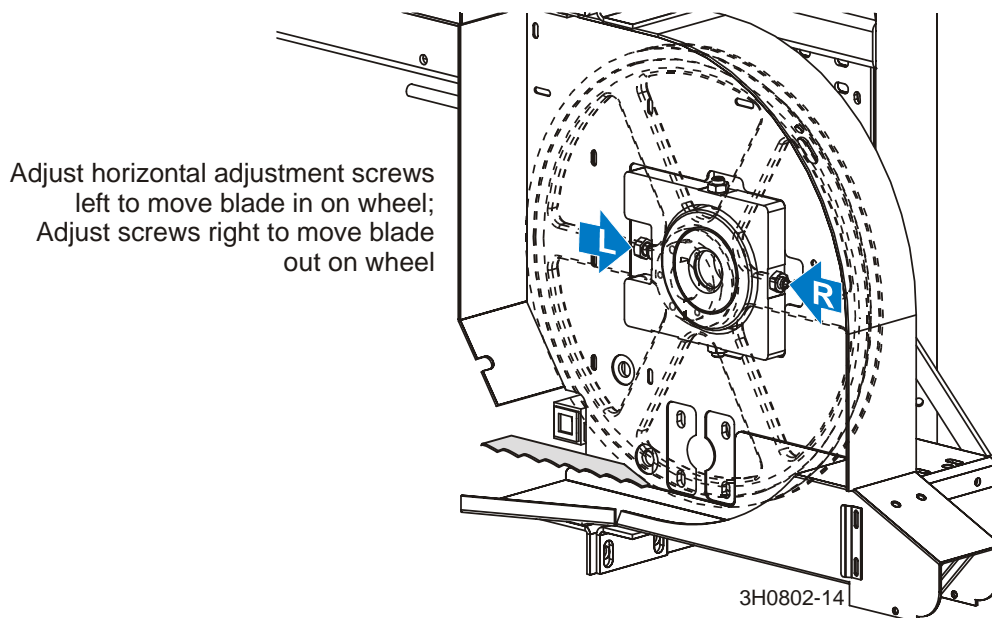


FIG. 7-22

7 Sawmill Alignment

Complete Alignment Procedure

LT25/LT27 rev. C7-D3:

See Figure 7-23. Use the horizontal adjustment bolts to adjust the horizontal alignment of the drive-side blade wheel. If the blade tracks too far back on the drive-side blade wheel, locate the long U-bolt on the right which mounts the bearing housing to the mounting plates. Loosen the hex nuts on the U-bolt (on the back side of the back plate). Loosen the jam nuts on the horizontal adjustment bolts. Tighten the adjustment bolts to spread the plates apart and bring the blade forward.

If the blade tracks too far to the front, loosen the jam nuts on the horizontal adjustment bolts and back the adjustment bolts out. Tighten the hex nuts on the long U-bolt (on the back side of the back plate).

Be sure to tighten all nuts against the mounting plates when the adjustment is complete.

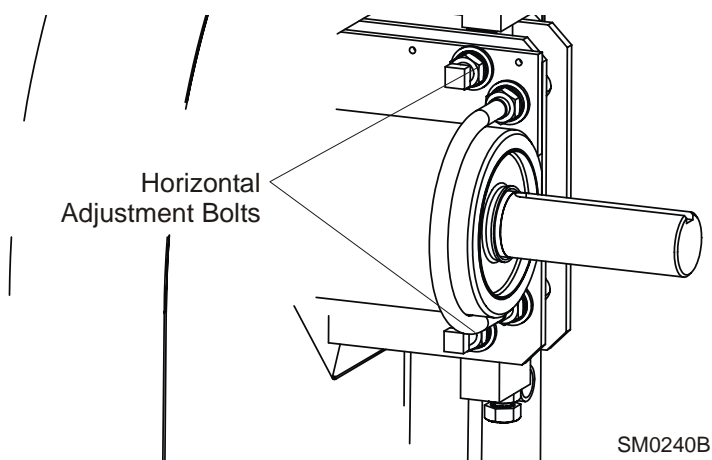


FIG. 7-23

Previous revisions:

To adjust the horizontal alignment of the drive-side blade wheel, locate the long U-bolt on the right which mounts the bearing housing to the mounting plates. Locate the jam nuts on the bolts between the two mounting plates. If the blade tracks too far to the front of the drive-side blade wheel, turn the jam nuts toward the bearing housing. If the blade is too far back, turn the nuts away from the bearing housing. Make sure to tighten the jam nuts against the mounting plates when the adjustment is complete.

Track Roller Adjustment

Making these adjustments correctly will insure the saw carriage travels smoothly along the track and blade will remain parallel with the bed frame.

1. Using the feed crank, move the saw carriage so that the blade is positioned over the front pivot end rail.

To adjust the bottom rollers (Sawmills prior to Rev. D6.00 only):

2. Check the lower roller on the bottom track rail. Make sure that the bottom rollers touch the bottom rail but remain loose enough that you can turn them with your finger. Use the vertical bolts to adjust the bottom track rollers.

See Figure 7-24. Tighten the vertical adjustment bolt to move the bottom rollers toward the track rail. Loosen the bolt to move the bottom rollers away from the track rail. Proceed to Step 4.

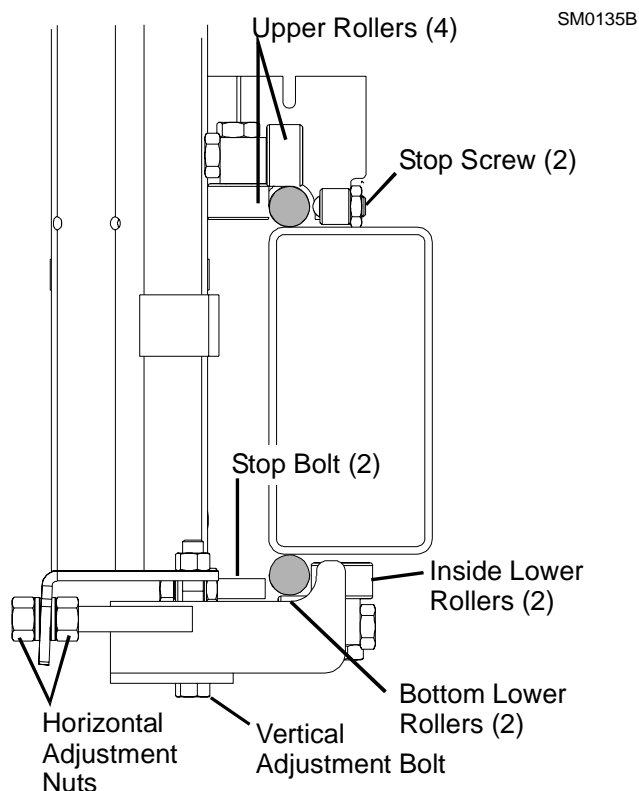


FIG. 7-24

7 Sawmill Alignment

Complete Alignment Procedure

To adjust the bottom stop blocks (Rev. D6.00+ only):

3. Check the lower stop blocks on the bottom track rail. Make sure that the stop blocks are adjusted $1/32$ "- $1/16$ " (.75mm - 1.5mm) from the track rail. Use the vertical bolts to adjust the stop blocks.

See Figure 7-25. Tighten the vertical adjustment bolt to move the stop block toward the track rail. Loosen the bolt to move the stop block away from the track rail.

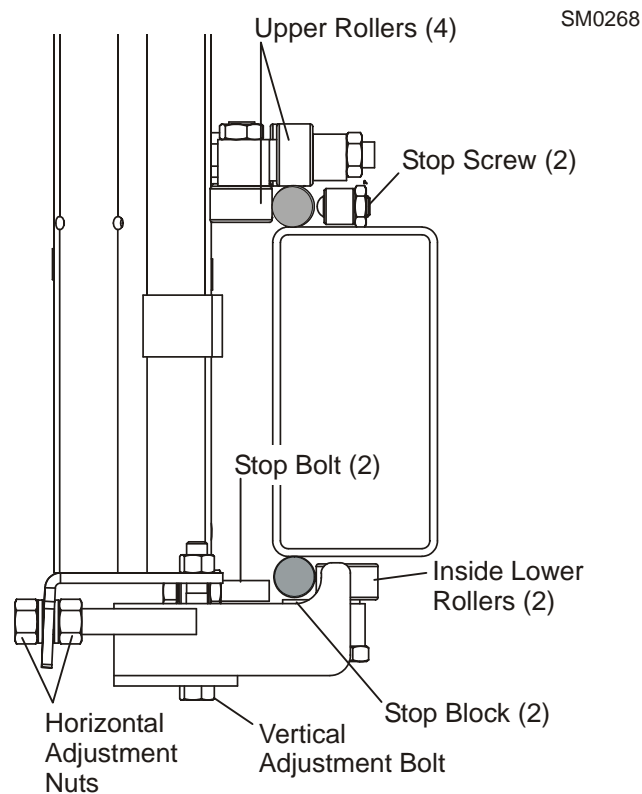


FIG. 7-25

4. Check the inside lower rollers. Both inside rollers should touch the rail so that you cannot spin them by hand. If the rollers are not adjusted evenly and you can spin one, adjust the horizontal adjustment nuts until the roller cannot be spun by hand. Stop adjusting before the other roller can be spun by hand. The two inside rollers should bear the weight of the saw carriage evenly.
5. Move the carriage forward until the blade is positioned over the rear pivot end rail. Repeat steps 2 & 3 until all lower rollers are adjusted properly at the front and rear of the sawmill.
6. Open the adjustable blade guide arm to within $1/2$ " (15 mm) of full open.
7. Move the carriage back to the front pivot end rail. Raise the cutting head until the bottom

of the blade is 17" (400 mm) above the outside of the pivot rail support by actual measurement with a tape or ruler.

See Figure 7-26.

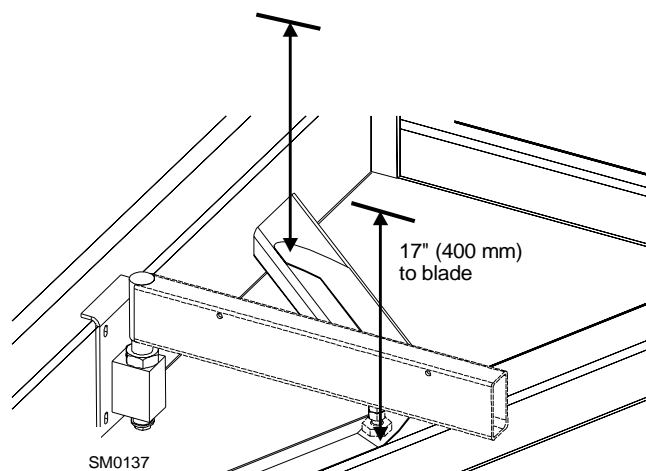


FIG. 7-26

8. Move the carriage forward to check the distance to the blade at the inside of the pivot rail support. All measurements should be equal within $1/32$ " (0.8 mm).

7 Sawmill Alignment

Complete Alignment Procedure

See **Figure 7-27**. To adjust the saw head tilt, use the horizontal adjustment nuts. To raise the outside of the saw head, loosen the four inner adjustment nuts 1/2 turn then tighten the four outer nuts. To lower the outside of the saw head, loosen the four outer adjustment nuts 1/2 turn then tighten the the inner nuts. Recheck the saw head tilt and readjust the nuts as necessary.

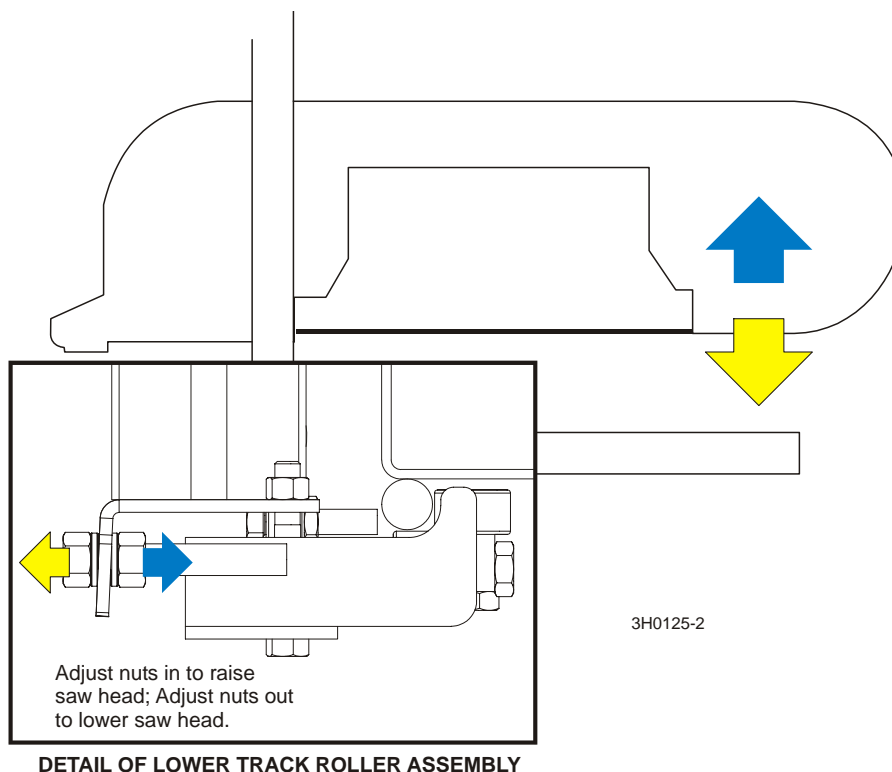


FIG. 7-27

9. After the lower track rollers are adjusted properly, adjust the upper and lower stop screws. Tighten each screw until it just touches the rail. Then, back the screw off 1/2 turn. The gap will be approximately 1/32" (0.8mm).



CAUTION! It is important that the lower stop bolts are properly adjusted to secure the carriage on the track rail. Failure to properly adjust the stop bolts can cause saw head damage, especially during mill transportation.

Bed Rail Adjustment

1. Install the log clamp at its lowest setting in a hole where the clamp is positioned 10" from the clamp stop (fourth hole from stop). Move the saw head until the blade is centered over the clamp. Raise the saw head until the blade measures 14 1/2" (360 mm) from the top of the clamp. Use a rule to determine the actual distance of the blade to the clamp.

See Figure 7-28.

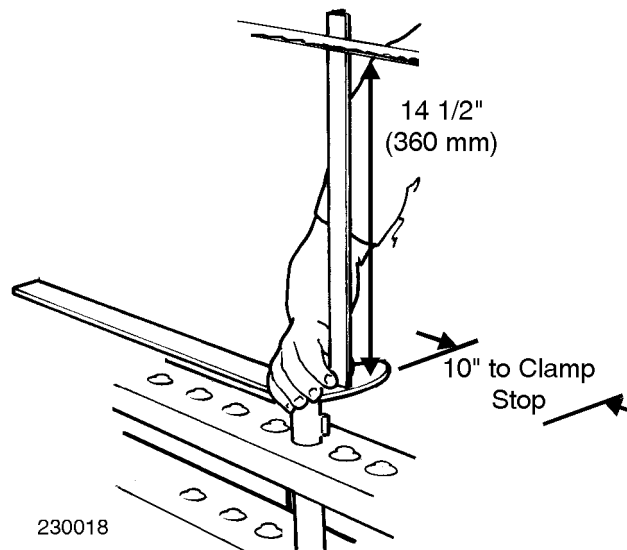


FIG. 7-28

2. Adjust the front pivot rail 90° to the main bed tube.
3. Move the saw head to center the blade over the front pivot bed rail.
4. Measure the distance from the top of the pivot rail to the bottom of the blade. Make this measurement at each end of the pivot rail.
5. The two measurements should be 15" (375 mm) (+1/32 [0.8 mm] -0).

7 Sawmill Alignment

Complete Alignment Procedure

See **Figure 7-29**. Loosen the locking set screws and turn the inner height adjustment nut to adjust the height of the inner end of the pivot rail. Loosen the jam nut and turn the outer adjustment bolt to adjust the height of the outer end of the pivot rail.

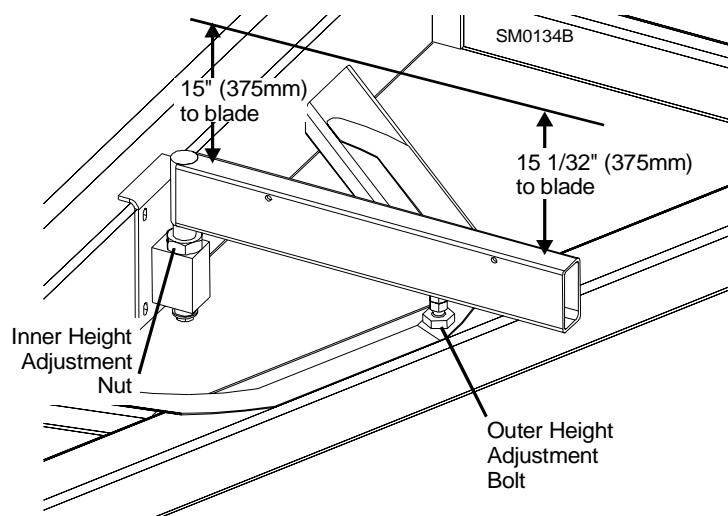


FIG. 7-29

6. Move the saw head so the blade is positioned over the center of the front main bed rail.
7. Measure the distance between the bottom of the blade and the bed rail at each end of the bed rail. The bed rail should measure 15" (375 mm) (+1/32 [0.8 mm] -0) from the blade at each end of the rail.

See **Figure 7-30**. Loosen the bed rail clamping bolts and turn the adjustment bolts to move the bed rails to the blade if necessary. Retighten the clamping bolts and adjustment bolt jam nuts.

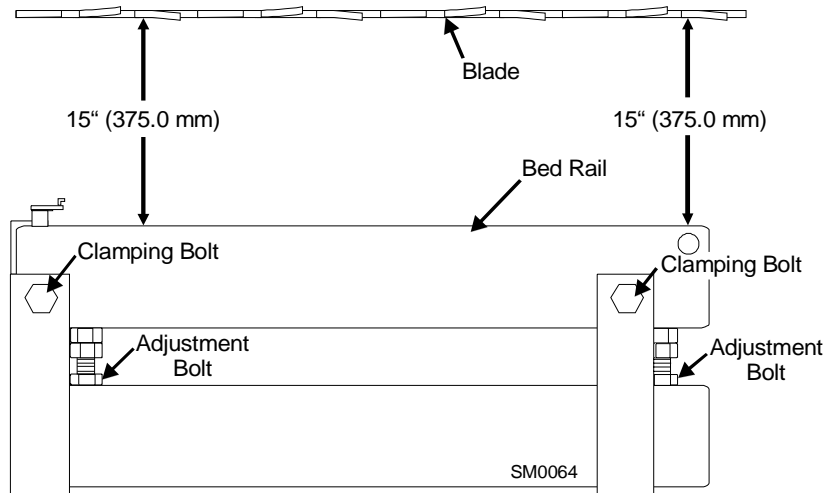


FIG. 7-30

- Without adjusting the saw head height, check the three remaining main bed rails and the rear pivot rail. Adjust them so that all measure the same distance from the blade at both ends of the bed rail.

7 Sawmill Alignment

Complete Alignment Procedure

Blade Guide Installation

Each Wood-Mizer sawmill has two blade guide assemblies that help the blade maintain a straight cut. The two blade guide assemblies are positioned on the saw head to guide the blade on each side of the material being cut.

One blade guide assembly is mounted in a stationary position on the drive side of the saw head. This assembly is referred to as the "inner" blade guide assembly.

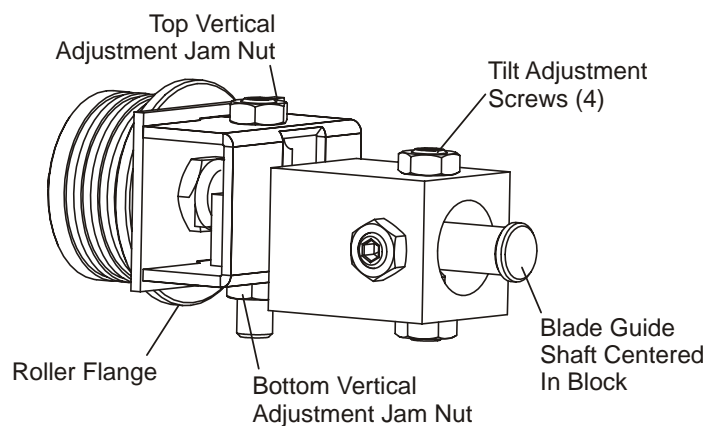
The other blade guide assembly is mounted on the idle side of the saw head. It is referred to as the "outer" assembly and is adjustable for various widths of materials to be processed.

NOTE: Before installing the blade guide assemblies, remove the blade guide adjusting screws and apply a lubricating oil such as 10W30 or Dexron III to each screw. This will prevent the screws and threaded holes from corroding and make screw adjustments easier.

1. Install the outer blade guide assembly (with waterlube tube) to the mounting block on the blade guide arm. Position the assembly so the roller flange is 1/8" (3.0 mm) from the blade.
2. Install the inner blade guide assembly to the mounting block on the saw head. Position the assembly so the roller flange is 1/16" (1.5 mm) from the blade.

See Figure 7-31.

Tighten the two previously-loosened tilt adjustment screws to secure the blade guide assembly. Loosen the top vertical adjustment jam nut and tighten the bottom vertical adjustment jam nut to adjust the blade guide roller up so it does not touch the blade.



3H0802-15

FIG. 7-31

Blade Guide Arm Alignment

The blade guide arm moves the outer blade guide in and out. If the arm becomes loose, the blade guide will not deflect the blade properly, causing inaccurate cuts. A loose blade guide arm can also cause blade vibration.

1. Adjust the blade guide arm in to 1/2" (15 mm) from fully closed.
2. Manually try to move the arm up and down. If you can move the arm by hand, you will need to tighten the arm rollers.

See Figure 7-32. Remove the blade housing cover to access the blade guide arm roller mounting bolts. The blade guide arm rollers are mounted on cam-shaped bolts. Turning the bolts will cause each roller to move up or down. If the inner lower roller is loose, adjust the inner top roller down. If the outer lower roller is loose, adjust the outer lower roller up. Retighten the jam nuts and recheck the tightness of the bottom rollers.

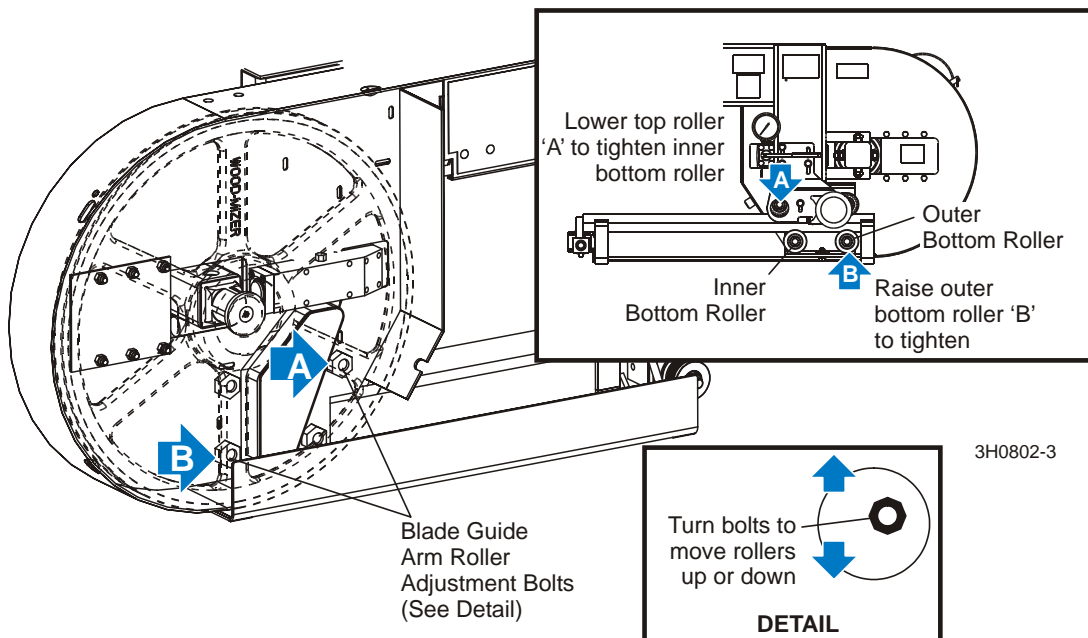


FIG. 7-32

7 Sawmill Alignment

Complete Alignment Procedure

After tightening the blade guide arm rollers, check that the arm is aligned properly.

3. With the arm adjusted 1/2" (15 mm) from fully closed, measure the distance between the blade guide roller flange and the back of the blade.

See Figure 7-33.

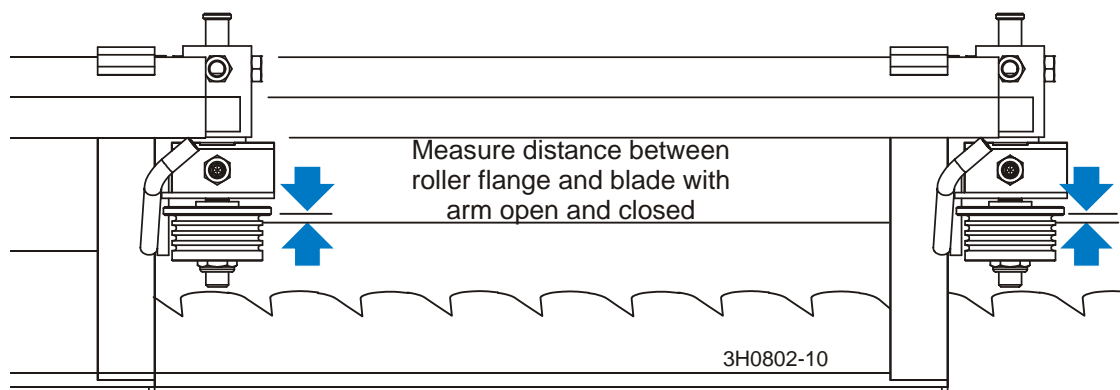


FIG. 7-33

4. Adjust the blade guide arm to 1/2" (15 mm) from fully open and remeasure the distance from the roller flange to the back of the blade. The two measurements should be the same. If not, adjust the inner rollers in or out to tilt the arm horizontally.

See Figure 7-34. To tilt the arm out away from the blade, loosen the front nuts on the inner rollers and tighten the rear nuts. To tilt the arm in toward the blade, loosen the rear nuts on the inner rollers and tighten the front nuts. Recheck the blade guide arm horizontal tilt.

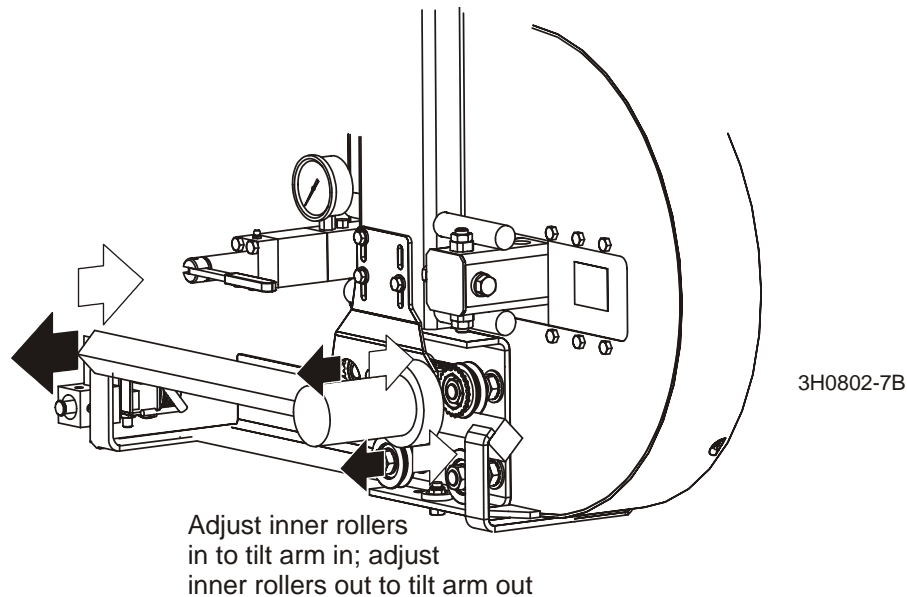


FIG. 7-34

5. Now check the vertical tilt of the blade guide arm. Move the saw carriage so the blade guide arm is positioned over a bed rail.
6. With the arm 1/2" (15 mm) from fully closed, raise or lower the saw head until the bottom of the blade guide block is 15" (375 mm) from the top of the bed rail.

7 Sawmill Alignment

Complete Alignment Procedure

See Figure 7-35. Adjust the blade guide arm to 1/2" (15 mm) from fully open. Measure the distance from the bottom of the blade guide mounting block to the bed rail. This measurement should be 15" (376.5 mm). If the measurements are not the same, adjust the outer rollers up or down to tilt the blade guide arm vertically.

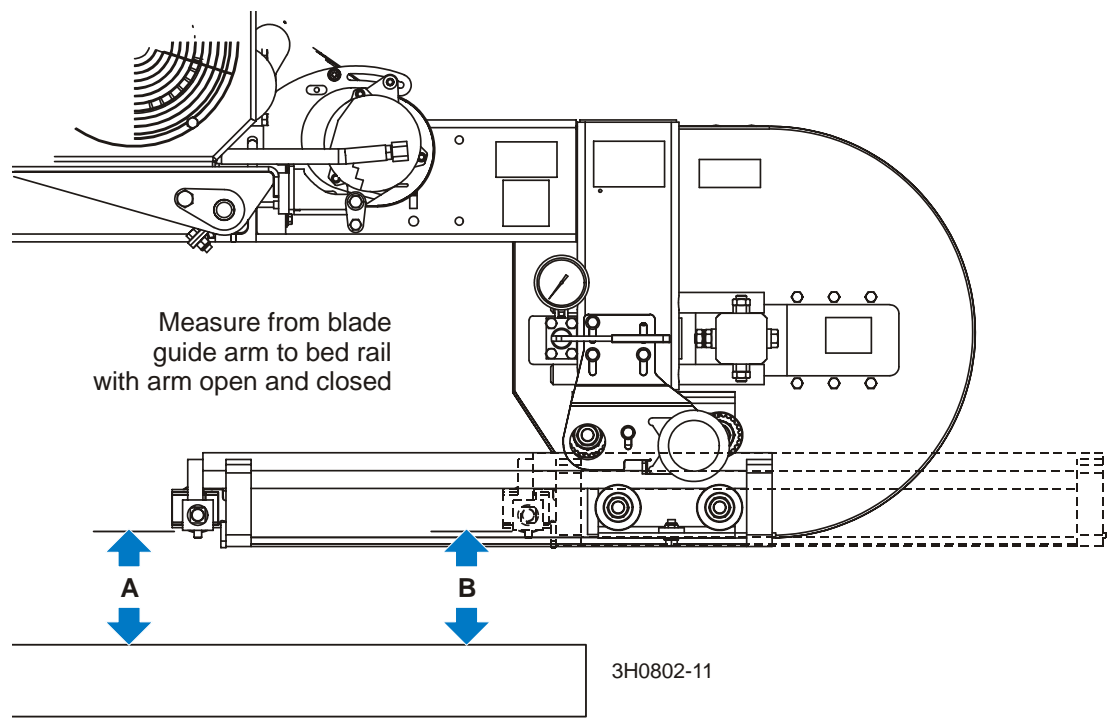


FIG. 7-35

See **Figure 7-36**. Remove the blade housing cover to access the blade guide arm roller mounting bolts. To adjust the rollers, loosen the jam nuts on the other side of the blade housing and turn the mounting bolts. To tilt the blade guide arm down, adjust the outer top and bottom rollers up. To tilt the blade guide arm up, adjust the outer top and bottom rollers down. Retighten the jam nuts and recheck the blade guide arm vertical tilt.

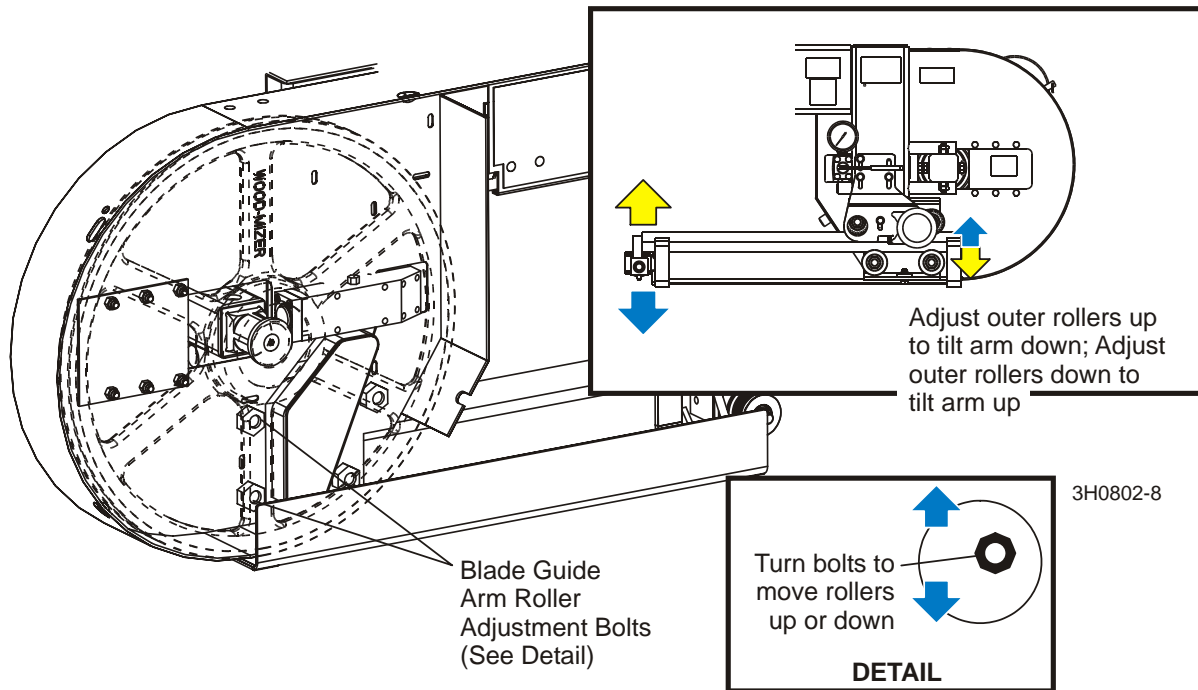


FIG. 7-36

7 Sawmill Alignment

Complete Alignment Procedure

Blade Guide Deflection

Perform the following steps to achieve proper blade deflection with the blade guides.

1. Raise the saw head until the blade is 15" (375 mm) above a bed rail. Measure the actual distance with a tape from the top of the rail to the bottom of the blade.
2. Make sure the two vertical adjustment set screws are threaded into the blade guide shaft until they touch each other.

See Figure 7-37.

Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down until the bottom of the blade measures 14 3/4" (370 mm) from the bed rail.

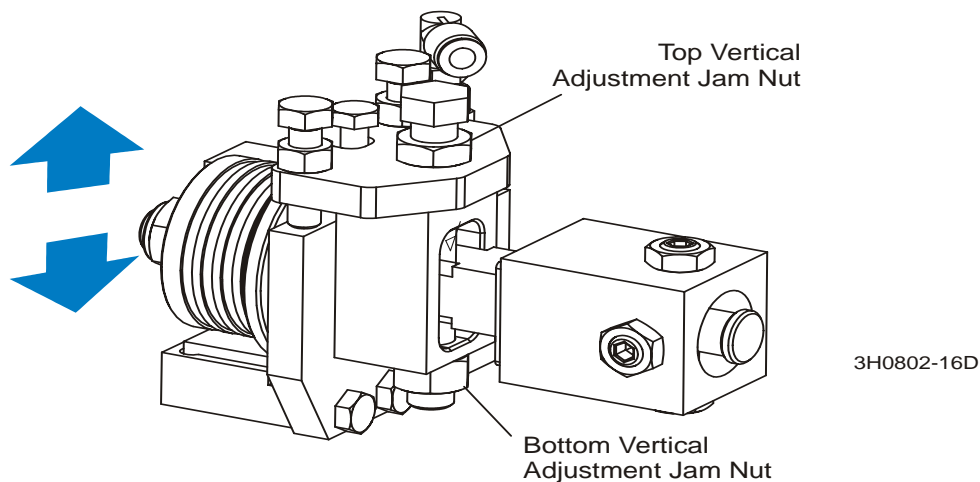


FIG. 7-37

3. Repeat for the other blade guide.

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

Blade Guide Vertical Tilt Alignment

The blade guides should be adjusted properly in the vertical plane. If the blade guides are tilted vertically, the blade will try to travel in the tilted direction.

A Blade Guide Alignment Tool (BGAT) is provided to help you measure the vertical tilt of the blade.

1. Open the adjustable blade guide arm 1/2" (15 mm) from full open.
2. Clamp the alignment tool on the blade. Position the tool close to the outer blade guide roller. Be sure the tool does not rest on a tooth or burr, and is lying flat on the blade.

See Figure 7-38.

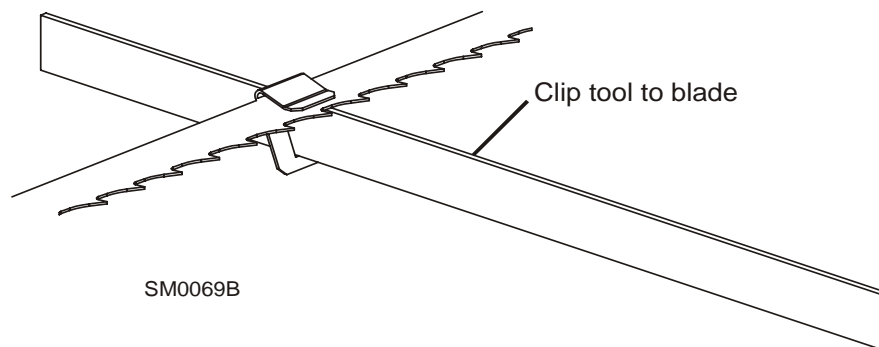


FIG. 7-38

3. Move the carriage so that the front end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.

NOTE: If the sawmill is equipped with stainless steel bed rail covers, be sure to measure from the blade guide alignment tool to the top surface of the cover rather than the bed rail tube.

4. Move the carriage so that the back end of the tool is positioned above the bed rail. Measure the distance from the bed rail to the bottom edge of the tool.
5. If the measurement from the tool to the bed rail is not equal within 1/32" (.75 mm), adjust the vertical tilt of the outer blade guide roller.
6. Loosen one set screw at the side of the blade guide assembly.

7 Sawmill Alignment

Complete Alignment Procedure

See **Figure 7-39**. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten top screw. To tilt the roller down, loosen the top screw and tighten the bottom screw. Tighten the jam nuts and recheck the tilt of the blade.

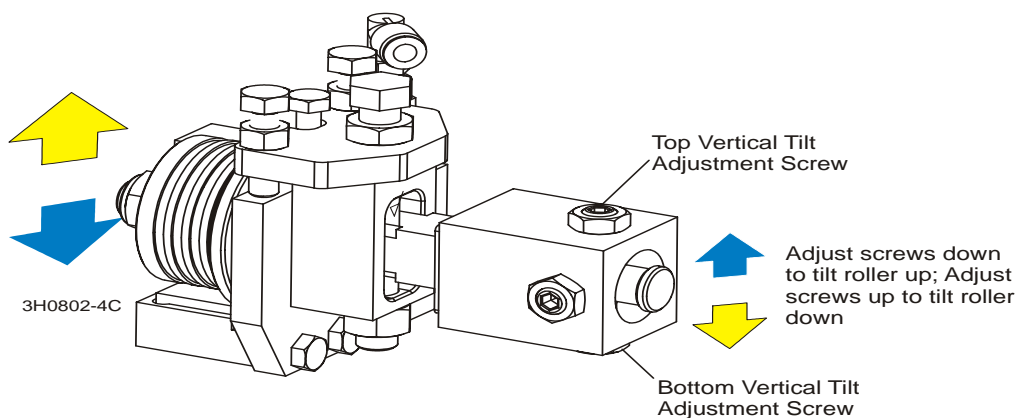


FIG. 7-39

7. Move the blade guide alignment tool close to the inner blade guide roller assembly and repeat the above steps. Adjust the vertical tilt of the inner blade guide if necessary.
8. After adjusting the vertical tilt of the blade guides, recheck the blade deflection and adjust if necessary.

Blade Guide Horizontal Tilt Adjustment

If the blade guides are tilted in the wrong direction horizontally, the back of the blade may contact the flange as the roller is spinning down, causing it to push the blade away from the guide roller.

1. Remove the blade guide alignment tool from the blade and adjust the blade guide arm halfway in.
2. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

See Figure 7-40.

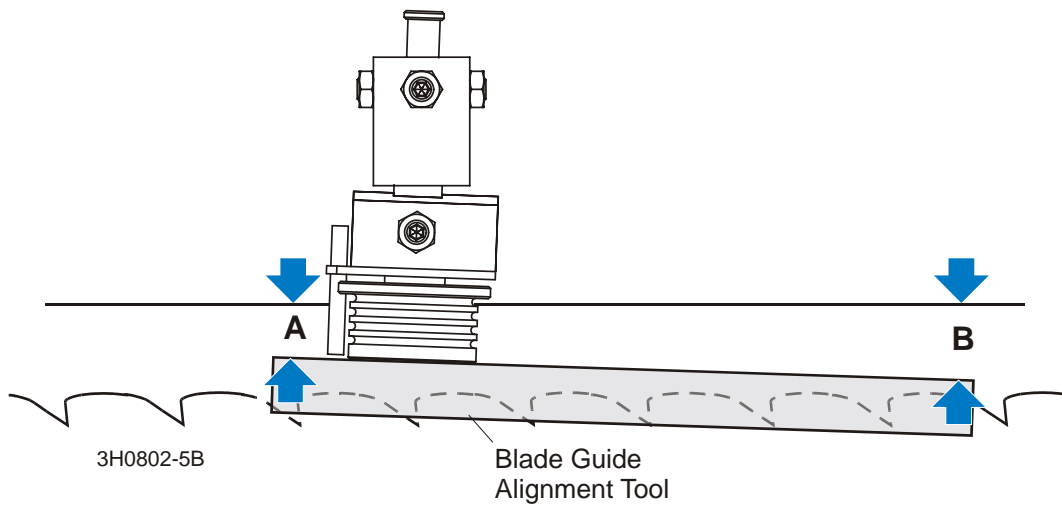


FIG. 7-40

3. Measure between the back edge of the blade and the tool at the end closest to the inner blade guide ("B").
4. Measure between the back edge of the blade and the other end of the tool ("A").

The roller should be tilted slightly to the left ('A' 1/8" [3 mm] less than 'B' \pm 1/8" [3 mm]).

7 Sawmill Alignment

Complete Alignment Procedure

See Figure 7-41. Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the right screw. Tighten the jam nuts and recheck the tilt of the blade.

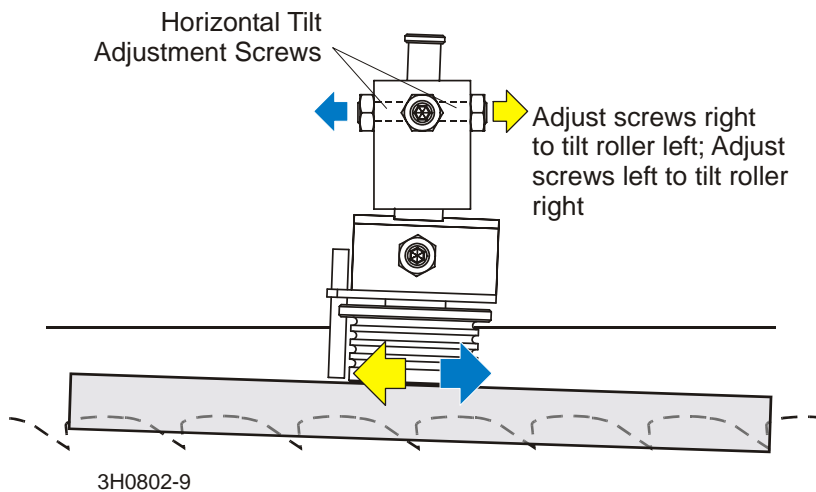


FIG. 7-41

5. Repeat the above steps for the inner blade guide roller assembly.

NOTE: Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade. [See Blade Handbook, Form #600.](#)

Blade Guide Flange Spacing

Each blade guide must be adjusted so the roller flange is the correct distance from the back edge of the blade. If the flange is too close to or too far from the blade, the sawmill will not cut accurately.

HINT: When adjusting blade guide spacing, loosen the top set screw and one side set screw only. This will ensure horizontal and vertical tilt adjustments are maintained when the adjustment screws are retightened.

1. Measure the distance between the flange on the inner blade guide roller to the back edge of the blade. This distance should measure 1/16" (1.5 mm). Adjust the roller back or forward if necessary.

See Figure 7-42. Loosen the top and one side screw shown. Tap the blade guide forward or backward until properly positioned. Retighten the screws and jam nuts.

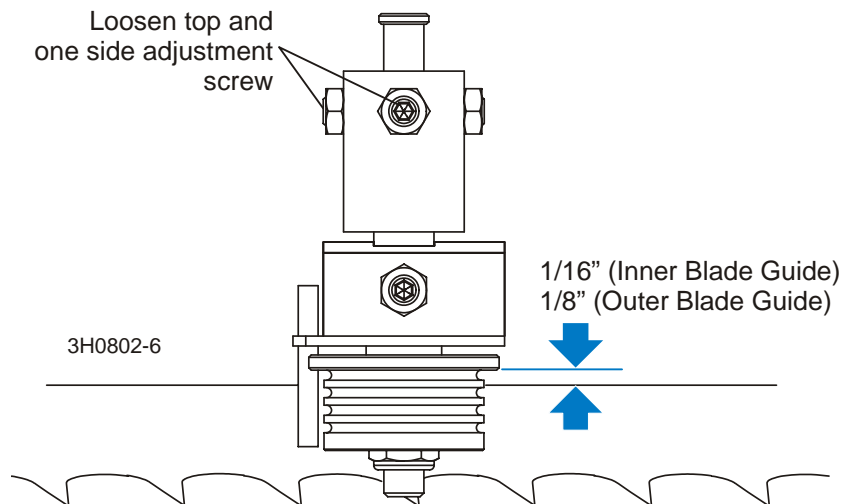


FIG. 7-42

2. Measure the distance between the flange on the outer blade guide roller to the back edge of the blade. This distance should measure 1/8" (3.0 mm). Adjust the roller back or forward if necessary.

7 Sawmill Alignment

Complete Alignment Procedure

Side Support Alignment

Logs and boards are clamped against the side supports when sawing. The side supports must be square to the bed to ensure square lumber.

1. Swing a side support down and measure between the face of the support and the main bed tube. The distance at the top of the side support ('B') should be equal to or no more than 1/32" (0.8 mm) greater than the distance at the base of the side support ('A'). Adjust the horizontal tilt of the side support if necessary.

See Figure 7-43. Loosen the two adjustment plate mounting bolts. Use a mallet to move the plate until the side support is parallel to the bed tube in the horizontal position. Retighten the mounting bolts.

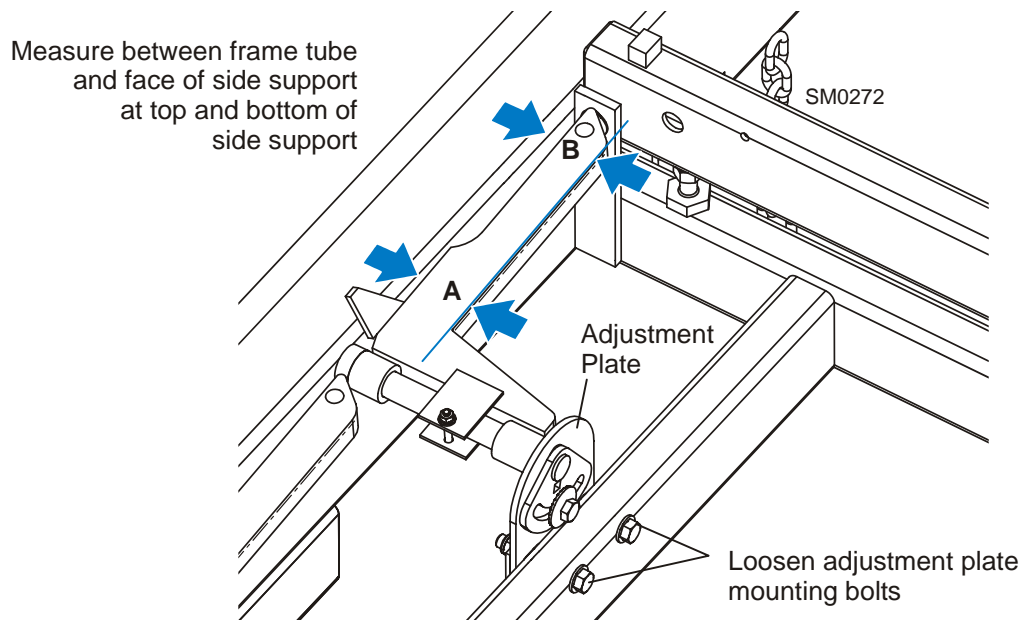


FIG. 7-43

2. Repeat the horizontal check for the remaining side supports. Adjust as necessary.
3. Place square alignment tubes (Part No. S12831 - 2 required) across the bed rails. Swing a side support up so that it is vertical.
4. Pull back at the top of the support to eliminate slack as if a log were being clamped against it.
5. Place a square against the face of the side support. The side support should be square or slightly tilted forward 1/32" (0.8 mm). Adjust the vertical tilt of the side support if necessary.

See Figure 7-44. Loosen the side support mounting bolt. If the side support mounting pin is equipped with a square hole (after 6/00), use a 3/8" ratchet to rotate the pin until the side support is square to the bed. For previous side supports, use a mallet to move the side support.

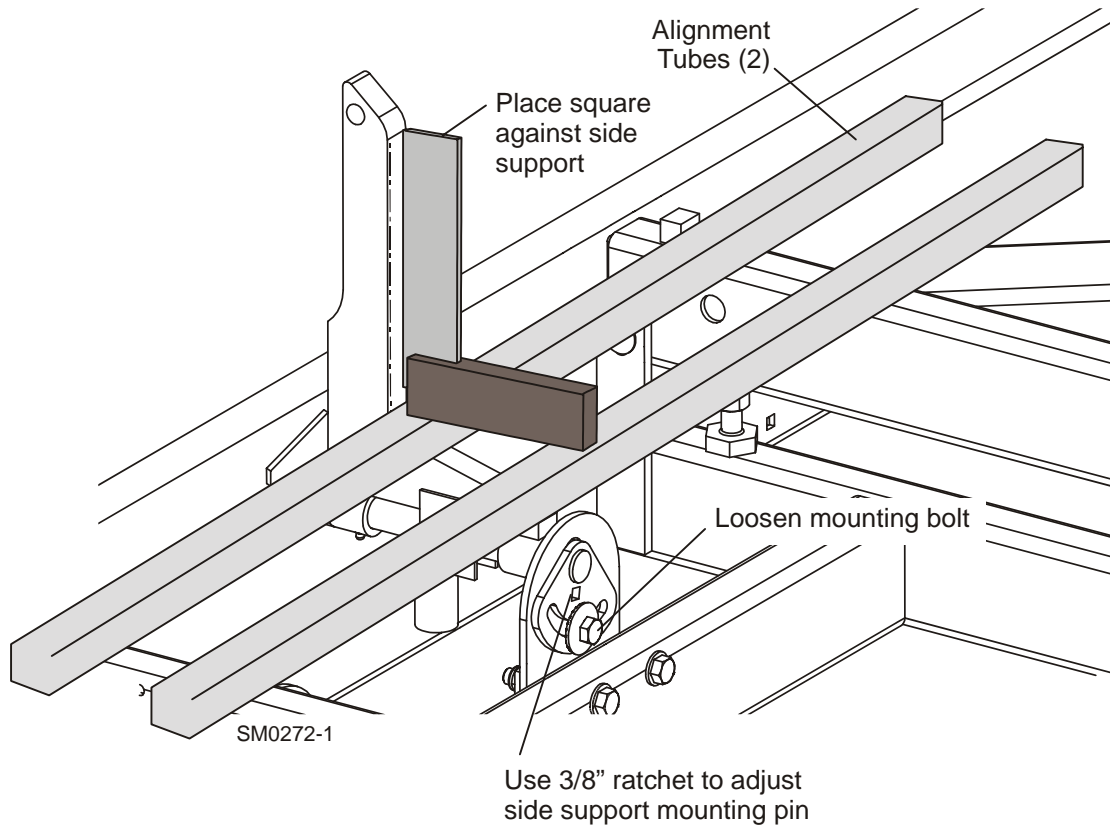


FIG. 7-44

6. Repeat the vertical check for the remaining side supports and adjust as necessary.

7 Sawmill Alignment

Complete Alignment Procedure

Clamp Stop/Stop Bolt Adjustment

1. Once the side supports are aligned, pivot them down to their horizontal position.
2. Tie a string to the stop block at the first bed rail. Stretch the string toward the rear of the frame and tie to the stop block at the last bed rail.

See Figure 7-45. Loosen the clamp stop bolts and adjust the clamp stop until it touches the string. Loosen the jam nut and adjust the bolt on the middle-rear bed rail until it touches the string.

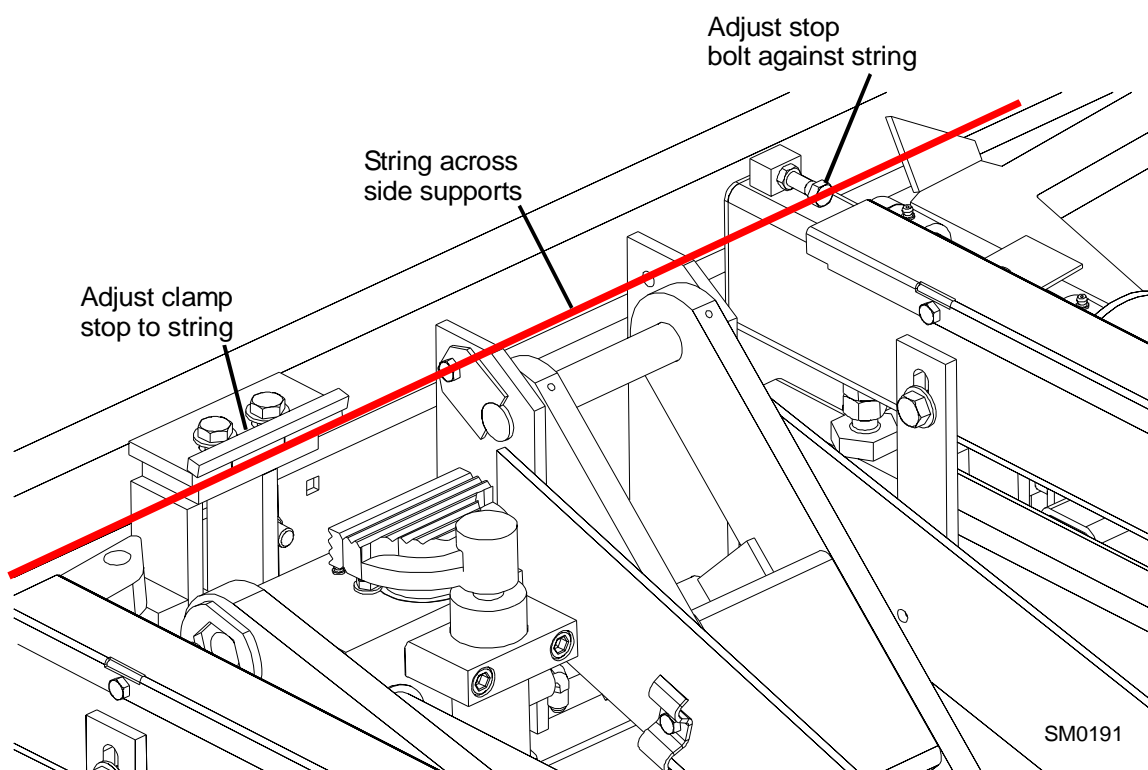


FIG. 7-45

Saw Head Tilt

As the blade enters a wide log or cant, the outside of the saw head will drop down slightly. To compensate for the drop, the saw head is adjusted $1/16"$ (1.5 mm) higher at the outside.

1. Move the saw carriage so the blade is positioned over a bed rail. Adjust the blade guide arm to $1/2"$ (15 mm) from full open. The saw head should still be adjusted so the blade is $14\ 3/4"$ (375 mm) above the bed rails.

See Figure 7-46.

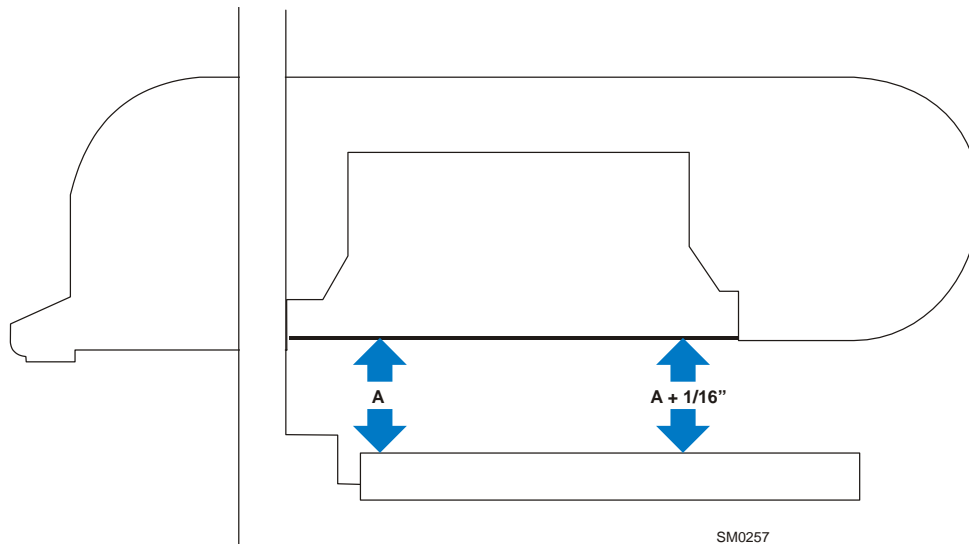


FIG. 7-46

2. Measure from the blade to the bed rail near the outer blade guide assembly. This measurement should be $1/16"$ (1.5 mm) higher than the inner measurement.

7 Sawmill Alignment

Complete Alignment Procedure

See Figure 7-47. To adjust the saw head tilt, use the horizontal adjustment nuts. To raise the outside of the saw head, loosen the four inner adjustment nuts 1/4 turn and tighten the four outer nuts. Recheck the measurement from the blade to the bed rails and adjust the horizontal adjustment nuts until the outside of the saw head is 1/16" higher than the inside.

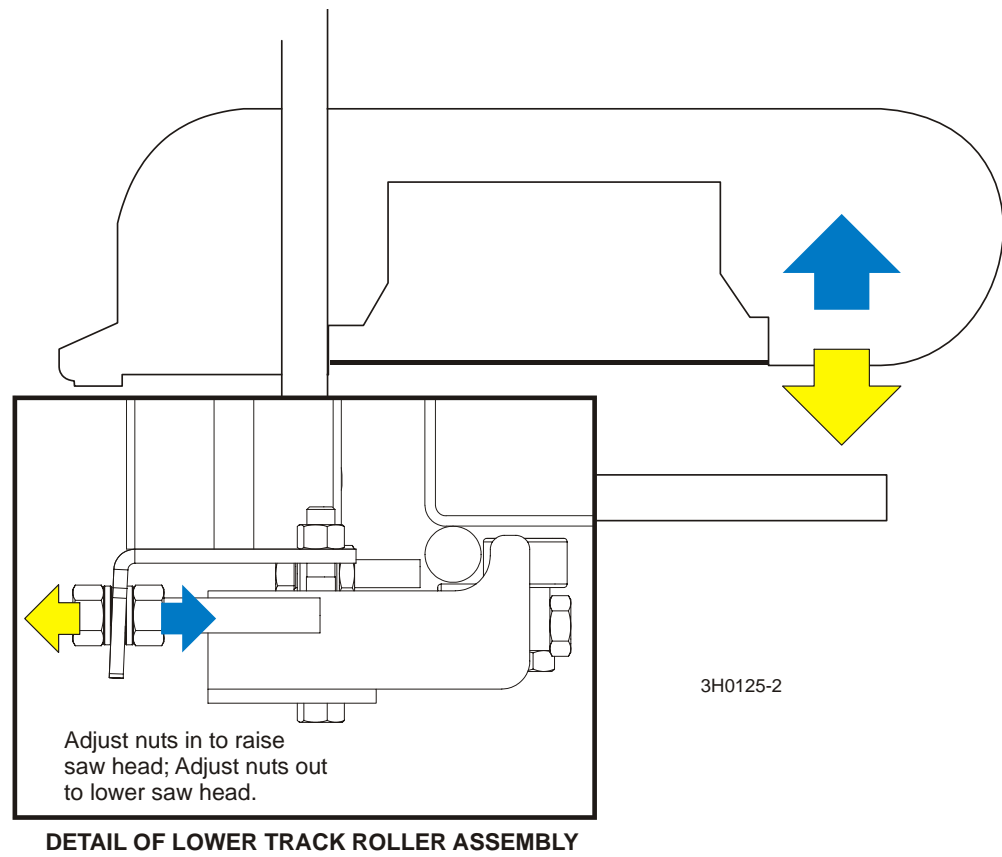


FIG. 7-47

Blade Height Scale Adjustment

After the entire sawmill has been aligned and all adjustments made, check that the blade height scale indicates the true distance from the blade to the bed rails.

1. Move the saw carriage so the blade is positioned directly above one of the bed rails. Measure from the bottom edge on a down-set tooth of the blade to the top of the bed rail (or stainless steel sleeve if applicable), near the inner blade guide assembly.
2. View the blade height scale with eyes level with the indicator. The scale should indicate the actual distance from the blade to the bed rail. Adjust the indicator if necessary.

See Figure 7-48. Loosen the indicator bracket mounting bolts. Adjust the bracket up or down until the indicator is aligned with the correct mark on the scale (+0 -1/32 [0.8 mm]). Retighten the bracket mounting bolts.

For example, if the measurement from the down-set tooth of the blade to the bed rail was 14 3/4" (375 mm), make sure the indicator reads 14 3/4" (375 mm) on the scale.

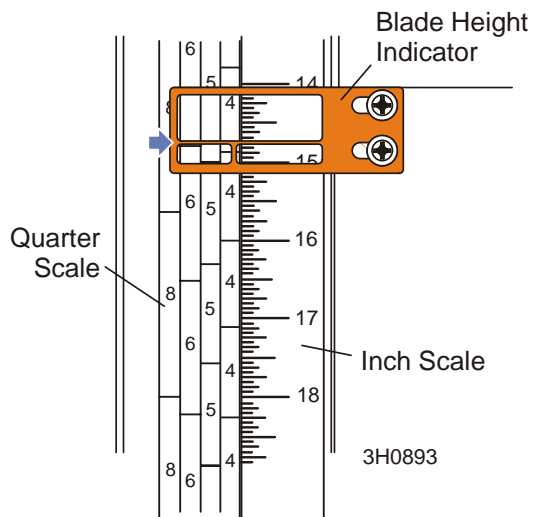


FIG. 7-48

INDEX

A

alignment

- lower track rollers 7-27
- main bed rails 7-31
- slide pad adjustment 7-27

B

blade

- breakage, troubleshooting 6-1
- installation 3-7
- tensioning 3-8
- tracking 3-9

blade guide arm

- operation 4-4

C

chain

- maintenance 5-8
- up/down tension 5-20

clutch/brake lever

- operation 4-5

L

leveling logs 4-2

loading logs 4-1

M

maintenance

- blade guide 5-2
- blade tensioner 5-9
- blade wheel belts 5-10, 5-11
- brake adjustment 5-12
- brake strap 5-12
- carriage track/wipers 5-5
- drive bearing 5-18
- drive belt 5-14
- feed rope 5-22
- mast rails 5-6, 5-7
- miscellaneous 5-8
- part wear life 5-1
- sawdust removal 5-4
- up/down 5-20

O

operation

- edging 4-11
- sawing 4-9

S

safety

- lockout procedure 2-12

scale

- blade height operation 4-12
- inch height 4-13
- quarter inch 4-14

service information

- branch locations 1-5
- customer & sawmill ID 1-2
- general contact info 1-4

setup

- portable sawmill 3-3
- stationary sawmill 3-1, 3-3

T

tensioner

 maintenance 5-9

troubleshooting 6-1

 sawing problems 6-1

turning logs 4-2

U

up/down

 operation 4-3

W

water lube

 operation 4-15