



## user manual

Instrukcja obsługi | Руководство пользователя  
Manuel de l'Utilisateur | Betriebsanweisung  
Bruksanvisning | Manual del Usuario  
Betjeningsvejledning | Gebruikershandleiding  
Käyttöohjeet | Manual de utilizare | Bruksanvisning  
Manuale d'uso | Příručka uživatele | Navodila  
za uporabo

Retain for future use  
Zachować do przyszłego użytku  
Сохраните для последующего  
использования  
A conserver pour une utilisation future  
Für zukünftige Benutzung aufbewahren  
Behold for senere bruk  
Säilytä nämä käyttöohjeet tulevaa tarvetta marten  
Opbevar manualen til fremtidig brug  
Bewaren voor gebruik in de toekomst  
Conservare il presente manuale a l'uso futuro  
Păstrați acest manual pentru utilizare viitoare  
Conservar para futuras consultas  
Behall för framtida användning  
Uchovejte pro další použití  
Hranite za prihodnjo uporabo



# **Wood-Mizer®**

## **Safety, Setup, Operation & Maintenance Manual**

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<b>LX50 Start EH5S</b>	<b>rev.B1.00</b>
<b>LX50 Start G9S</b>	<b>rev.B1.00</b>

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

*Form #818*

**This is the original language  
for the manual**

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## SECTION 1 SAFETY INSTRUCTIONS


### 1.1 Safety symbols

These symbols 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 to persons or equipment.

 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.

Before operating the sawmill, read the operator's manual and all additional manuals provided with the machine. Observe all safety instructions included in these manuals.

Always be sure that all safety decals are clean and readable. Replace immediately all damaged safety decals to prevent personal injury or damage to the equipment. Contact Wood-Mizer Customer Service or Wood-Mizer distributor in your area to order a new decal.

**IMPORTANT!** It is always LX50 Start sawmill owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership, operation and transport of your sawmill. All Wood-Mizer owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the sawmill.

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

Safety instructions are listed in this section by the following operations:

- Blade Handling,
- Sawmill Setup,
- Sawmill Operation,
- Sawmill Maintenance.

## 1.2 Blade Handling



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



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

## 1.3 Sawmill Setup



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

**WARNING!** Keep all persons away from area while loading and unloading the sawmill. Failure to do so may result in serious injury or death.

## 1.4 Sawmill Operation



**IMPORTANT!** The sawmill is intended for sawing wood only. [See Section Cutting Capacity](#) for log size capacities of the machine.

**IMPORTANT!** The operator of the sawmill should get the adequate training in operation and adjustment of the machine.



**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.

**DANGER!** Be sure the blade housing is in place and secured.

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

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

**DANGER!** Maintain a clean and clear path for all necessary movement around the sawmill and lumber stacking areas. failure to do so may 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 may result in serious injury.

**WARNING!** Always wear eye, ear, respiration and foot protection as well as safety clothing when operating or servicing the machine. Failure to do so may result in serious injury.



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

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

**WARNING!** Use ONLY water or alcohol solution 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.



**CAUTION!** Be sure the log clamps are in all the way down before loading a log onto the bed. Failure to do so may result in machine damage.

**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!** Do not try to force the saw head beyond its upper and lower travel limits. Failure to do so may result in damage to the up/down system.

**CAUTION!** Be sure to stop the blade before returning the saw head. 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.

**CAUTION!** If optional loading ramps are used to load a log onto the sawmill bed, remove them from the brackets on the bed frame before sawing. The saw head may hit the ramp stops when adjusted for low cuts and get damaged.



**CAUTION!** Never clean the blade or blade wheels with a brush or a scraper during sawmill operation.

**CAUTION!** Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.

**CAUTION!** The blade should be replaced every two hours of sawmill operation.

**CAUTION!** Always wear gloves when handling the blade. Never grab the blade with bare hands.

**CAUTION!** If the blade breaks during sawmill operation, push the EMERGENCY STOP button to stop the blade engine/motor and wait 10 seconds before you open the blade housing cover.

**CAUTION!** The sawmill's work-stand should be equipped with a 4 kg or bigger dry powder extinguisher.

## 1.5 Refueling



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

## 1.6 Gas Engine Operation



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

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

**DANGER!** Engine components can become very hot during operation (especially exhaust engine components). Avoid contact with any part of a hot engine. 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 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.



**DANGER!** Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine. 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!** Do not operate the engine without proper and operational spark arrester/muffler. Sparks emitted from the engine exhaust could ignite surrounding materials, causing serious injury or death.

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

**WARNING!** Always wear proper and necessary safety equipment when performing service functions. Proper safety equipment includes eye protection, breathing protection, hand protection and foot protection.



**IMPORTANT!** Always dispose of coolant, oil, fuel, oil filters and fuel filters in a responsible manner and in accordance with local, state and federal regulations.



**WARNING!** Always disconnect the sawmill battery cables before servicing.



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

### 1.7 Sawmill Maintenance



**CAUTION!** Reinstall the track wiper so that it lightly touches the track rail. If the wiper presses too firmly against the rail, it can cause the forward/reverse movement to bind.

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

### 1.8 Safety Instructions

**NOTE:** ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding 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 the machine at all times, regardless of ownership.

Also read all additional manuals that you received with the machine (such as: engine/motor manual) and observe safety instructions included in these manuals.

**IMPORTANT!** Only adult 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 the children.

**IMPORTANT!** It is always owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership and operation of your Wood-Mizer sawmill.

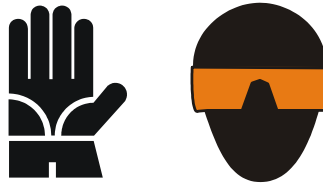


## Wear Safety Clothing



**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 as well as safety clothing when operating or servicing the sawmill.



## Keep Sawmill and Area Around Sawmill Clean



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

## Dispose Of Sawing By-Products Properly



**IMPORTANT!** Always properly dispose of all sawing by-products, including sawdust and other debris.

## Check Sawmill Before Operation



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



### Keep Persons Away



**DANGER!** Keep all persons out of the path of moving equipment and lumber when operating the sawmill. Failure to do so may result in serious injury.

**DANGER!** Always be sure all persons are out of the path of the blade before starting the engine/motor. Failure to do so may result in serious injury.



**WARNING!** Allow the blade to come to a complete stop before opening the blade housing cover. Failure to do so may result in serious injury.

### Keep Hands Away



**DANGER!** Always shut off the blade engine/motor before changing the blade. Failure to do so may result in serious injury.

**DANGER!** Engine components can become very hot during operation. Avoid contact with any part of a hot engine. 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 may 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!** Use extreme caution when spinning the blade wheels by hand. Make sure your hands are clear of the blade and wheel spokes before spinning. Failure to do so may result in serious injury.



## Use Proper Maintenance Procedures



**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!** Hazardous voltage inside the electric boxes 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 sawmill operation.



**WARNING!** Consider all electrical circuits energized and dangerous.

**WARNING!** Disconnect and lock out power supply before servicing the sawmill! Failure to do so may result in serious injury.

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



**DANGER!** Never clean the blade or blade wheels with a brush or a scraper during sawmill operation.



**NOTE!** Before installation of the blade, inspect it for damage and cracks. Use only properly sharpened blades. Always handle the blade with extreme caution. Use suitable carrier equipment for transporting the blades.

## Keep Safety Labels in Good Condition.



**WAŻNE!** Always be sure that all safety decals placed on the machine are clean and readable. Replace all damaged safety decals to prevent personal injury or damage to the machine. Contact your local distributor or call Wood-Mizer Customer Service to order more decals.

**IMPORTANT!** When replacing any component having a safety decal affixed, be sure to place an identical safety decal on the new component.

# 1

## Safety Instructions

Keep Safety Labels in Good Condition.

See table 1-1. See the table below for descriptions of the pictographic warning and informational decals placed on the LX50 Start sawmill.

**TABLE 1-1**

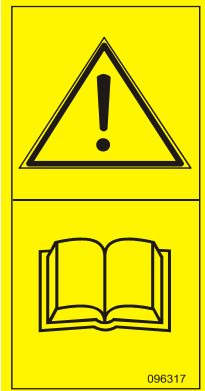

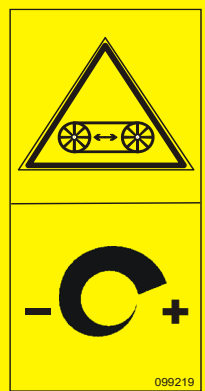

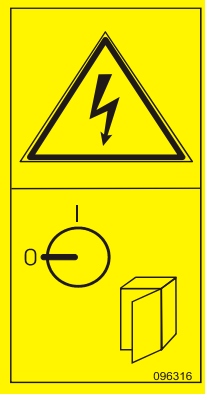
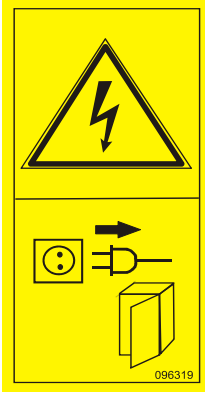
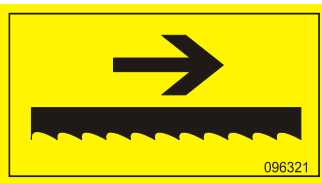
Widok nalepki	Nr nalepki	Opis
	096317	CAUTION! Read thoroughly the operator's manual before operating the sawmill. Observe all safety instructions and rules when operating the machine.
	099220	CAUTION! Close all guards and covers before starting the machine.
	099219	Blade tension. Turning the bolt clockwise will increase the blade tension and turning the bolt counterclockwise will decrease the tension.

TABLE 1-1

	<p>099221</p>	<p>CAUTION! Keep all persons away from work area when operating the machine.</p>
	<p>096316</p>	<p>CAUTION! Do not open or close the electric box when the switch is not in the "0" position.</p>
	<p>096319</p>	<p>CAUTION! Disconnect power supply before opening the box.</p>
	<p>096321</p>	<p>Blade movement direction.</p>

# 1

## Safety Instructions

Keep Safety Labels in Good Condition.

TABLE 1-1



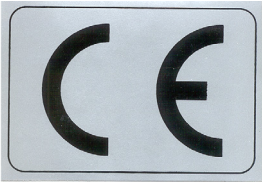


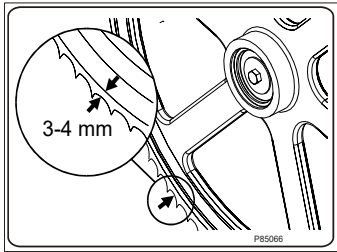
 <p>A blue circular icon with a white silhouette of a person wearing safety goggles. The icon is labeled 'S12004G' in the bottom right corner.</p>	<p>S12004G</p>	<p>CAUTION! Always wear safety goggles when operating the sawmill!</p>
 <p>A blue circular icon with a white silhouette of a person wearing protective ear muffs. The icon is labeled 'S12005G' in the bottom right corner.</p>	<p>S12005G</p>	<p>CAUTION! Always wear protective ear muffs when operating the sawmill!</p>
 <p>A blue circular icon with a white silhouette of a safety boot. The icon is labeled '501465' in the bottom right corner.</p>	<p>501465</p>	<p>CAUTION! Always wear safety boots when operating the sawmill!</p>
 <p>A red circular icon with a black silhouette of a hand holding a spray nozzle, indicating a lubrication point. The icon is labeled '501467' in the bottom right corner.</p>	<p>501467</p>	<p>Lubrication point.</p>
 <p>A technical diagram showing two views of a saw blade and its wheels. The top view shows the blade with an upward arrow and a clockwise rotation arrow. The bottom view shows the blade with a downward arrow and a counter-clockwise rotation arrow. The diagram is labeled 'P11789b' in the bottom right corner.</p>	<p>P11789</p>	<p>Tracking the blade on the blade wheels.</p>

TABLE 1-1

	<p>P85070</p>	<p>CE certification marking.</p>
	<p>eac</p>	<p>Russian safety certification.</p>
	<p>S20097</p>	<p>Motor rotation direction.</p>
	<p>P85066</p>	<p>Blade positioning.</p>

## 1.9 Belt Sizes

See table 1-2. Belt sizes for the LX50 Start sawmill are shown below.

Description	Belt size
Drive-side blade wheel belt G9	BX72 CONTITECH
Drive-side blade wheel belt EH5	B69 CARLISLE SUPER II
Idle-side blade wheel belt	B47.5 <sup>1</sup>

TABLE 1-2

<sup>1</sup> To insure proper blade tracking, use Goodyear, Dayco Super II or Browning belts only.

## 1.10 Blade Sizes

See table 1-3. Wood-Mizer offers three types of blade for all models of sawmill to provide efficient sawing. The engine/motor size of your sawmill and type of wood you saw should determine which blade you choose for optimum performance.

Engine/motor size	Recommended Blade for Sawing:	
	Thickness	Length
EH5S/G9	0,90mm (0.035")	3340 mm (131,5")
	1 mm (0.039")	
	1,07 mm (0.042")	
	1,14mm (0.045")	

TABLE 1-3

See the *Blade Handbook* for blade hook angle, tooth height and tooth set specifications.

## 1.11 Cutting Capacity

See table 1-4. The log size capacities of the LX50 Start sawmill are listed below.

	Maximum diameter	Maximum length
LX50 Start	60 cm	3,2 m

TABLE 1-4

## 1.12 Engine/Motor Specifications

See table 1-5. The power options available for the LX50 Start sawmills are listed below.

Engine/Motor Type	Manufacturer	Model Number	Other Data
Electric Motor, EH5S, 4kW	Indukta, Polska	3SIE100L2A	3 x 400V, 50 Hz, 7,7 A
Electric Motor, EH5, 4kW	Indukta, Polska	3SIE100L2A	3 x 400V, 50 Hz 7,7 A

TABLE 1-5

See table 1-6. Specifications of power supply for the LX50 START E5 sawmill are given in the table below.

3-Phase V	Circuit Breaker	Recommended Wire Size
400 VAC	8 A	2,5 mm <sup>2</sup> Maximum length: 15 m

TABLE 1-6



**DANGER!** It is recommended that a 30mA Ground Fault Interrupter (GFI) be used.

See table 1-7. See the table below for specifications of the engine used on the LX50 Start, LX50 StartG7/G13 sawmills.

Engine	Manufacturer	Model Number	Other Data
G9 Gas Engine	Kohler	PA-CH395-3209	9 KM

TABLE 1-7

## 1.13 Noise Level

See table 1-8. The average level of noise generated by the LX50 sawmill is given in the table below<sup>12</sup>.

Sawmill	Level noise
LX50 Start E5	L <sub>pA</sub> = 84 dB (A); L <sub>WA</sub> = 100 dB (A)
LX50 Start G9	L <sub>pA</sub> = 96 dB (A); L <sub>WA</sub> = 112 dB (A)

TABLE 1-8

1. The noise level measurement was taken in accordance with PN-EN ISO 3746 Standard. The noise exposure level given above concerns an 8-hour work day. Value for associated uncertainty K=4dB.

2. The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission and exposure levels, it is not possible to determine with certainty if preventives are needed or are not needed. The factors affecting a current level of noise exposure during work are inter alia room characteristics and characteristics of other noise sources, e.g. number of the machines and machining operations nearby. Also the permissible exposure level can vary from country to country. This information, however will enable the user of the machine to make a better evaluation of the hazard and risk.

## 1.14 Sawdust Extractor Specifications

See table 1-9. Specifications of the dust extractor used on the sawmill are listed below<sup>1</sup>.

Maximum capacity	1200 m <sup>3</sup> /h
Collector Inlet Diameters (in front of fan)	100 mm
Electric Motor Horsepower	1,5 kW
Number of Sacks for Waste	1 pcs
Total Capacity of Sacks	0.25 m <sup>3</sup>
Pressure Drop	1,5 kPa (0.22 psi) <sup>1</sup>
Weight	110 kg
Conveying Speed When 10m Long Hose is Used	20 m/s

**TABLE 1-9**

<sup>1</sup> The pressure drop between the inlet of the capture device and the connection to the CADES should not exceed 1.5 kPa (for the nominal air flow rate). If the pressure drop exceeds 1.5 kPa the machine might not be compatible with conventional CADES.



**IMPORTANT!** The sawdust extractor hoses must be grounded or made with materials not accumulating electrostatic charge.



**CAUTION!** Always turn on the dust extractor before starting the machine.



**IMPORTANT!** The total value of the hand-arm vibration the operator may be exposed to does not exceed 2,5 m/s<sup>2</sup>. The highest root mean square value of weighted acceleration to which the whole operator's body is subjected does not exceed 0,5 m/s<sup>2</sup>.

1. External chip and dust extraction equipment with fixed installations are dealt with in EN 12779:2016-04.



### 1.15 Overall Dimensions

See figure 1-1. The overall dimensions of the LX50 Start sawmill are shown below.

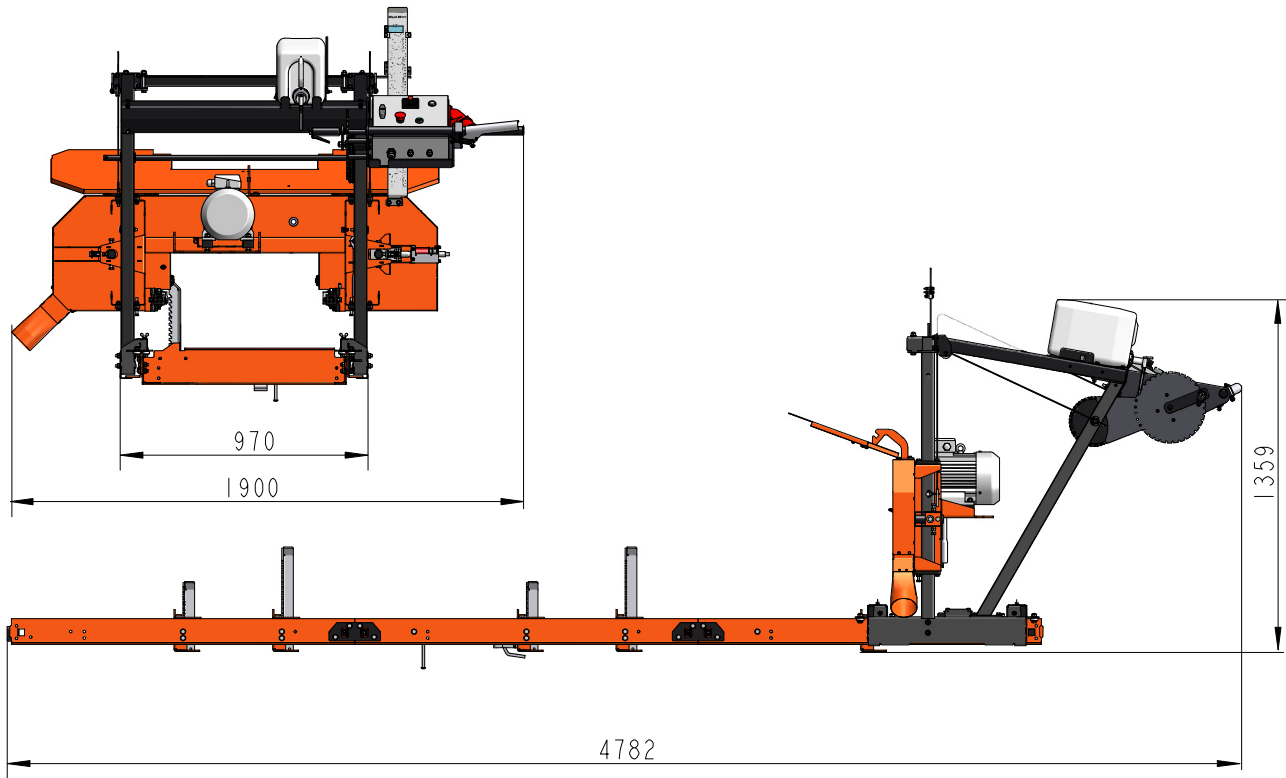


FIG. 1-1

See figure 1-2. See the figure below for the operator's work-place.

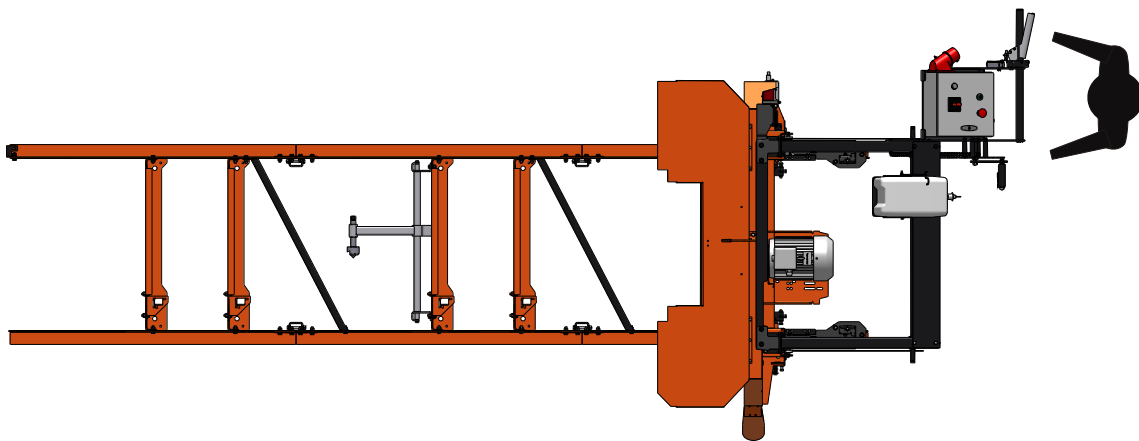
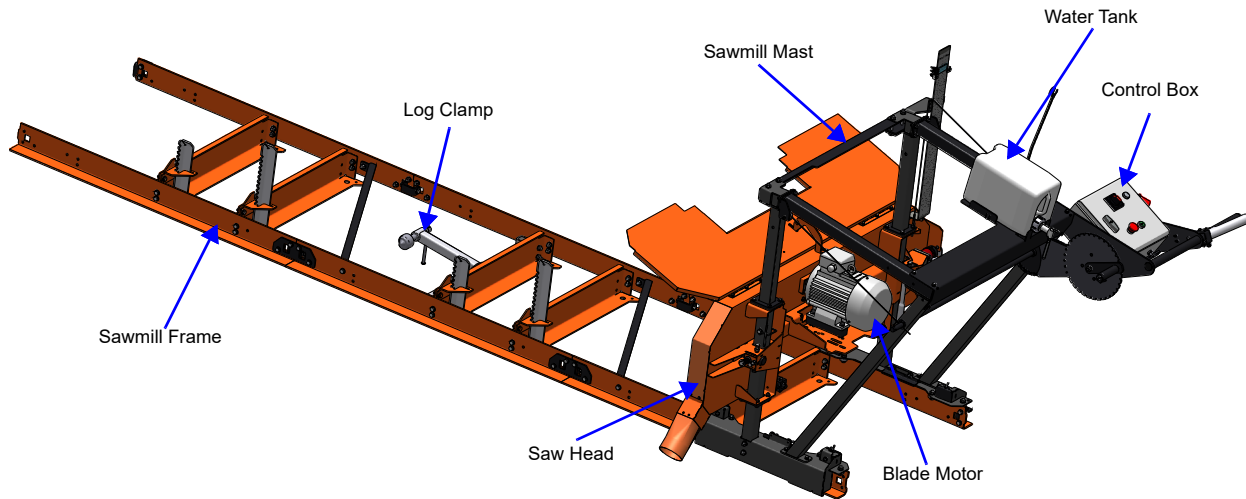


FIG. 1-2

## 1.16 Components

See figure 1-3. The major components of the LX50 Start EH5S sawmill are shown below.



**FIG. 1-3**

See figure 1-4. The major components of the LX50 Start G9S sawmill are shown below.

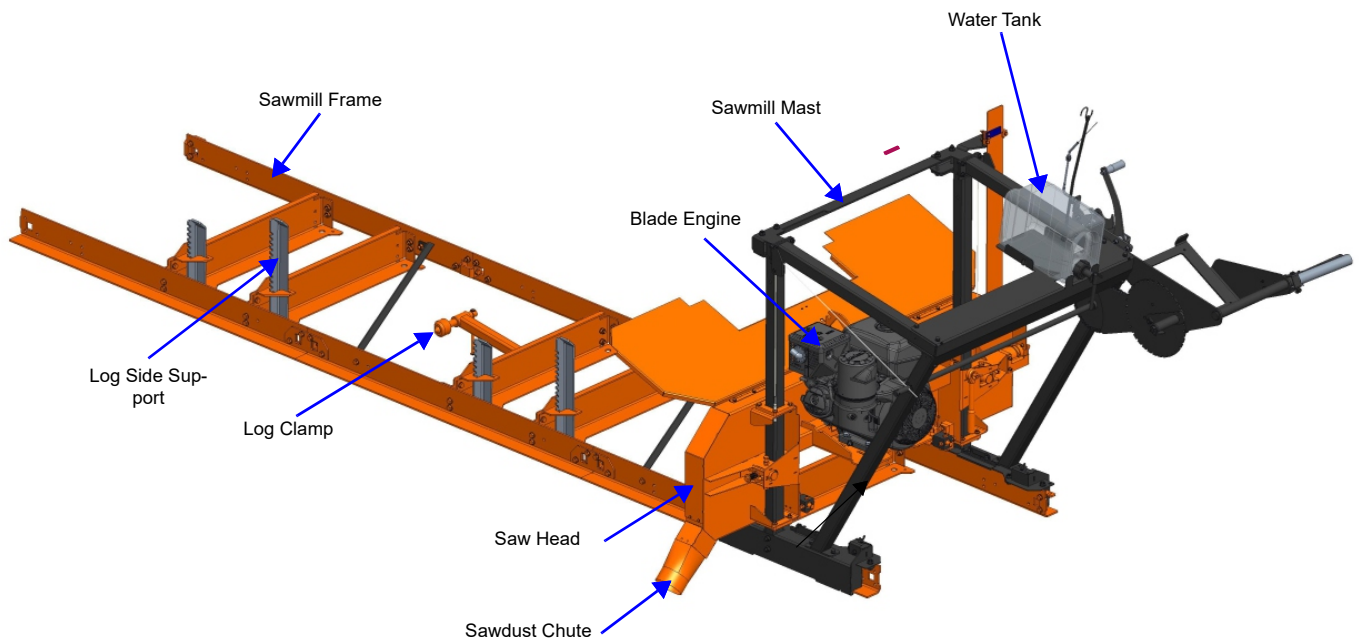


FIG. 1-4

**SECTION 2 SAWMILL ASSEMBLY**

**2.1 Mounting Parts of LX50 Start sawmill**

*2.1.1 Parts specifications*

Scan to see the assembly video.



**Table 1:**

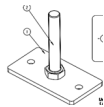




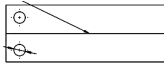

Fig.	Wood-Mizer No.	Description	QTY LX50 Start Electric		QTY LX50 Start Gas	
			CE	NON CE	CE	NON CE
	514996-1	Foot, Bed - Complete (option)	12	12	12	12
	507563	Stud w/Rod, Log Clamp - Complete	1	1	1	1
	T00041-1 T00051-1	Log Side Support	1	1	1	1
	530674-1	Bracket, Side Support Mounting	2	2	2	2
	T00414	Cap, Mounting	1	1	1	1
	094821	Indicator, Blade Height Scale	1	1	1	1
	532335-1	Spacer, Blade Height Scale	1	1	1	1

Table 1:




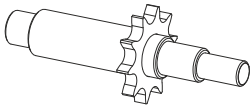

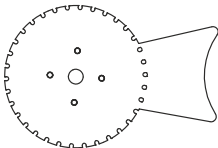
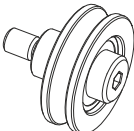
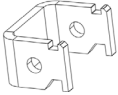
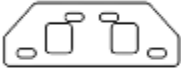
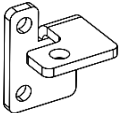
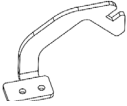


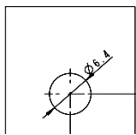
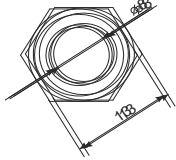
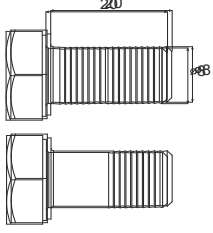
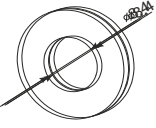
	096499	Blade Distance Handle	1	1	1	1
	516939	Key, A6x6x14 Parallel	1	1	1	1
	519161	Key, A6x6x22 Parallel	1	1	1	1
	531997-1	Handle, Crank LX50 Start	1	1	1	1
	532332	Bushing, Slide	4	4	4	4
	550689-1	Sprocket, LX50 Start	1	1	1	1
	550695	Chain, L=939 75-Link	1	1	1	1
	091625	Link, Master	1	1	1	1
	550687	Blade Height Scale Assembly	1	1	1	1
	550817	Roller, Lift Cable Guide	2	2	2	2

Table 1:

	X100-1273	Channel, Bed Frame Section Connector	4	4	4	4
	X100-1272	Plate, Flat	4	4	4	4
	X100-1275	Block, Stop	2	2	2	2
	X100-1155	Pawl, Cover	1	1	1	1
	014151	Pin	2	2	2	2
	550700	Up/Down System Steel Cable	2	2	2	2
	X100-1179	Bar, Scale Stiffener	2	2	2	2
	R01885	Tubing, Water Lube	105cm	105cm	105cm	105cm
	F81082-5	Tie Wrap, 4.8x240mm	5	5	5	5
	LX50 Start G/E	Bolt Kit	1 kit	1 kit	1 kit	1 kit

2.1.2 Specifications of Fasteners

Table 2:

Wood-Mizer No	Description	QTY LX50 Start Electric		QTY LX50 Start Gas	
		CE	Non CE	CE	Non CE
<b>Designations of fasteners:</b>					
<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> <p>NUT, M8</p>  </div> <div style="text-align: center;"> <p>Bolt, M8x20</p>  </div> <div style="text-align: center;"> <p>8.4 Washer</p>  </div> </div>					
Bracket, Scale 530667					
F81000-10	BOLT, M5x35 8.8 HEX HEAD FULL THREAD ZINC	2	2	2	2
F81030-2	NUT, M5-8 DIN 985 ZINC-PLATED	2	2	2	2
F81052-1	WASHER, 5.3 FLAT ZINC	4	4	4	4
F81001-8	BOLT, M6X30-8.8 HEX HEAD FULL THREAD ZINC	2	2	2	2
F81002-11	SCREW, M8x20-8.8- ZINC MUSH-ROOM HEAD SQUARE NECK	2	2	2	2
F81031-2	NUT, M6-8-B HEX NYLON ZINC LOCK	2	2	2	2
F81032-2	NUT, M8-8-B HEX NYLON ZINC LOCK	2	2	2	2
F81053-1	WASHER, 6.4 FLAT ZINC	4	4	4	4
F81054-1	WASHER, 8.4 FLAT ZINC	2	2	2	2
Sawdust Chute					
F81000-13	SCREW, M5X10 8.8 CROSS RECESSED PAN HEAD ZINC	4	4	4	4
F81030-2	NUT, M5-8 DIN 985 ZINC-PLATED	4	4	4	4
F81052-1	WASHER, 5.3 FLAT ZINC	4	4	4	4
Latch, Cover					
F81002-4	BOLT, M8x20-8.8-B HEX HEAD FULL THREAD ZINC	2	2	2	2
F81054-1	WASHER, 8.4 ZINC FLAT	2	2	2	2
F81054-4	WASHER, 8.2 SPLIT LOCK ZINC	2	2	2	2
Mast, Sawmill - Complete					
F81003-50	BOLT, M10X80-8.8 HEX HEAD ZINC	4	4	4	4

**Table 2:**

F81002-71	BOLT, M8x70-8.8 HEX HEAD ZINC	8	8	8	8
F81002-7	BOLT, M8x30-8.8 HEX HEAD FULL THREAD ZINC	12	12	12	12
F81002-20	BOLT, M8x16 -8.8-B HEX HEAD FULL THREAD ZINC	8	8	8	8
F81033-1	NUT, M10-8-B HEX NYLON ZINC LOCK	10	10	10	10
F81033-3	NUT, M10-8-B HEX ZINC	4	4	4	4
F81032-2	NUT, M8-8-B HEX NYLON ZINC LOCK	16	16	16	16
F81055-1	WASHER, 10.5 ZINC FLAT	20	20	20	20
F81054-1	WASHER, 8.2 SPLIT LOCK ZINC	36	36	36	36
F81054-4	WASHER, 8.2 SPLIT LOCK ZINC	12	12	12	12
F81003-107	BOLT, M10x75-8.8 CARRIAGE ZINC	4	4	4	4
<b>Bed, Frame M120 - Complete</b>					
F81003-2	BOLT, M10x30-5.8 HEX HEAD FULL THREAD ZINC	64	64	64	64
F81003-50	BOLT, M10x80-8.8 HEX HEAD ZINC	4	4	4	4
F81033-1	NUT, M10-8-B HEX NYLON ZINC LOCK	68	68	68	68
F81055-1	WASHER, 10.5 ZINC FLAT	136	136	136	136
<b>Hanger, Power Cord</b>					
F81087-2	Clip, 1.20/20 Retaining	6	6	0	0
F81002-5	BOLT, M8x25-8.8 HEX HEAD FULL THREAD ZINC	4	4	0	0
F81032-2	NUT, M8-8-B HEX NYLON ZINC LOCK	4	4	0	0
F81054-1	WASHER, 8.4 ZINC FLAT	8	8	0	0
<b>Log Side Support, LX50 Start</b>					
F81001-9	BOLT, M6x60-8.8 HEX HEAD FULL THREAD ZINC	2	2	2	2
F81031-2	NUT, M6-8-B HEX NYLON ZINC LOCK	2	2	2	2
F81053-1	WASHER, 6.4 FLAT ZINC	4	4	4	4
F81003-53	BOLT, M10x20-8.8 HEX HEAD FULL THREAD ZINC	4	4	4	4
F81003-111	BOLT, M10x30-8.8 HEX HEAD ZINC	8	8	8	8
F81033-1	NUT, M10-8-B HEX NYLON ZINC LOCK	8	8	8	8
F81055-1	WASHER, 10.5 ZINC FLAT	20	20	20	20
<b>UP/DOWN ASSEMBLY, 532337</b>					
516939	Key, A 6x6x14 Parallel	1	1	1	1



Table 2:

519161	Key, A 6x6x22 Parallel	1	1	1	1
F81001-103	SCREW, M6X16 45H HEX SOCKET SET W/FLAT POINT	2	2	2	2
F81013-1	SCREW, M6X8-45H GEOMET HEX SOCKET SET W/FLAT POINT	1	1	1	1
F81002-5	BOLT, M8x25 -8.8-B HEX HEAD FULL THREAD ZINC	2	2	2	2
F81002-20	BOLT, M8x16 -8.8-B HEX HEAD FULL THREAD ZINC	4	4	4	4
F81002-71	BOLT, M8x70 8.8 HEX HEAD ZINC	4	4	4	4
F81002-19	BOLT, M8X50 -8.8 HEX HEAD FULL THREAD ZINC	2	2	2	2
F81032-2	NUT, M8-8-B HEX NYLON ZINC LOCK	8	8	8	8
F81054-1	WASHER, 8.4 ZINC FLAT	18	18	18	18
F81054-4	WASHER, 8.2 SPLIT LOCK ZINC	4	4	4	4
F81034-2	NUT, M12-8 HEX NYLON ZINC LOCK	1	1	1	1
Foot, Bed 514997					
F81037-1	NUT, M20-8- HEX ZINC	24	24	24	24
F81059-2	WASHER, 21	24	24	24	24

### 2.1.3 Tools Necessary for Assembling the Sawmill

Table 3:

Required tools	
Flat Wrench #8	1 pcs
Flat Wrench #10	2 pcs
Flat Wrench #13	2 pcs
Flat Wrench #17	2 pcs
Flat Wrench #19	2 pcs
Ratchet Wrench #30	1 pcs
Hammer	1 pcs
Allen Wrench #4	1 pcs
Allen Wrench #5	1 pcs

## 2.2 Unpacking the Sawmill

Needed tools:

- Strap cutter
- Screwdriver Set
- Socket Wrench Set
- Socket Wrench Extension Bar (Option)
- Flat Wrench Set
- Allen Wrench Set
- Moving equipment (such as a fork-lift truck)

Leave enough room around the sawmill for the operators, sawdust removal, log loading, and board removal.

LX50 SA sawmill on a pallet

See figure 2-1.



FIG. 2-1

1. Cut the bands holding the components together.
2. Unbolt frame segments from the pallet. Remove all sawmill parts from the pallet and put them on the level surface.



**WARNING!** When removing the saw head, use extreme care and keep all persons at a safe distance. Failure to do so may result in serious injury or death.

See figure 2-2. LX50SA sawmill components.



FIG. 2-2

### 2.3 Bed Frame Assembly



**CAREFULLY!** Place the sawmill bed on 140 x 140mm cants on level ground. Use bolts to fasten the bed to the cants to prevent it from moving during operation. Failure to do so may cause the saw head to tip, resulting in serious injury or death.

1. Place the track rails on cants on level ground. Attach them to the cross rails using the M10x30 bolts. Repeat it for all bed segments.

See figure 2-3.

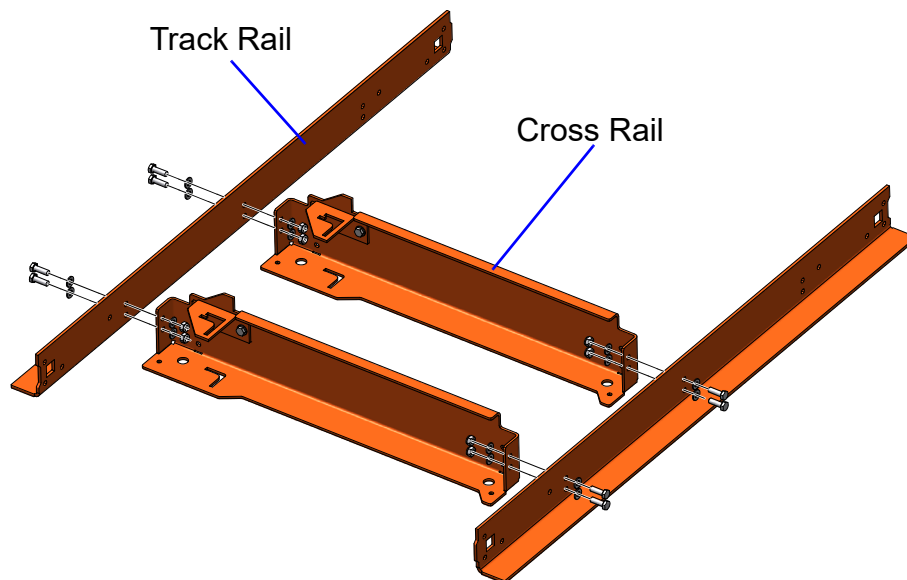


FIG. 2-3

- Position all three assembled bed sections end-to-end in the order shown on the figure 2-4.

See figure 2-4.

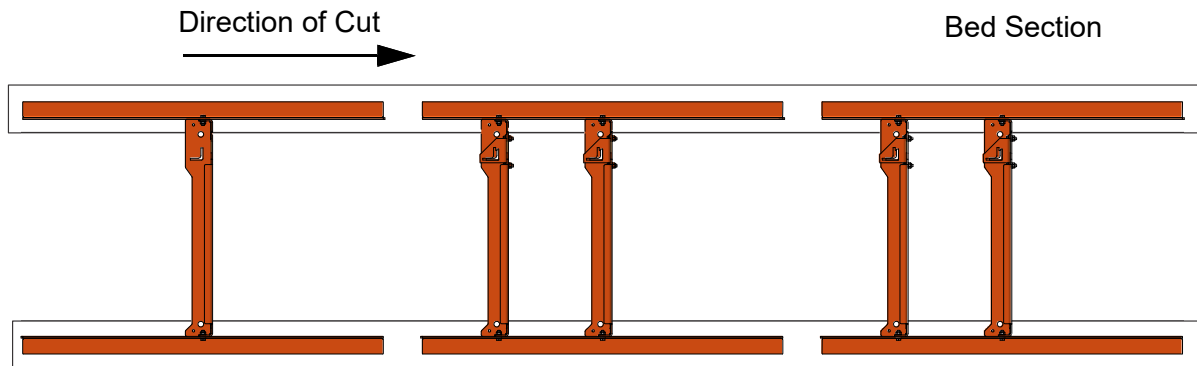


FIG. 2-4

- Connect the bed sections using the connecting plate, clamp and bolts shown in Figure 2-5. Set the clamp in place by inserting the smaller notch ② in first and tilting the clamp in then upward to catch the larger notch ①.

See figure 2-5.

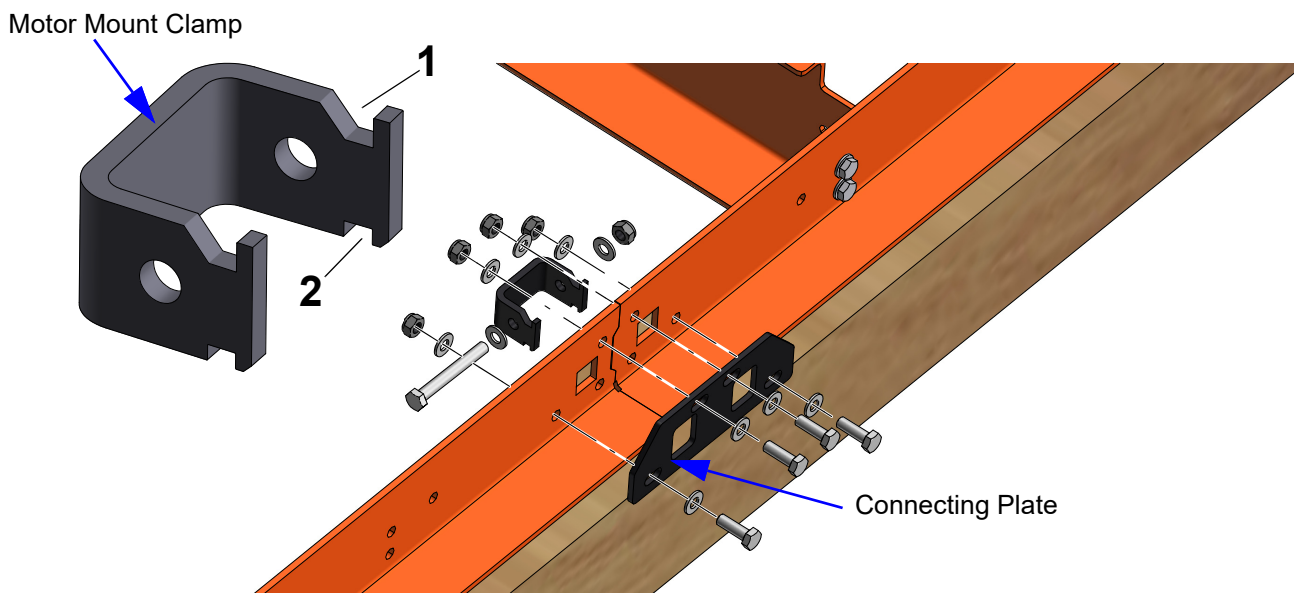


FIG. 2-5

**NOTE: Before tightening the bolts, be sure the track rails (top and side surfaces) of each bed section are aligned.**

Repeat the above steps for the remaining bed section connections.

Optional bed extension sections may be added at this time, in the same manner as the standard bed sections.

See figure 2-6. Mount the reinforcing bracket using M10x30 bolts, washers and nuts. Fasten the assembled sawmill bed to the cants using the bolts. .

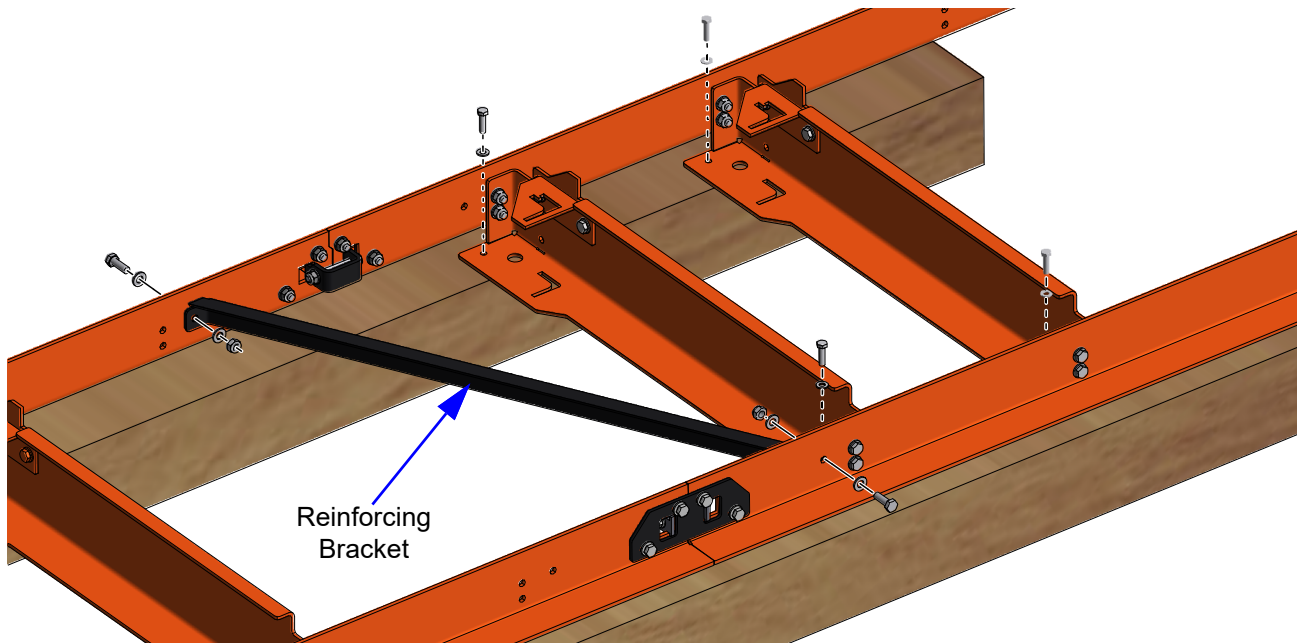


FIG. 2-6

## 2.4 Log Clamp Installation

1. To mount the log clamp, first dismount the mounting bracket on one side of the log clamp rod, insert the log clamp arm onto the rod and reinstall the mounting bracket with M10x20 bolts. Attach the complete log clamp in the middle of the bed using the M10x30 bolts.

See figure 2-7.

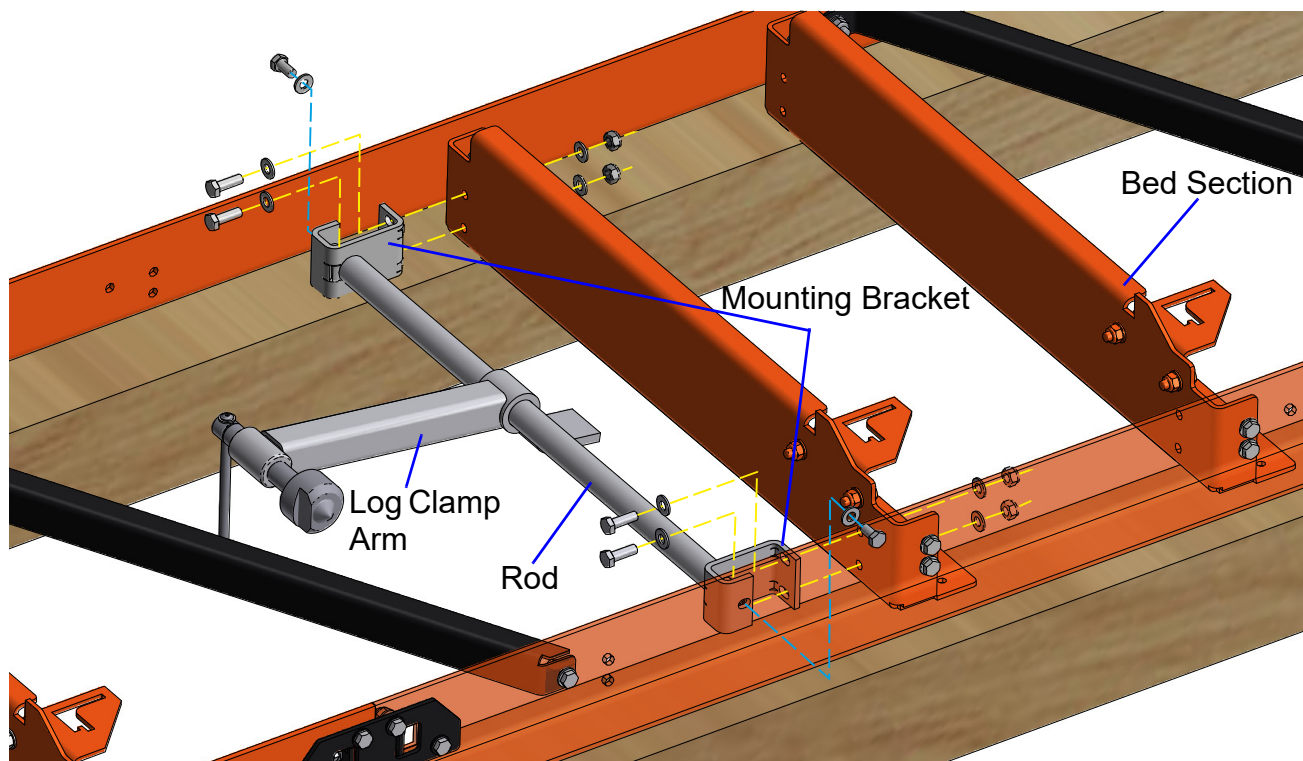


FIG. 2-7

## 2.5 Stop Blocks Installation

Install the stop blocks at both ends of the bed to prevent the saw head from sliding off the bed. Attach the stop blocks on the outside surfaces of the front and last bed sections. Use M10x30 bolts. The stop blocks can also be used to prevent accidental saw head movement - See Section 3.7 **Saw Head Installation** step 5.



**WARNING!** Failure to do so may result in serious personal injury or machine damage

See figure 2-8.

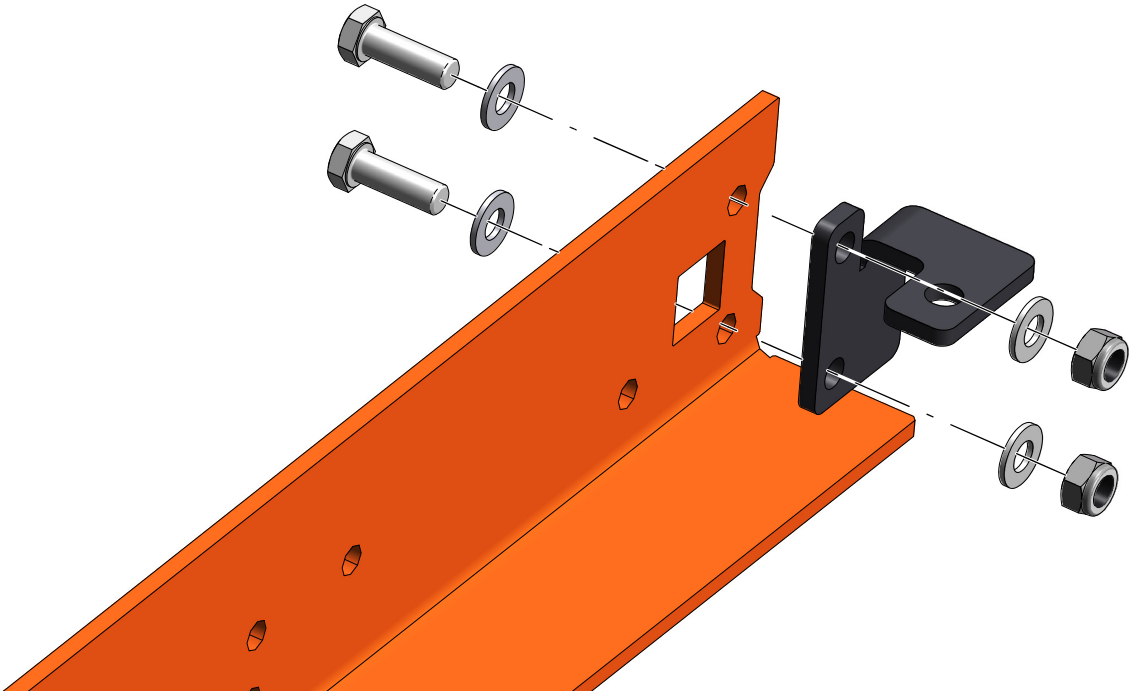


FIG. 2-8

### 2.6 Bed Leveling with Optional Bed Feet

Use a min. 4-foot (120cm) level (or laser level) to level the bed in all directions.

**CAUTION!** It is important that the bed be level for the saw head to travel smoothly over the rails.

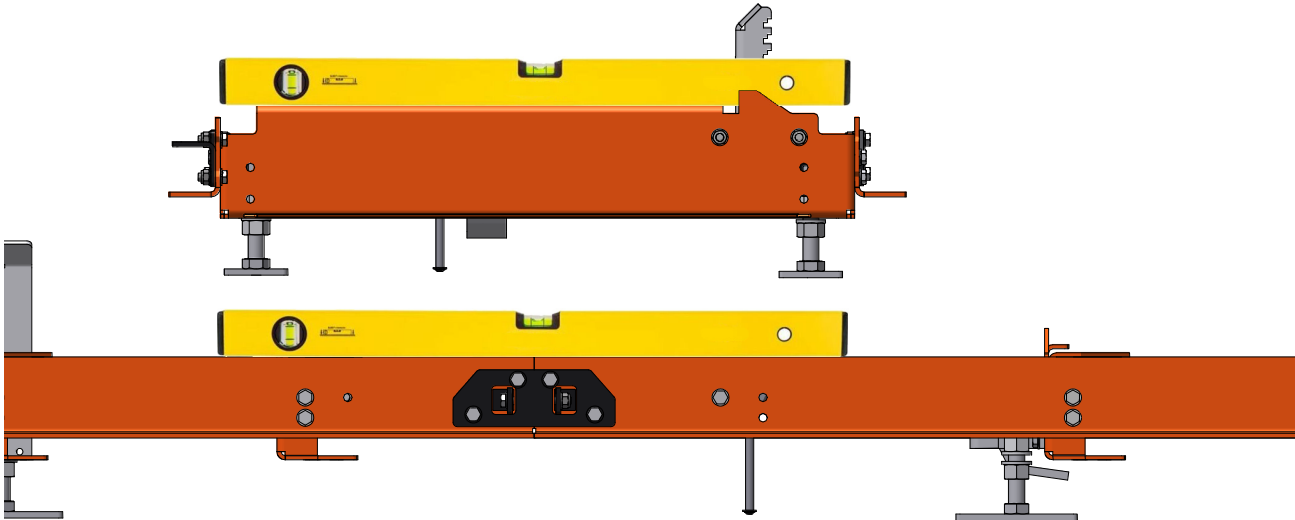


FIG. 2-9



2. If your sawmill is equipped with the optional adjustable legs, use these legs to level the bed. Adjust the bed height by turning the lower nut (B) and lock the bed position with the upper nut (A).

See figure 2-10.

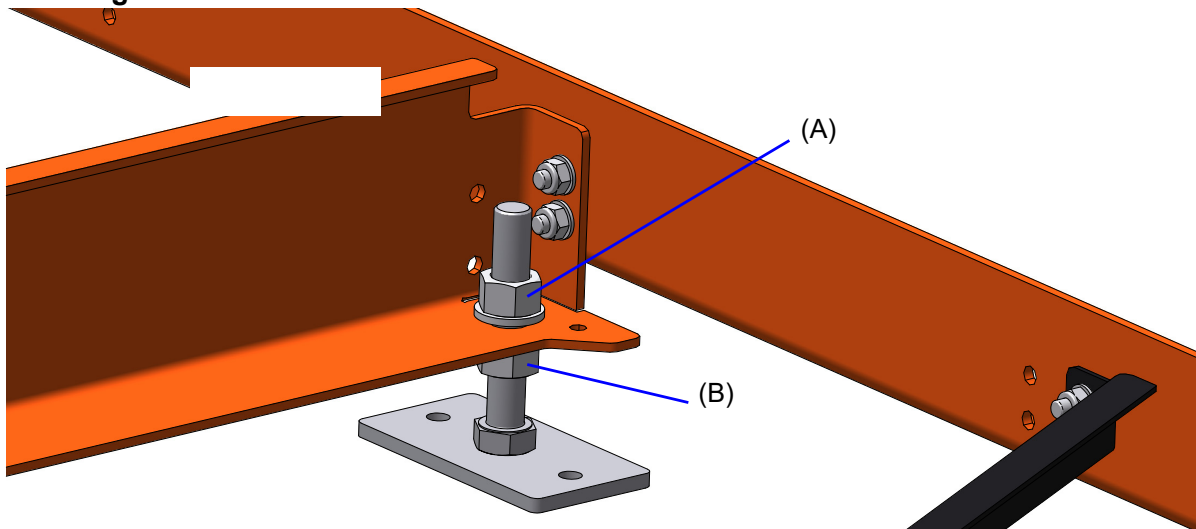


FIG. 2-10

## 2.7 Saw Head Installation



**WARNING!** When removing the saw head, use extreme care and keep all persons at a safe distance. Failure to do so may result in serious injury or death.

1. Before installation of the mast tubes, loosen the mounting bolts located on the mast guide bracket at both sides of the saw head. The figure below shows one of these brackets.

See figure 2-11.

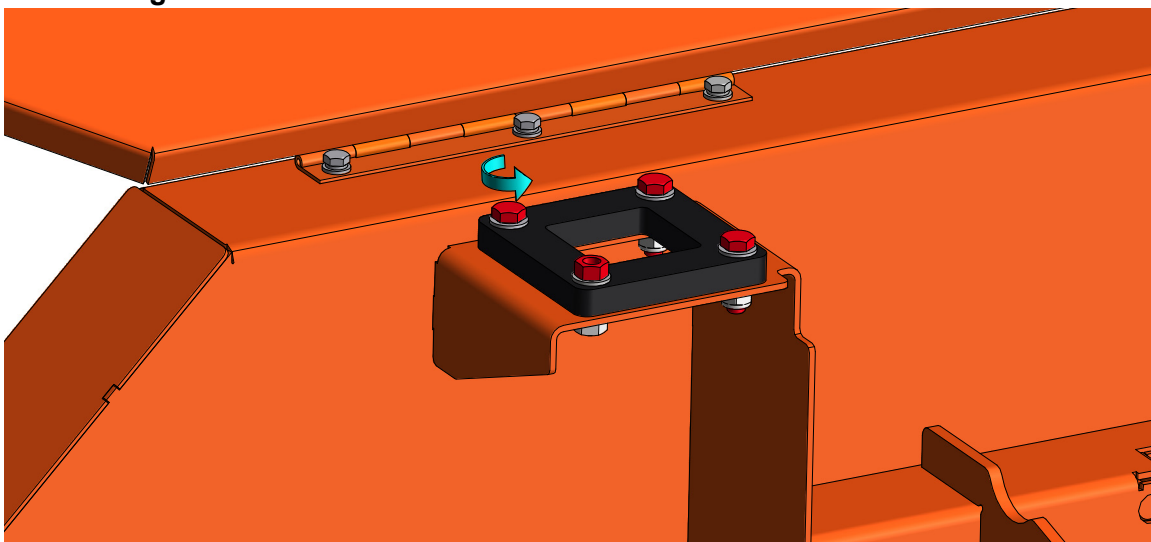
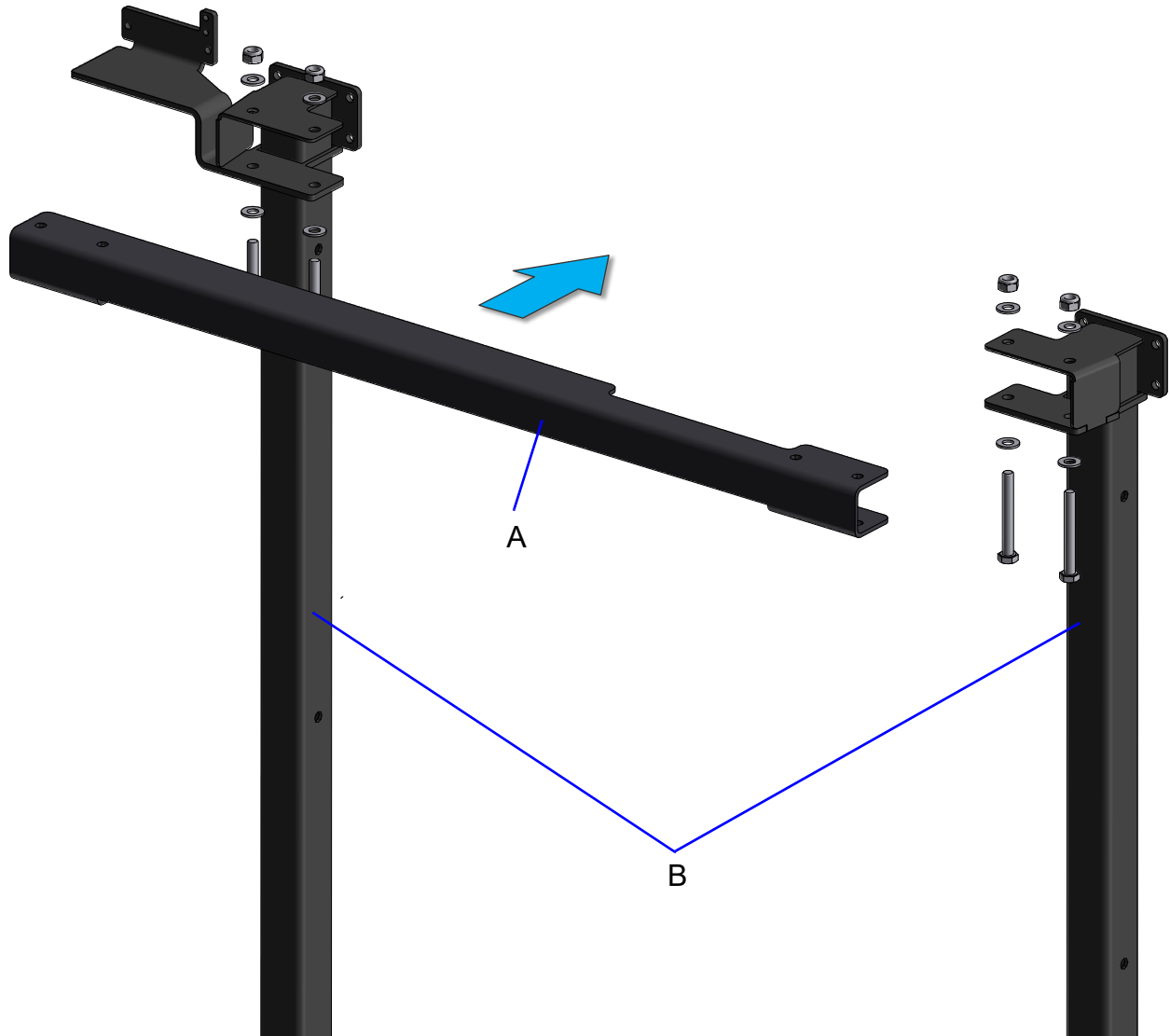


FIG. 2-11

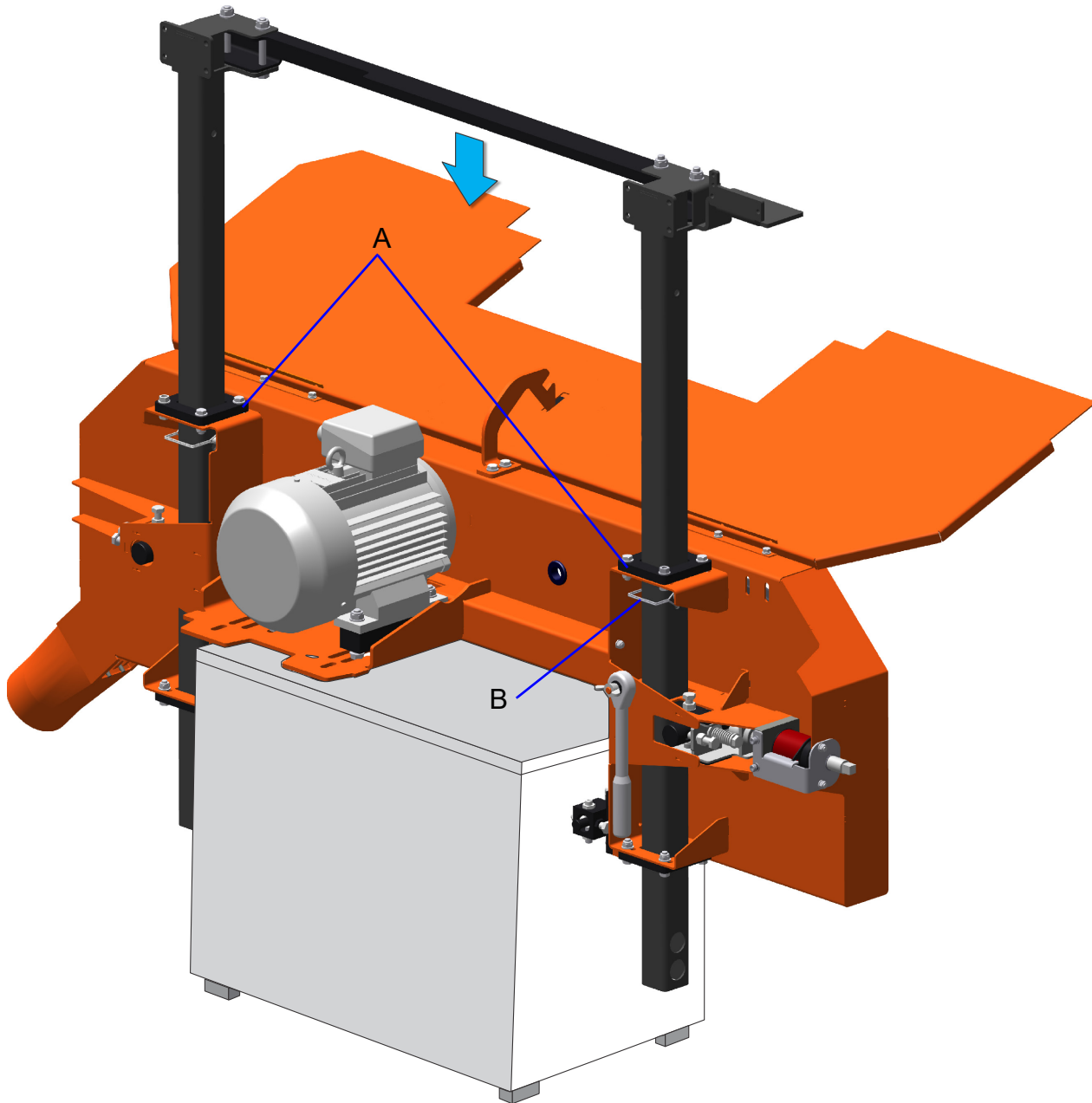


2. Insert the upper mast tube (A) into the brackets and tighten using the M10x80 bolts. Connect the left and right mast tubes (B) with the upper mast tube before inserting them into the guide brackets.

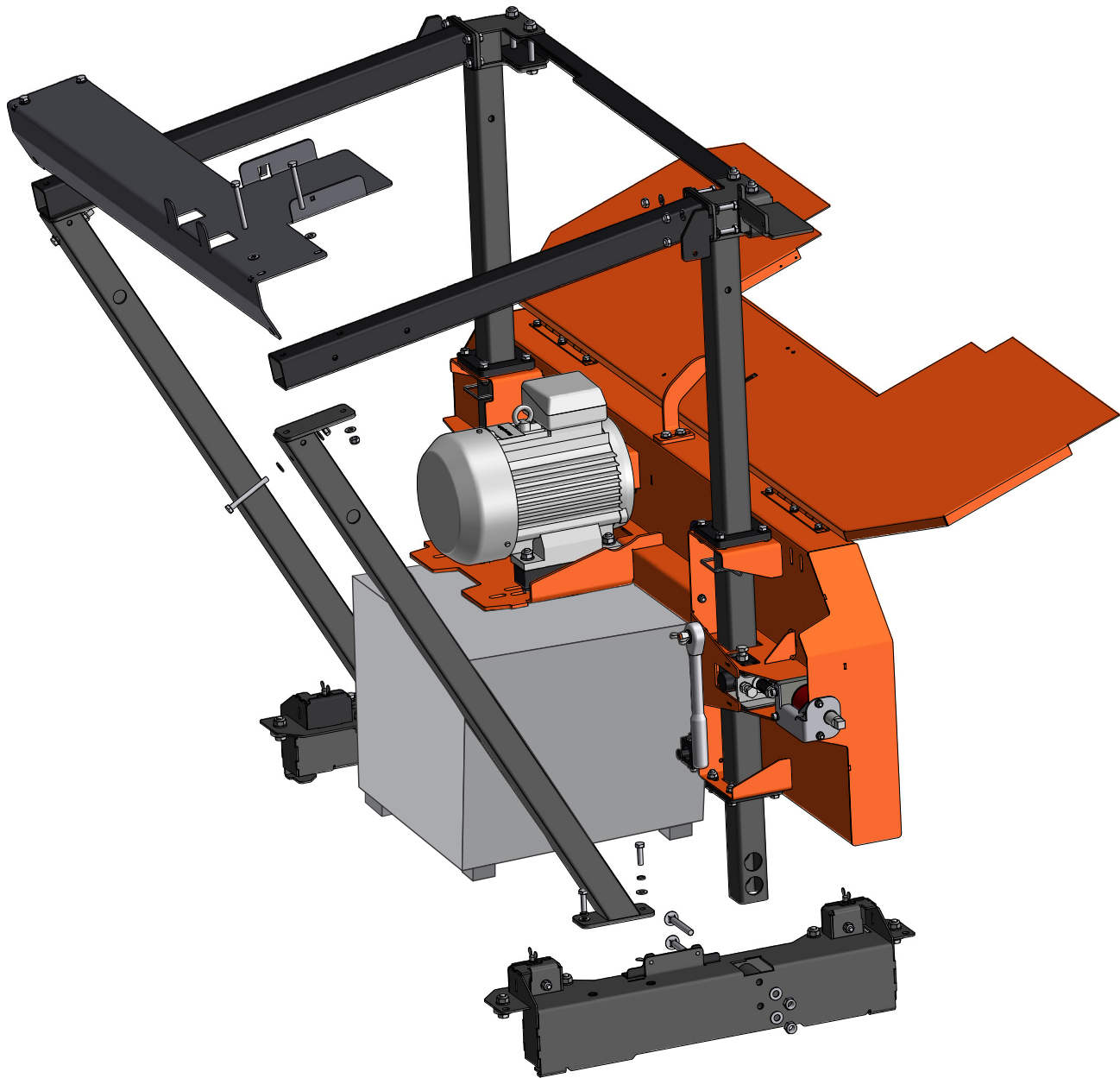
See the figure below.



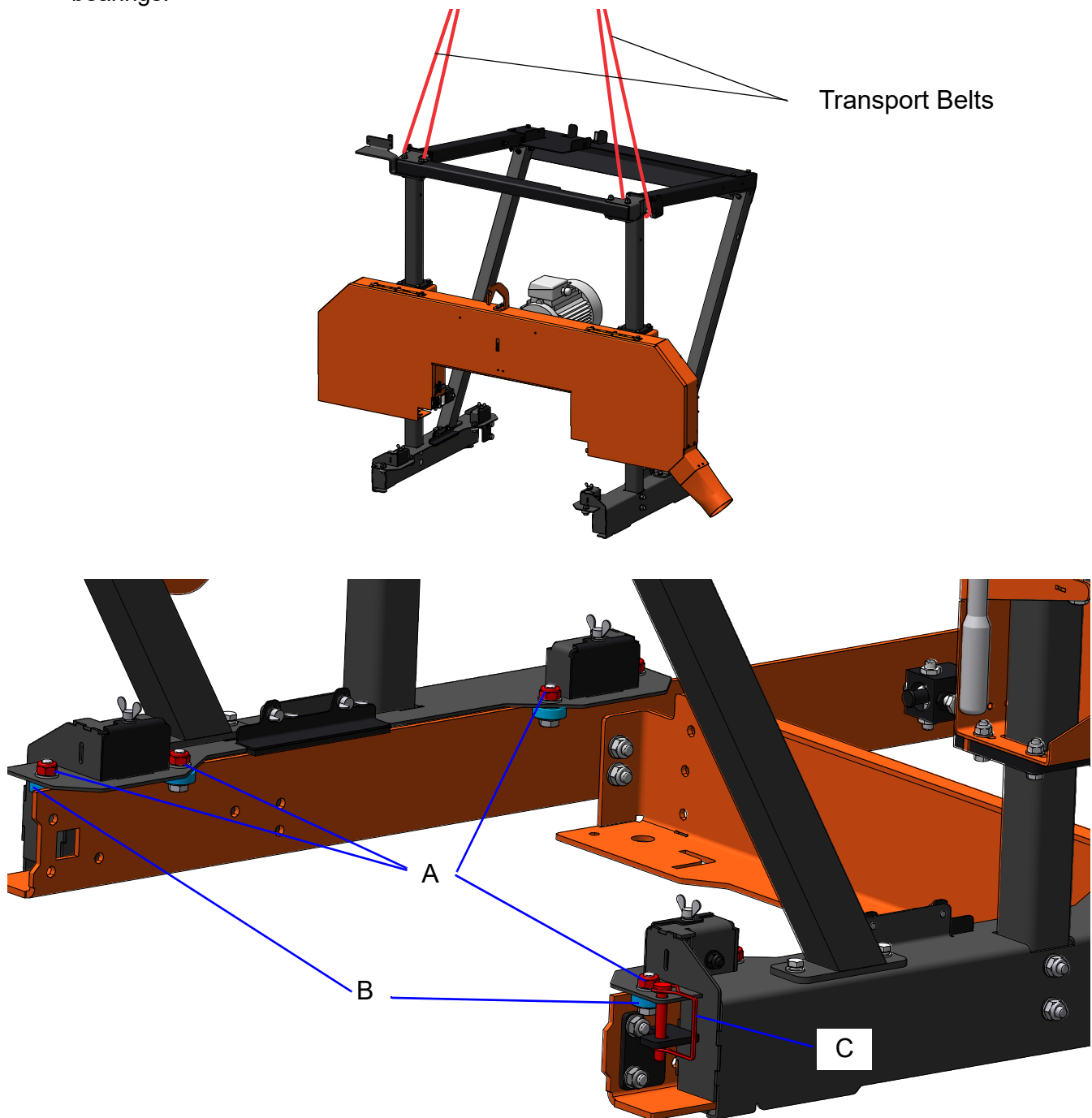
3. Insert the connected tubes into the mast guide brackets (A). The saw head should be placed vertically and stable on the table. Install the head-locking stop pins (B) (Part No 014151) in the holes on both tubes. These pins will prevent the saw head from lowering.



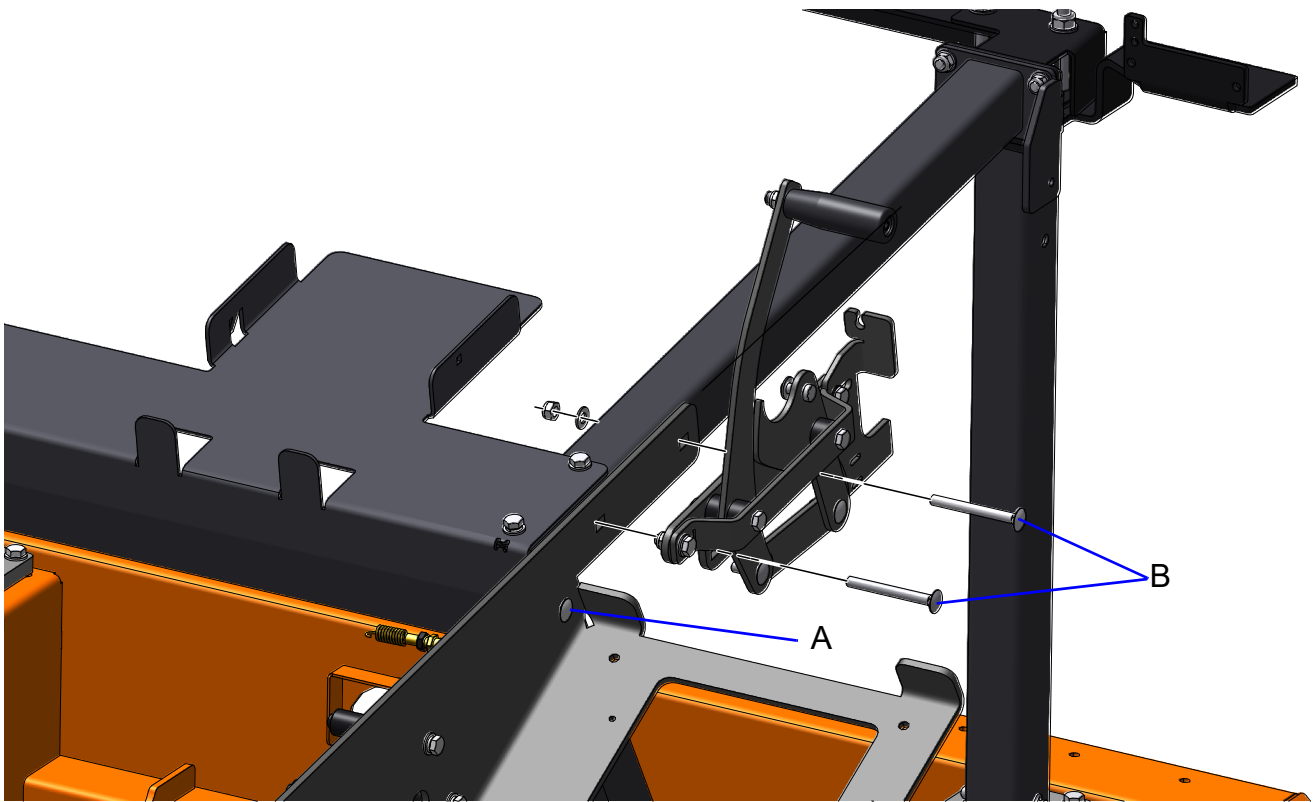
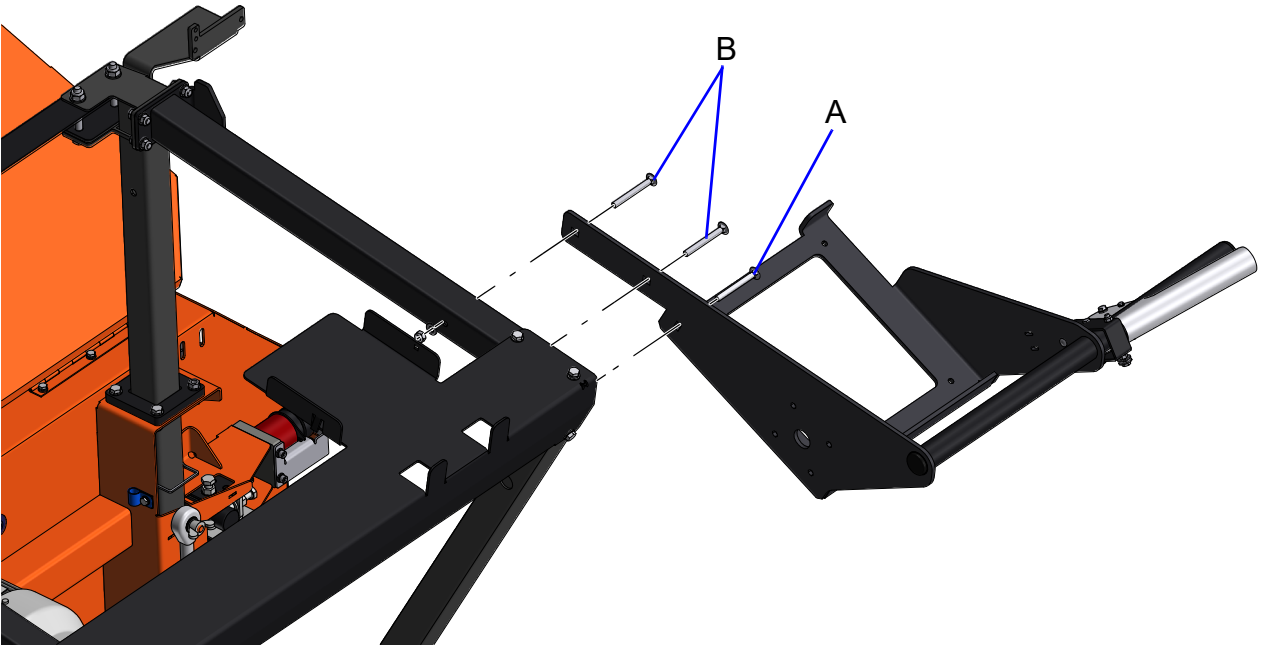
4. Assemble the sawmill mast as it is shown below.



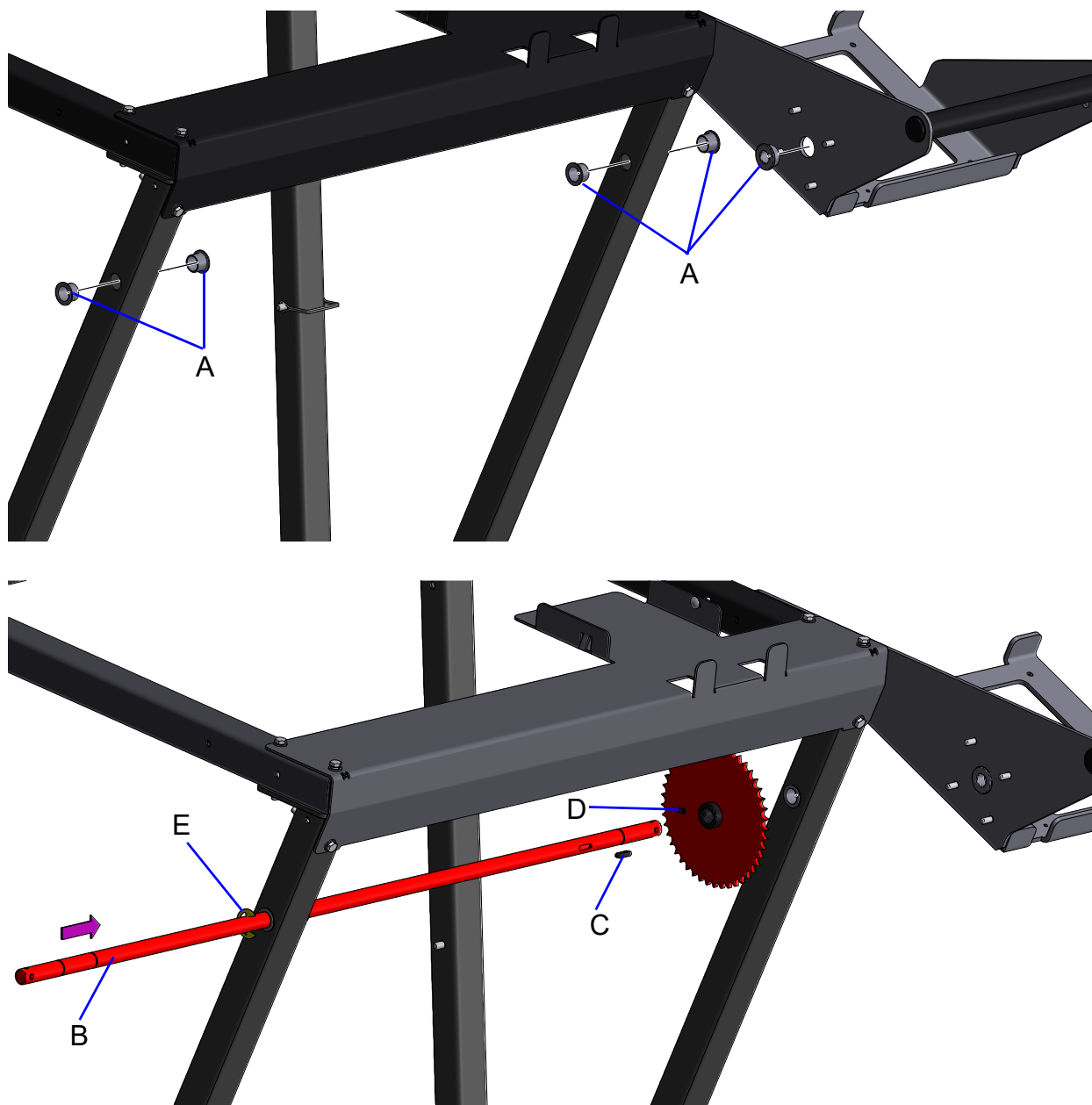
5. Loosen M10x30 roller clamping bolts (A). Using lifting equipment, place the saw head with the mast on the sawmill bed. Make sure the track rollers ride smoothly on the track rail. Then position the saw head at the front of the bed to secure it with a locking pin (C) that will prevent accidental saw head movement. The saw head should be in its lowest position. The side bearings (B) must be properly clamped against the track rail so that there is no clearance between the bearings and the track rail while the saw head is being moving. The side bearings should lightly touch the vertical surface of the track rail. Tighten the nuts to lock the bearings in the adjusted position. If the bearings press too firmly against the rail, it will cause the saw head to not move easily on the rail and will result in premature bearing wear. Make this adjustment for all side bearings.



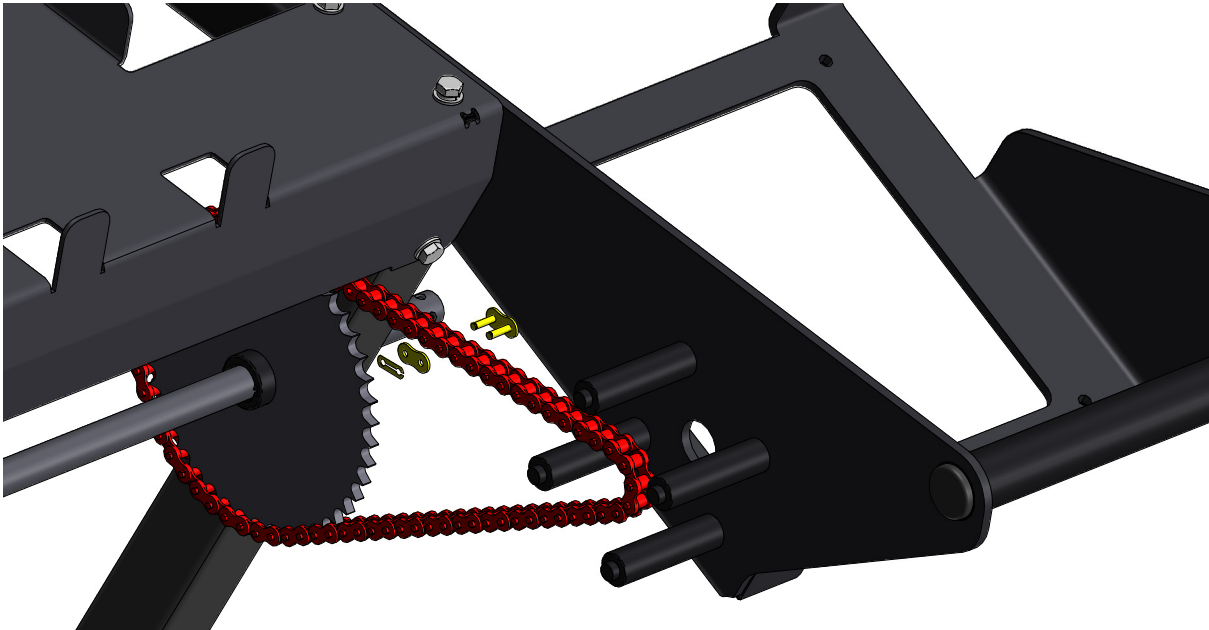
6. Install the electric box bracket to the sawmill mast using carriage bolts and washers with M8-8 nuts. See the figure below. For sawmills with gas engine, first install the electric box bracket with one bolt (A), next mount the clutch lever to this bracket using bolts (B).



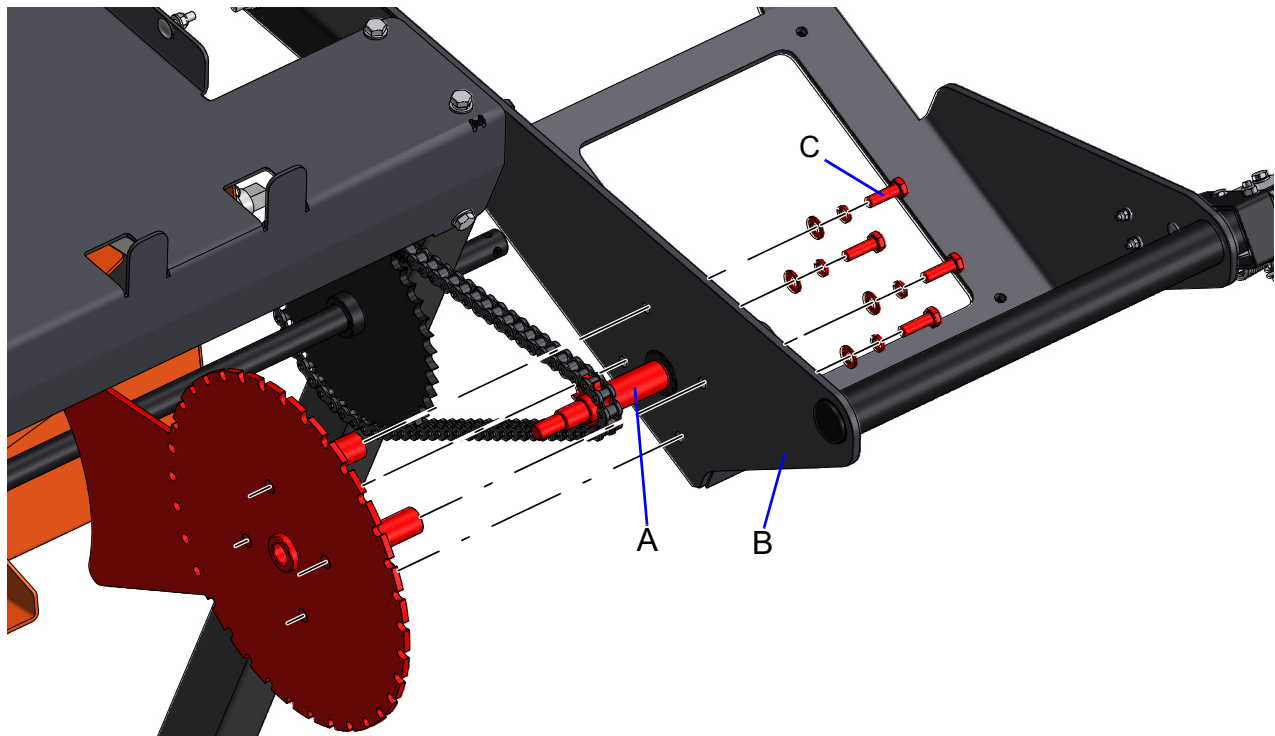
- Use rubber mallet to insert the plastic bushings (A) into the holes located on the frame. Place the winch shaft rod (B) from the right side of the mast. Insert the key (C) into the slot in the winch shaft. Slide the sprocket onto the shaft and tighten the set screw (D). Secure the complete winch shaft with retaining washer (E).



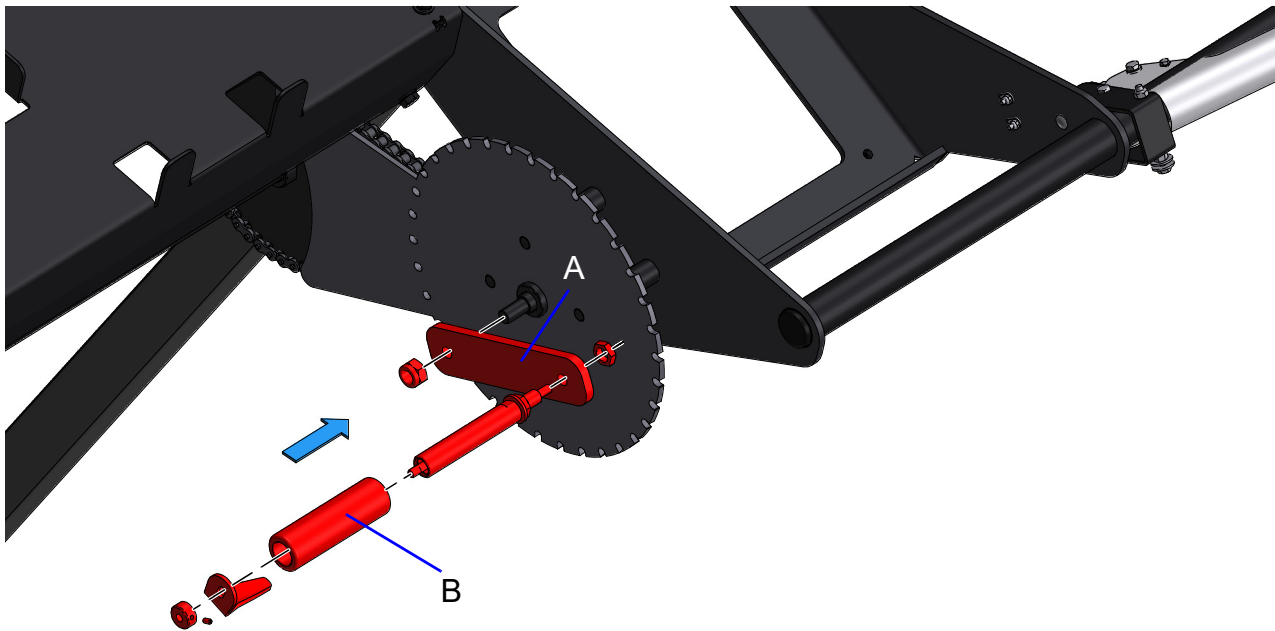
8. Install the chain on the up/down shaft sprocket and connect the chain ends with the master link.



9. Next, install the chain on lever shaft sprocket (A) and slide the shaft into the electric box bracket (B). Use the M8x25 bolts (C) with retaining and flat washers. See the picture below.



10. Install the crank arm (A) and tighten the nut. Mount the crank handle (B) as shown below.

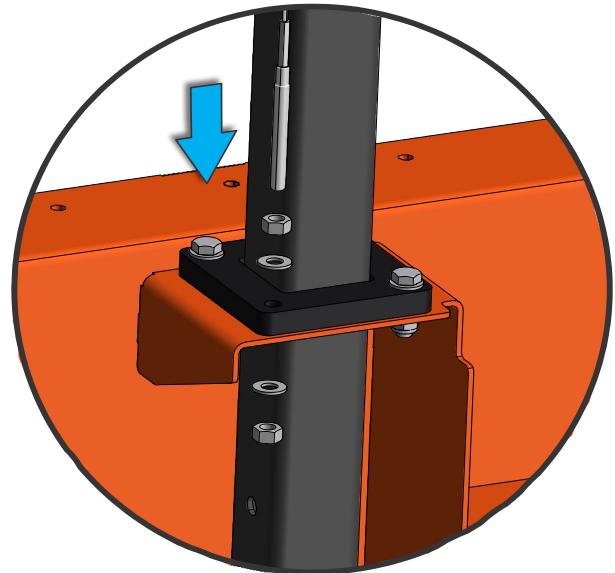
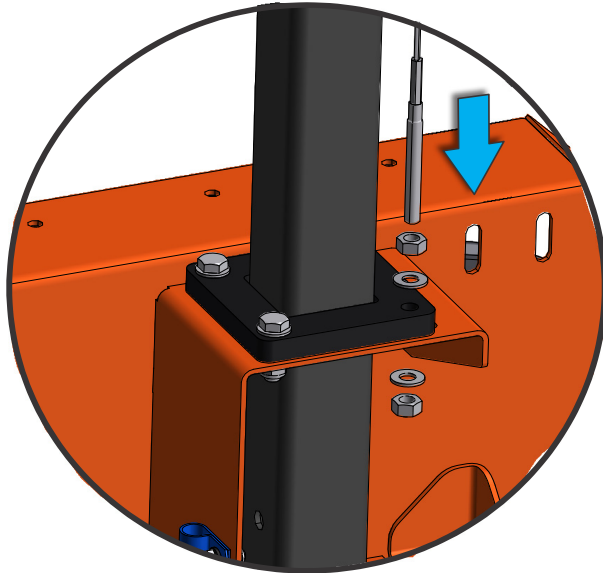


11. Mount the cable guide roller at both sides of the mast as shown below. Tighten them using allen wrench.

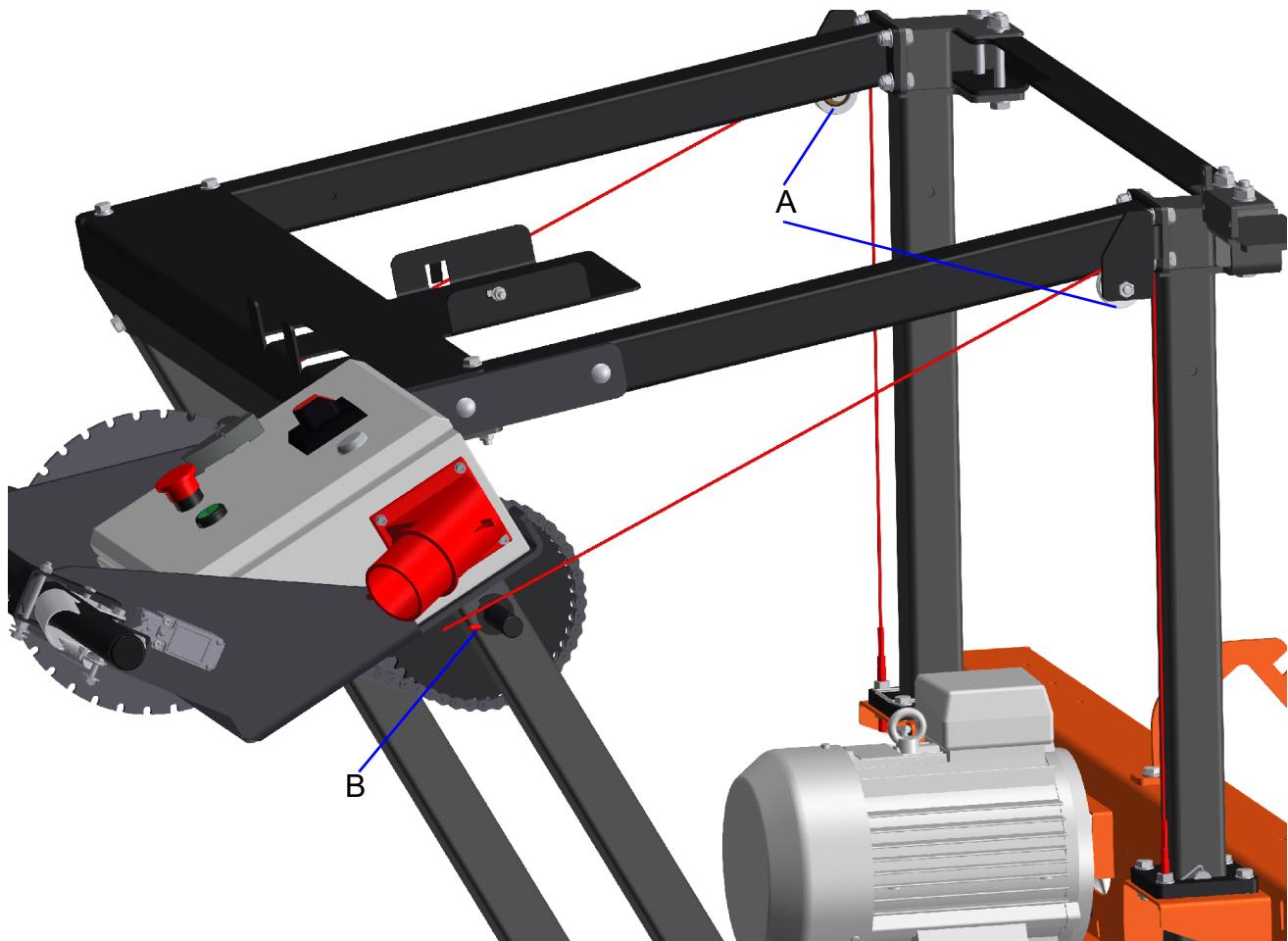




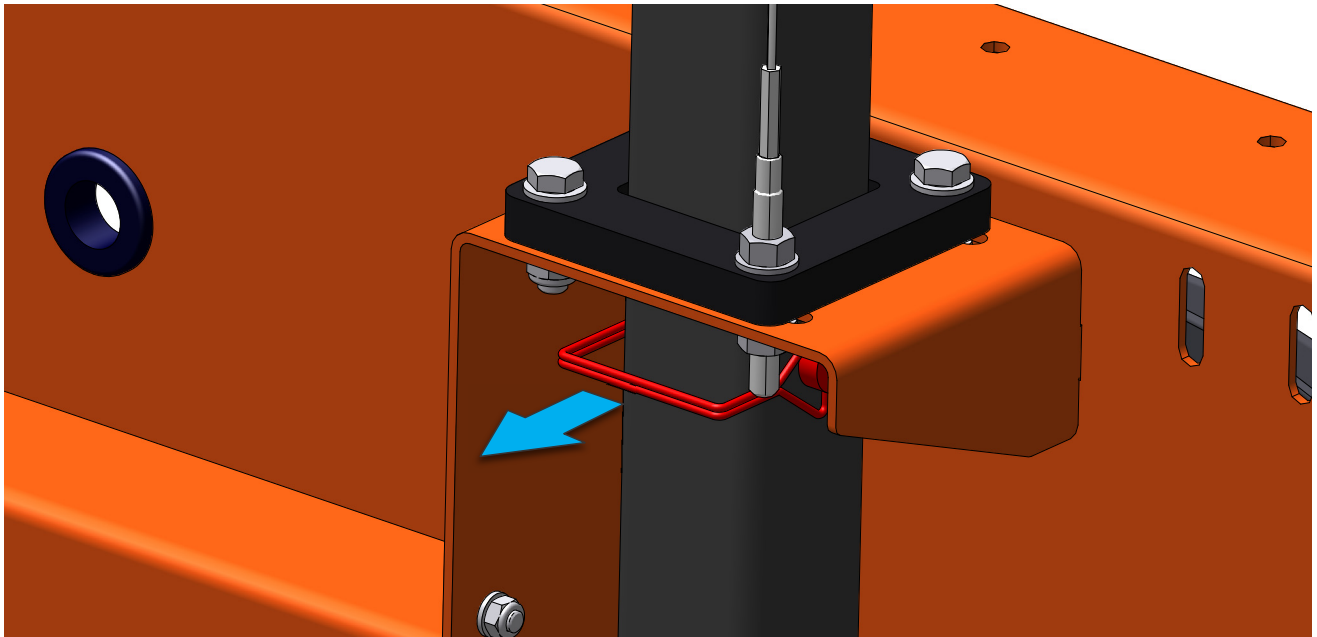
12. Thread the end of the steel lift cable through the hole in the mast (from the top). Lock the cable in place using the washer and M10 nut as shown below. Repeat for the other cable.



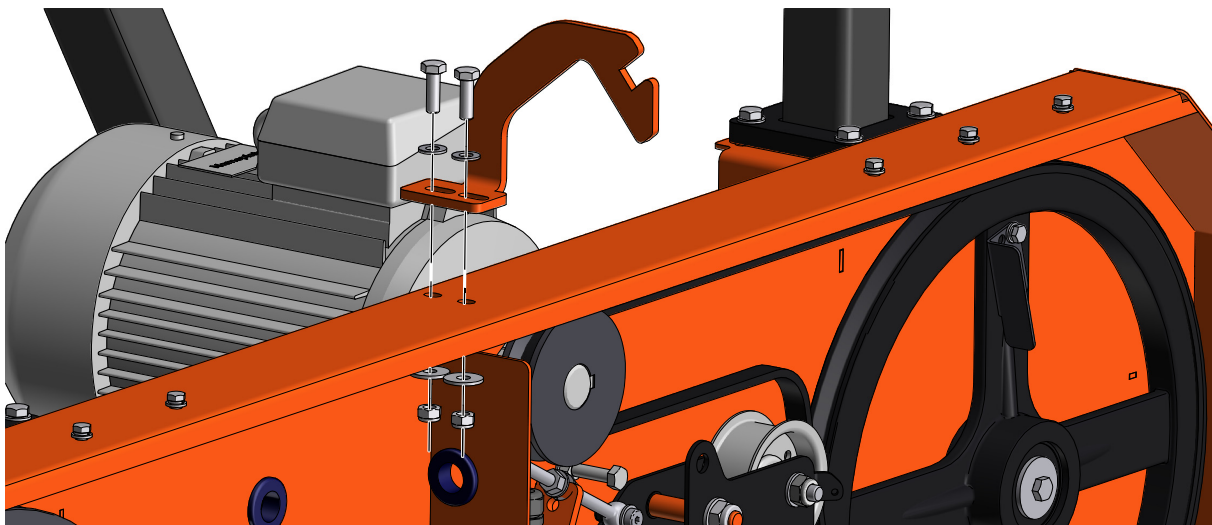
13. Install the steel lift cable on the guide roller (A). Thread the end of the steel lift cable through the hole in the up/down shaft and lock the cable in place using set screw (B). Repeat for the steel cable on the other side of the mast.



14. Raise the saw head few centimeters up and remove the head-locking stop pins from both vertical mast tubes. The saw head is on the steel lift cables.



15. Install the saw head cover latch using two M8x20 bolts.



## 2.8 Sawdust Chute Assembly

1. Open the saw head cover and fasten the sawdust chute using the (A) M5x12 and (B) M5x10 bolts.

See figure 2-12.

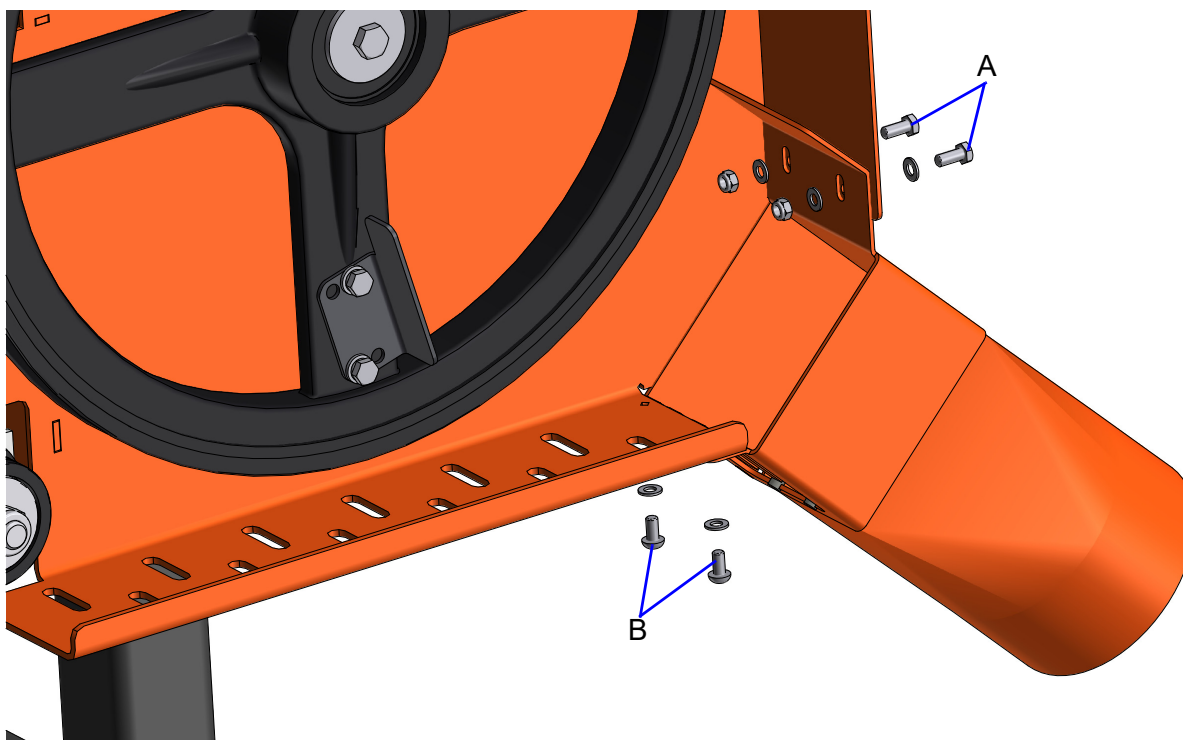


FIG. 2-12

## 2.9 Water Bottle Installation

1. Install the water bottle on the mast cross tube and secure with rubber cable clamp (A) to the tray. Attach the hose to gas cable using cable clamps.

See figure 2-13.

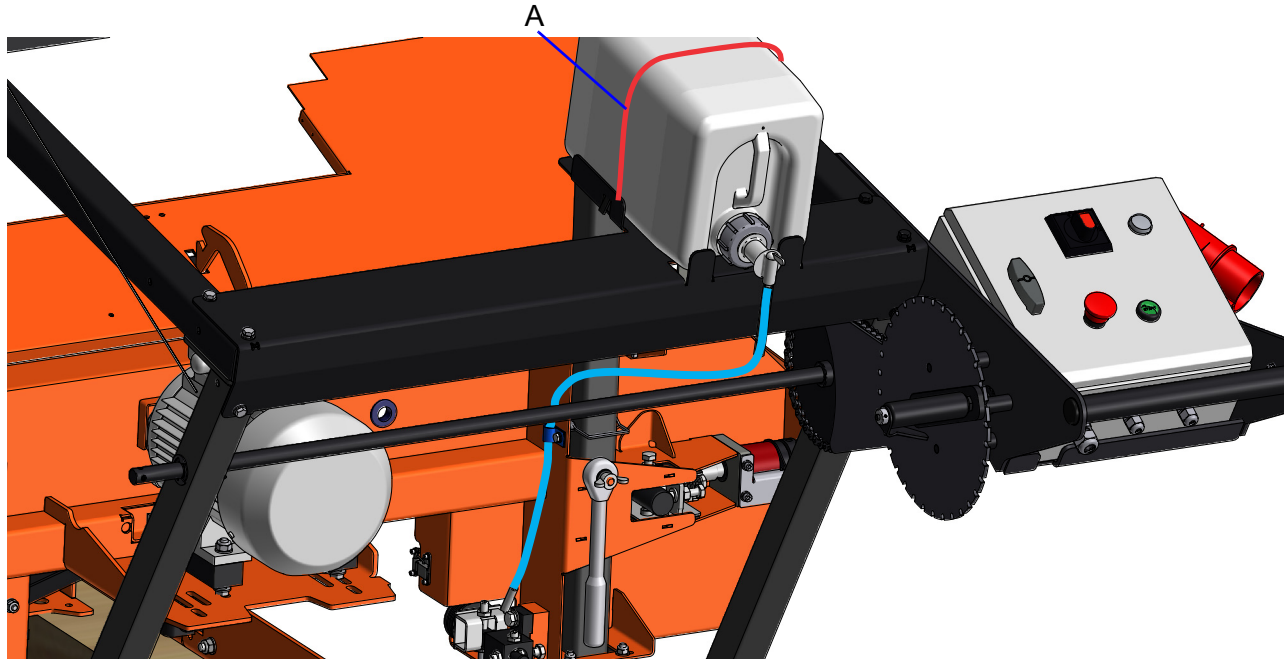


FIG. 2-13

2. Slide the rubber water tube onto the water bottle pipe fitting. Place the other end of the water tube on the fitting located on the blade guide.

See figure 2-14.

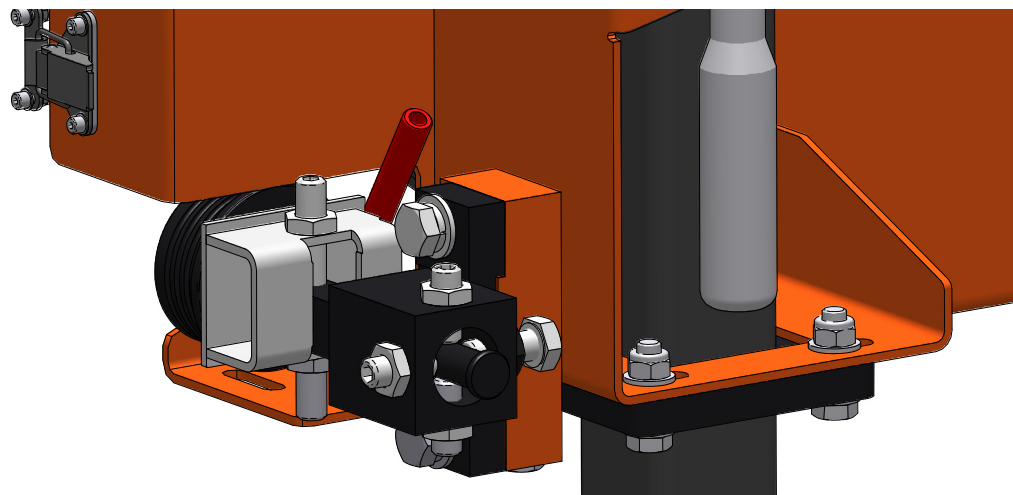
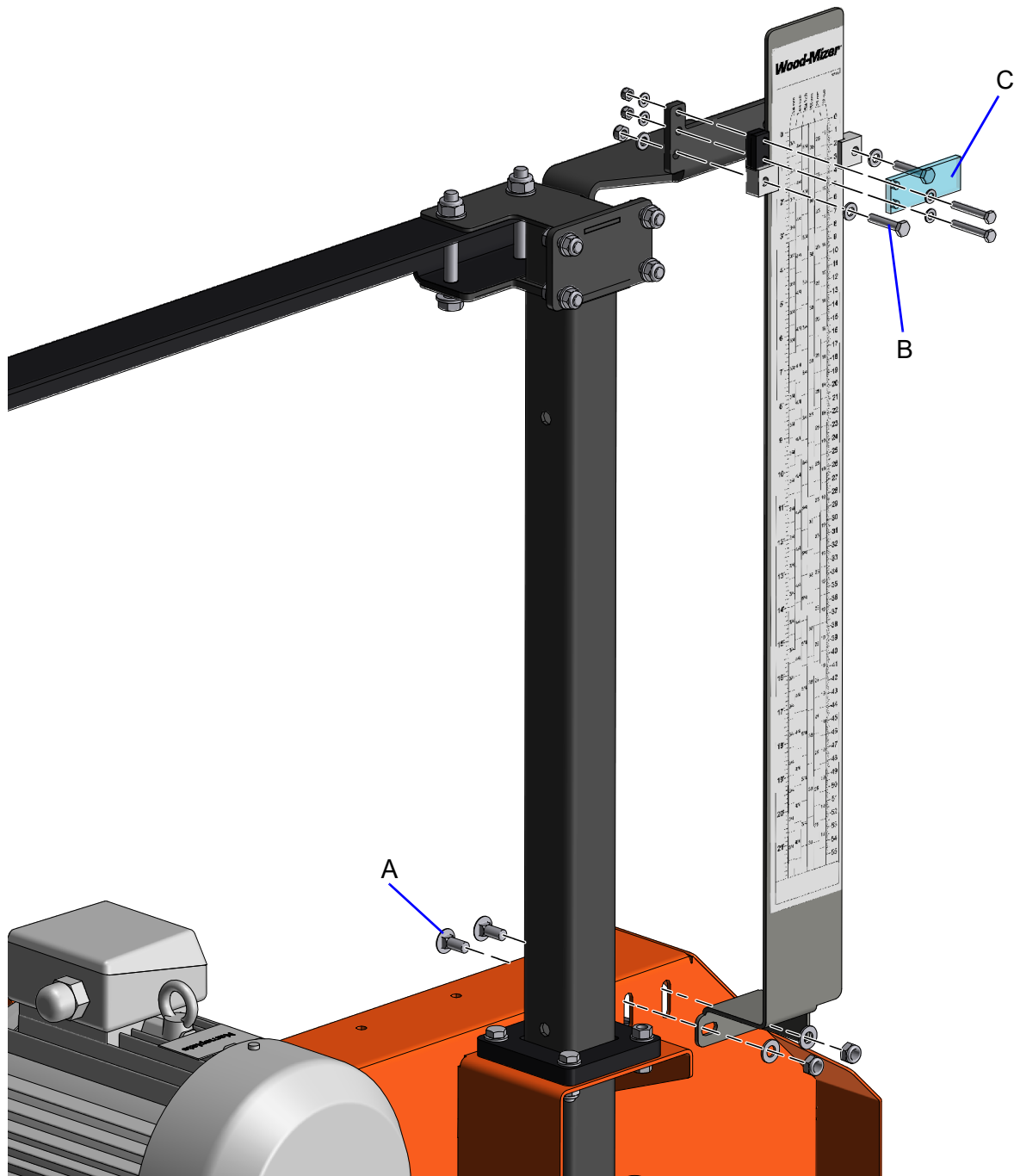


FIG. 2-14

## 2.10 Blade Height Scale Installation

1. Open the saw head cover to install the blade height scale. Use (A) M8x20 bolts to attach blade height scale to the saw head cover. Bolt the scale guide blocks on both edges of the scale using (B) M6x30 bolts. Use (C) M5x35 bolts to install the blade height indicator.



## 2.11 Clutch Lever Installation (Gas Sawmills)

1. Install the emergency stop button (A) on the control box and the safety switch (B) to the clutch lever bracket.

See figure 2-15.

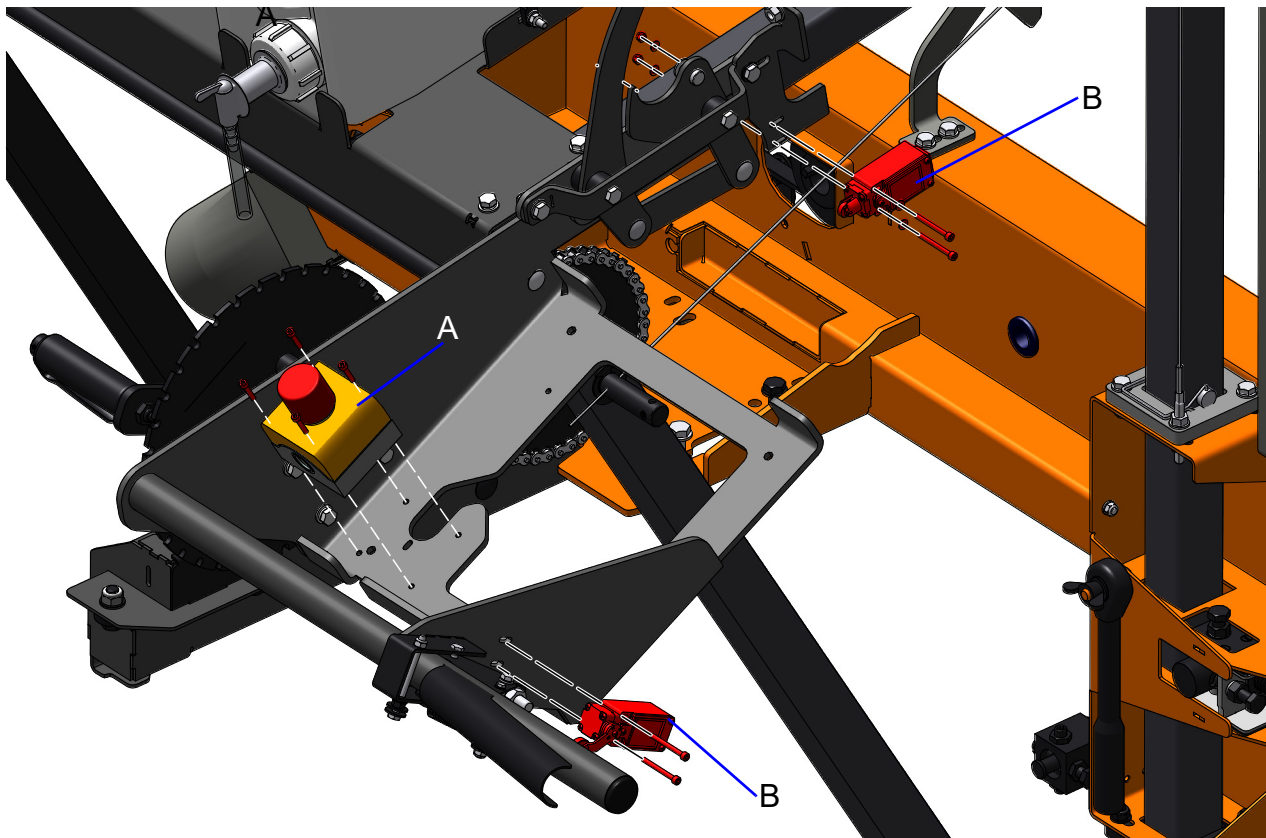
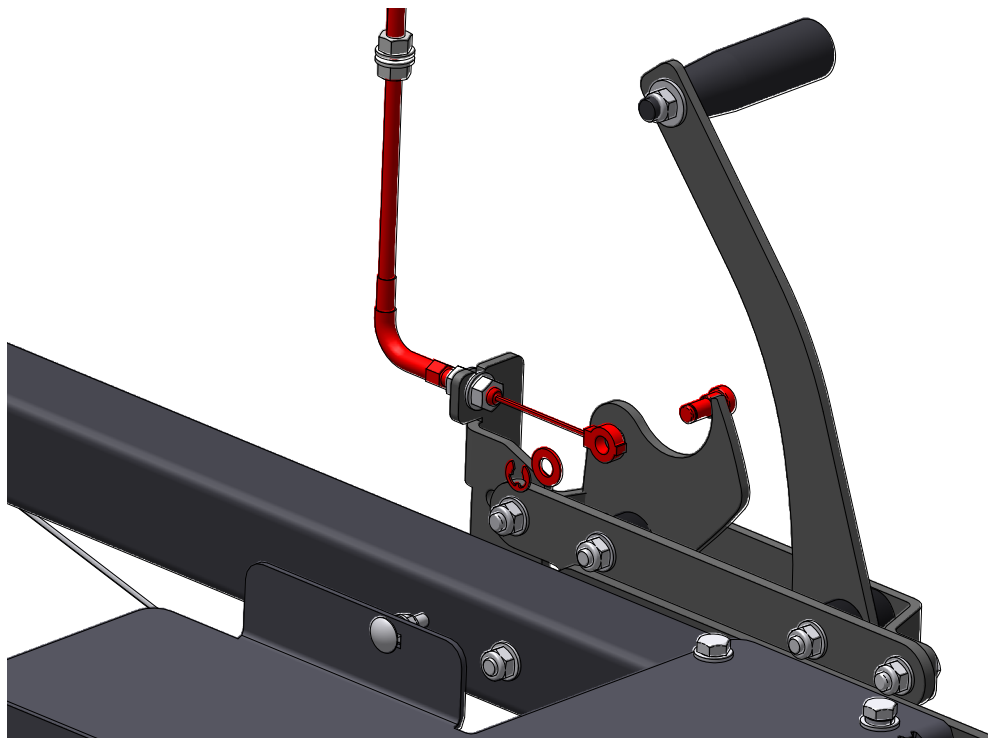


FIG. 2-15

2. Bolt the clutch cable to the lever.

See figure 2-16.



**FIG. 2-16**



3. Install the safety switch to the clutch lever bracket using the two screws as shown below.

See figure 2-17.

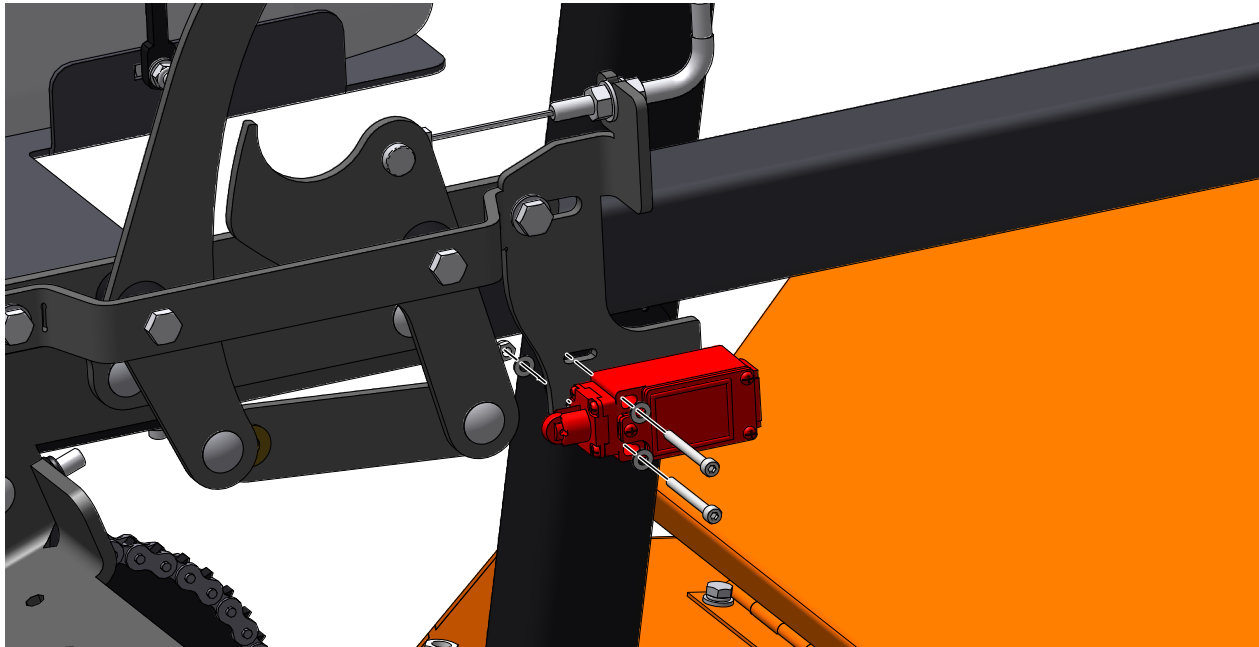


FIG. 2-17

## SECTION 3 SAWMILL OPERATION

### 3.1 Safety Instructions



**DANGER!** Make sure that the motor/engine is off before performing any maintenance. Failure to do so may result in serious injury or death.



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



**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 eye, ear, respiration and foot protection as well as safety clothing when operating or servicing the machine. Failure to do so may result in serious injury or death.



**WARNING!** Always keep a safe distance from the sawdust chute when operating the sawmill. Failure to do so may result in serious injury or death.



**WARNING!** Assemble the sawmill bed on firm, level ground. Failure to do so may cause the saw head to tip, resulting in serious injury or death. If you have a stationary sawmill, fasten it to the floor.



**WARNING!** If the blade or drive belt breaks, wait until all moving parts stop completely. Failure to do so may result in serious injury.

**CAUTION!** Release the blade tension when the mill is not in use (for example at the end of a shift). Tension the blade again before starting the motor/engine.

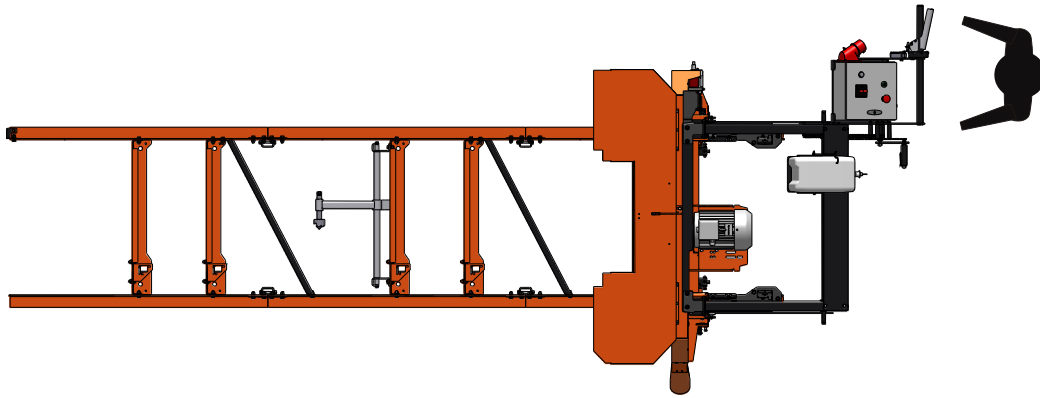
### 3.2 Sawmill Setup



**IMPORTANT!** Before starting to use the sawmill you have to meet the following conditions:

- Clear the area. Inspect the area for debris or uneven surfaces that may become a trip hazard. Ensure that eye, ear and respiration protection are readily available. Ensure that the operator is wearing foot protection and proper work clothing.
- The sawmill must not be operated indoors without a sawdust collection system connected and started.
- Check the engine oil level (DC Sawmill - See the Engine Manual).
- The sawmill must not be operated under roof without a sawdust collection system connected and started.

- AC sawmills must not be used outdoors when it is raining or snowing. In such a case, they must be used and stored under roof or indoors.
- Gas sawmills must not be used indoors. Such sawmills can be operated outdoors without a sawdust collection system, but the operator should be positioned downwind. It will prevent the operator from being exposed to sawdust and engine exhaust gases.
- The sawmill can be operated in the temperature range of  $-15^{\circ}\text{C}$  to  $40^{\circ}\text{C}$
- The intensity of light at the operator's work-place must be at least 300 lx.
- The sawmill's operator position is shown below.



- Have a qualified electrician to install the power supply (according to EN 60204 Standard). The power supply must meet the specifications given in the table below.

See table 3-1.

3-Phase Volts	Circuit Breaker	Suggested Wire Size
400 VAC	8 A	2,5 mm <sup>2</sup> Maximum length: 15 m

**TABLE 3-1**

**IMPORTANT!** When starting the machine for the first time, check that main motor rotation direction is as indicated by the arrow located on the motor body. If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket (electric box). Setting the phases in the phases inverter correctly will ensure correct rotation directions of all sawmill motors.

**WARNING!** If the blade or drive belt breaks, wait until all moving parts stop completely. Failure to do so may result in serious injury or death.

**DANGER!** It is recommended that a Ground Fault Interrupter (GFI) be used.

The LX50 Start sawmills are only partially aligned at the factory. Some assemblies need to be aligned by the user before first usage of the sawmill.

### Assemblies aligned at the factory:

- Engine rpm (DC sawmills only);
- Blade wheels (in vertical and horizontal planes);

## 3.3 Replacing the Blade



**DANGER!** Always disengage the blade and shutoff the sawmill motor/engine before changing the blade. Disconnect the power supply using the main switch. Failure to do so may result in serious injury.



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

Turn the blade tensioner screw to decrease the blade tension until the blade is lying loose in the blade housing. Lift the blade out of the blade housing.

Place a new blade loosely around the blade wheels. When installing the blade, make sure the teeth are pointing the correct direction. Adjust the blade track as instructed in section “Tracking the Blade”.

## 3.4 Tensioning the Blade

A wrench for tensioning the blade is located at the rear of the saw head. Place the wrench on the tensioner screw. Turn the tensioner screw right until the tension indicator is in the middle of the notch indicating the correct tension.

See figure 3-1.

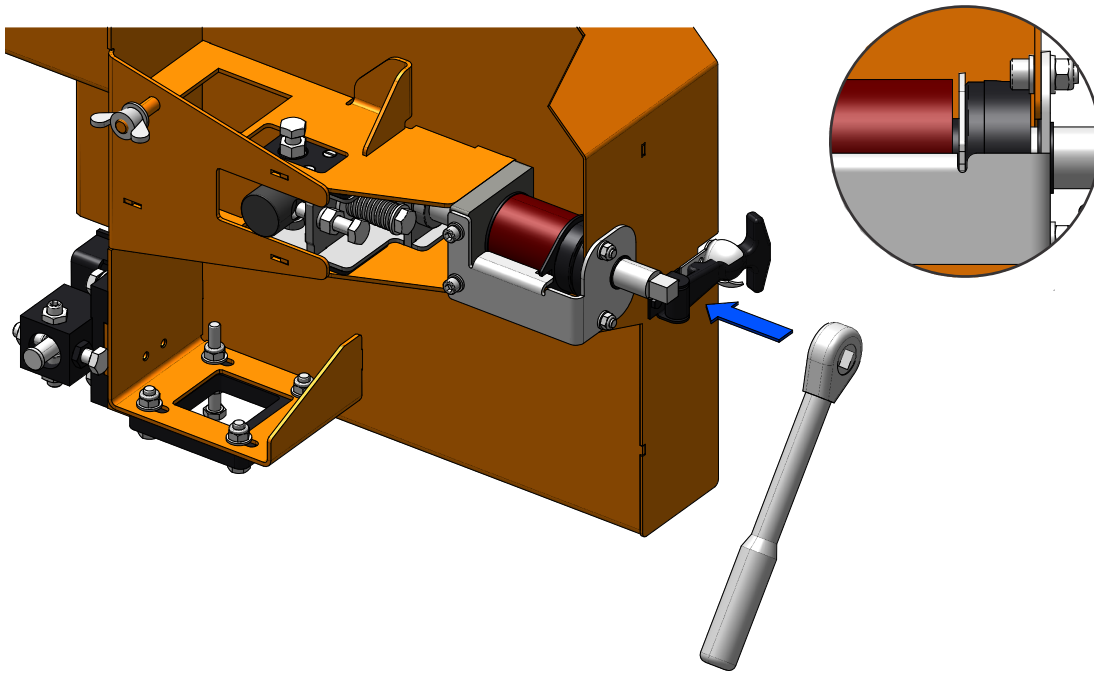



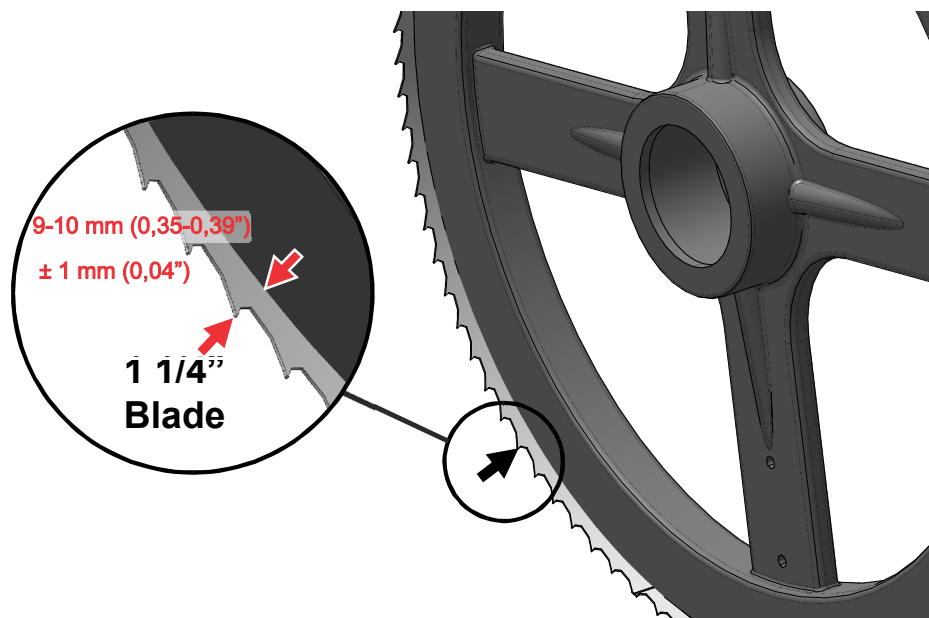
FIG. 3-1

 **CAUTION!** Release the blade tension after you have finished using the sawmill (e.g. after each shift). Place information on the machine for other operators that it is necessary to tension the blade again before further sawmill operation.

### 3.5 Tracking the Blade

After tensioning the blade, check its position on the blade wheels.

**See figure 3-2.** Position 1 1/4" (32 mm) wide blades on the blade wheels so the blade teeth are 9-10 mm ( $\pm 1$  mm) out from the edge of the wheel. Make sure the rear edge of the blade is lying flat on the wheels and is no more than 3mm out from the edges of the blade wheel belts.



**FIG. 3-2**

To track the blade properly on both blade wheels:

- (CE electric version) - open the blade housing cover, set the key switch to the "H" position and spin the blade wheel by hand a few times.
- (Non- CE electric version) - open the blade housing cover and spin the blade wheel by hand a few times.
- (Gas engine version) - open the blade housing cover and spin the blade wheel by hand a few times.

Two cant control bolts are located at the rear of the saw head, on both sides.

### 3.6 Horizontal Adjustment of Idle-Side Blade Wheel

First, adjust the idle-side blade wheel horizontally. To do this, loosen the set nuts on the adjustment bolts and tilt the blade wheel until it is properly aligned.

See figure 3-3. Bolt for adjusting the idle-side wheel is shown below.

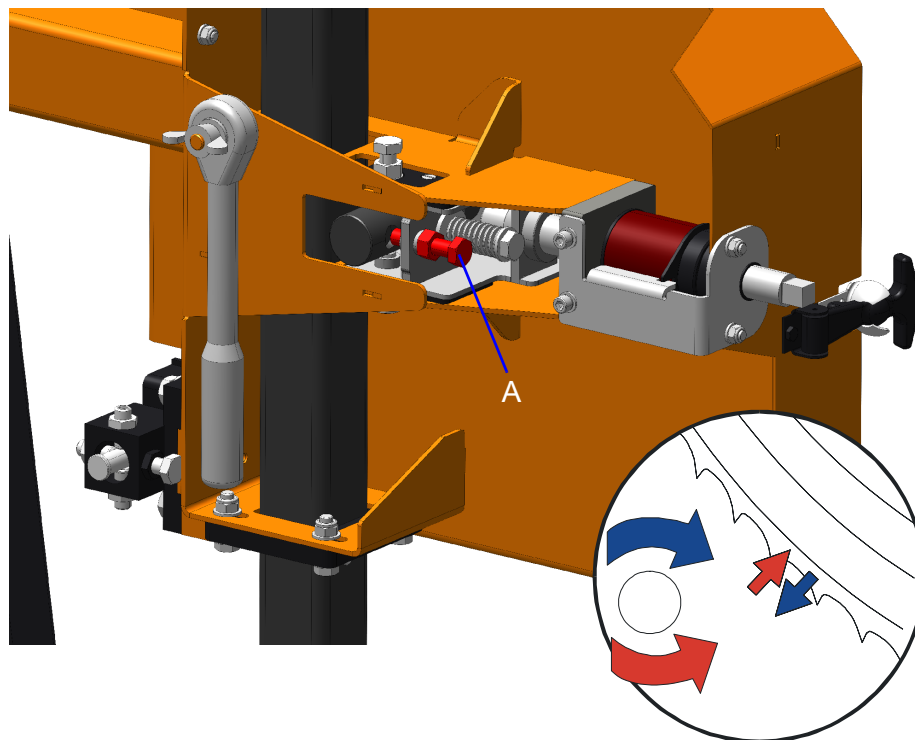
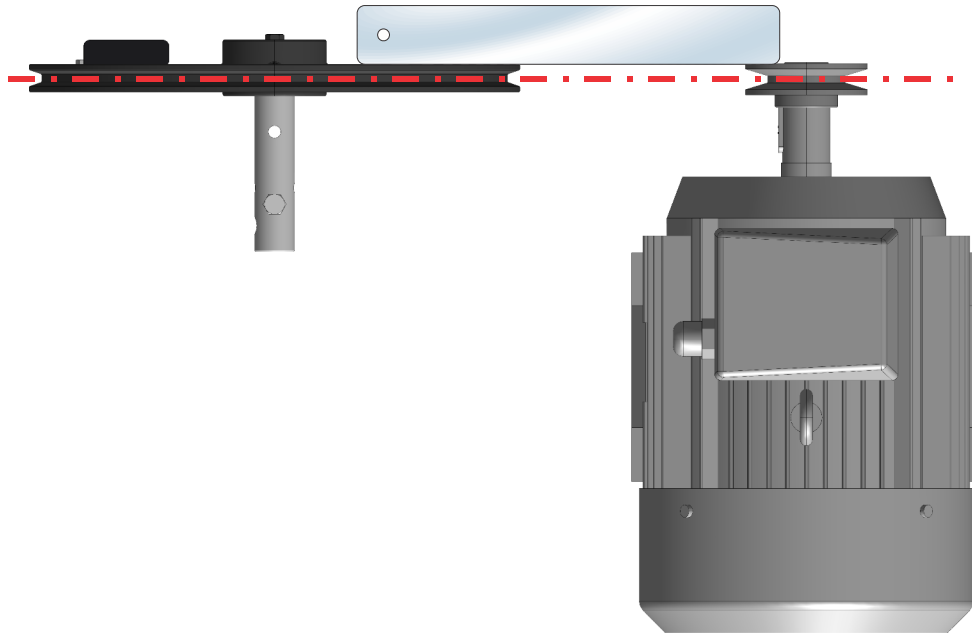


FIG. 3-3

If the blade is too far out, back the blade onto the wheel by turning the cant control bolt left. If the blade is too far in, turn the cant control (A) right until the gullet of the blade is the correct distance from the front edge of the wheel.

### 3.7 Motor Drive Pulley Alignment

See figure 3-4. Check that the motor drive pulley is aligned with the blade wheel using a ruler as shown below.



**FIG. 3-4**

To align the pulleys, loosen or tighten the bolts in the motor mount plates on both sides of the motor. Incorrect pulley alignment may result in premature drive belt wear.



### 3.8 Horizontal Adjustment of Drive-Side Blade Wheel.

Check the position of the blade on the drive-side blade wheel. The blade should be positioned on this wheel as described for the idle blade wheel. If not, adjust the drive wheel horizontally.

**See figure 3-5.** Use the adjustment screw (A) shown below to adjust the drive-side blade wheel horizontally. First, loosen the nut on this screw. If you want to move the blade on the wheel away from the machine, loosen the screw. To move the blade towards the machine, tighten the screw. Be sure to tighten the nut after adjustment.

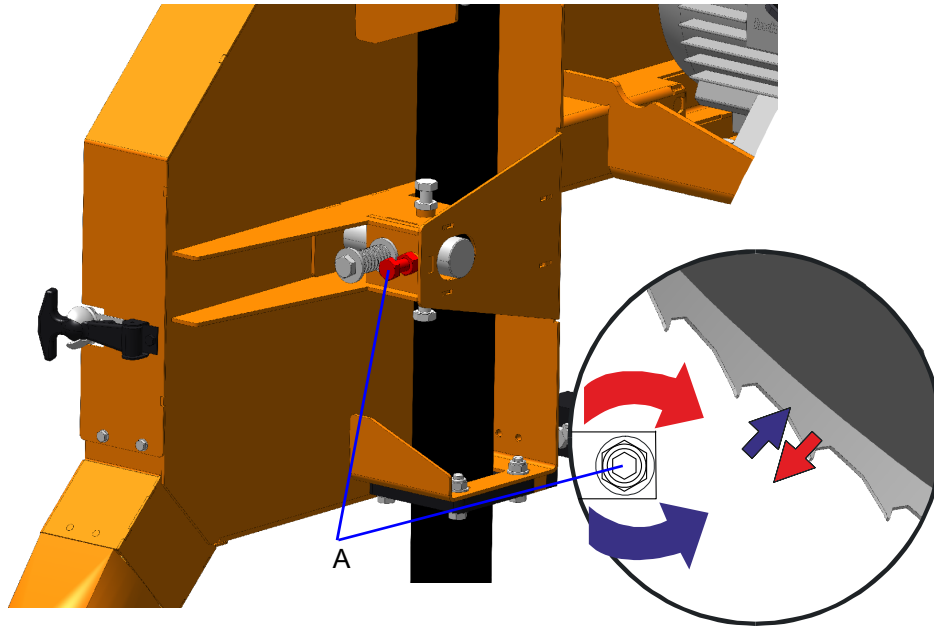


FIG. 3-5

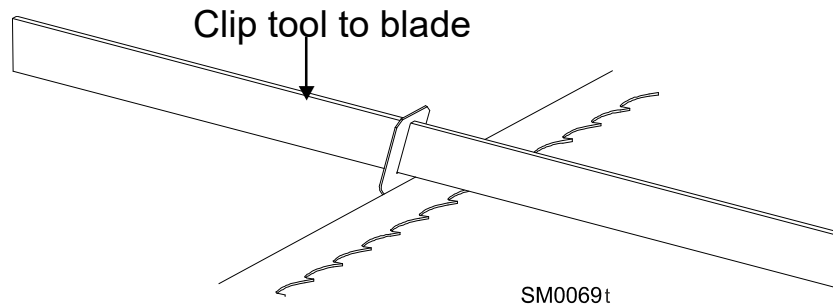
### 3.9 Vertical Adjustment of Drive-Side Blade Wheel

The blade wheels must be square to the sawmill bed and parallel to each other in the vertical and horizontal planes. If the blade wheels are tilted up or down, the blade will not be properly adjusted in relation to the sawmill bed and sawn wood. If the blade wheels are tilted horizontally, the blade will not track properly on the wheels.

Use the blade guide alignment tool to check the vertical alignment of each blade wheel.

1. Attach the alignment tool to the blade near the drive-side blade guide. Be sure the tool does not rest on a tooth or burr and is lying flat against the blade.

See figure 3-6.



**FIG. 3-6**

2. Move the saw head so the front end of the tool is positioned over the first bed rail. Measure the distance from the bottom of the tool to the top surface of the bed rail.
3. Move the saw head so the rear of the tool is positioned over the bed rail. Again, measure the distance from the bottom of the tool to the bed rail.
4. If the two measurements differ by more than 1/16" ( $\pm 1,5$  mm), adjust the vertical tilt of the drive-side blade wheel.

**See figure 3-7.** Use the screws shown below to adjust the drive blade wheel vertically. To tilt the wheel down, loosen the top adjustment screw a half turn. Loosen the jam nut on the bottom adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

To tilt the wheel up, loosen the bottom adjustment screw a half turn. Loosen the jam nut on the top adjustment screw and tighten the screw. Tighten the top and bottom jam nuts.

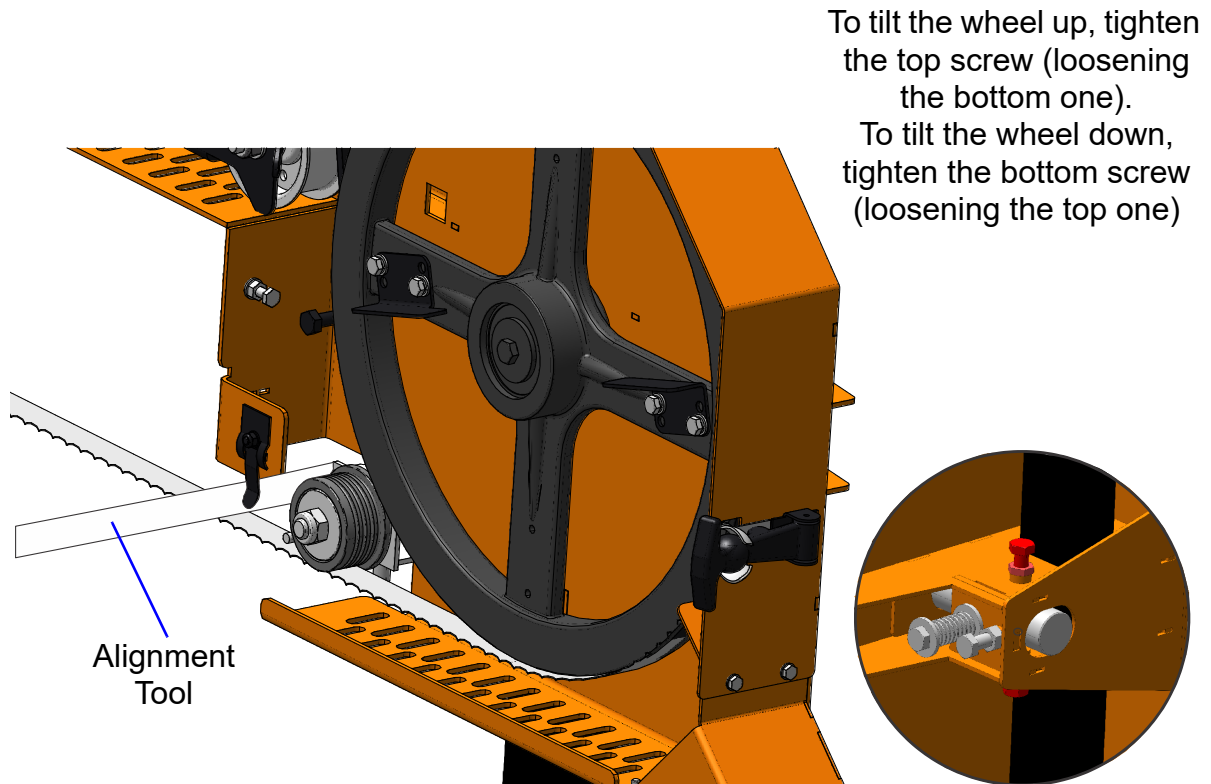


FIG. 3-7

5. Measure again the distance between the tool and the bed rail at both ends of the tool. If the measurements at the front and rear ends of the tool still differ by more than 1/16" ( $\pm 1,5$  mm), readjust the drive-side blade wheel in the vertical plane.

### 3.10 Vertical Adjustment of Idle-Side Blade Wheel

1. Attach the alignment tool to the blade near the idle-side blade guide.
2. Measure the distance from the bottom of the tool to the bed rail at both ends of the tool. If the measurements are not equal ( $\pm 1,5$  mm), adjust the idle-side blade wheel in the vertical plane.

**See figure 3-8.** To tilt the idle-side blade wheel up, loosen the lower nut and adjustment screw 1/2 turn, loosen the nut on the upper adjustment screw and tighten the upper screw. Then tighten the upper and lower nut.

To tilt the idle-side wheel down, loosen the upper adjustment screw 1/2 turn, loosen the nut on the lower adjustment screw and tighten the lower screw. Tighten the upper and lower nut.

### 3 Sawmill Operation

#### Vertical Adjustment of Idle-Side Blade Wheel

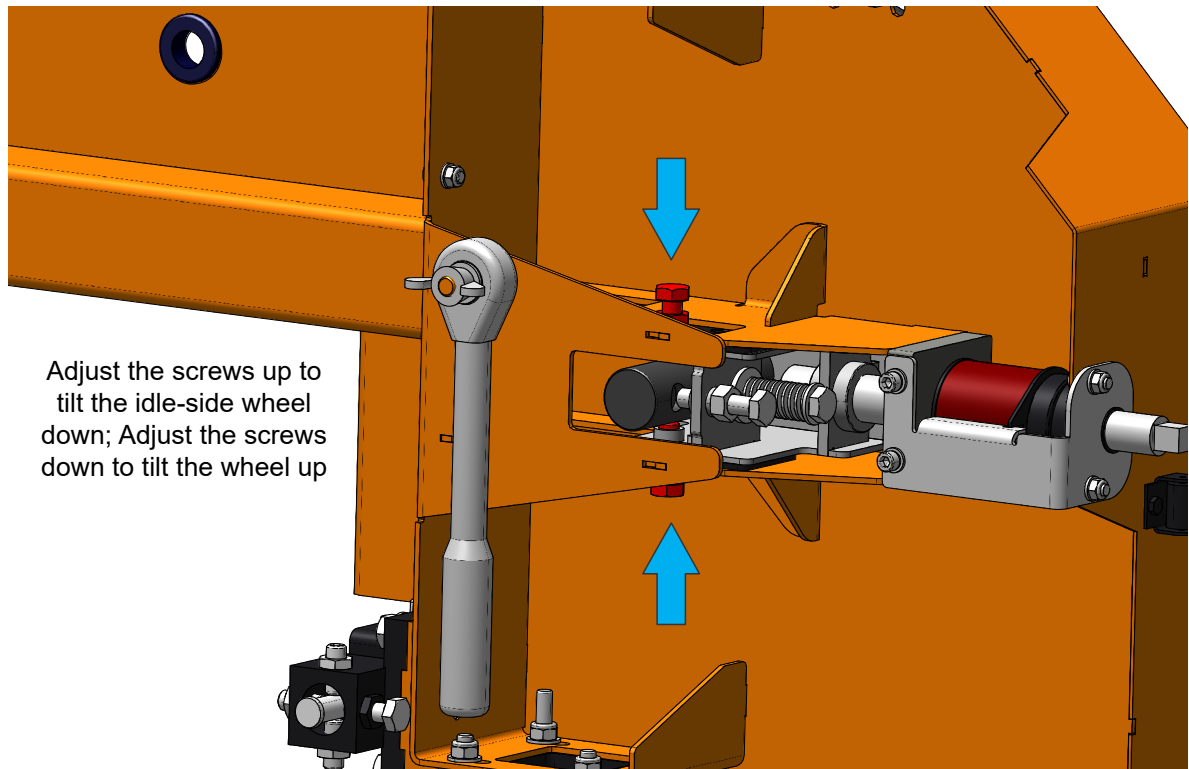


FIG. 3-8

3. Recheck the vertical tilt of the idle-side blade wheel. If it is still incorrect, repeat the adjustment procedure.
4. Check the position of the blade on the blade wheel.

See figure 3-9. The figure below shows the screws for positioning the blade on the blade wheels.

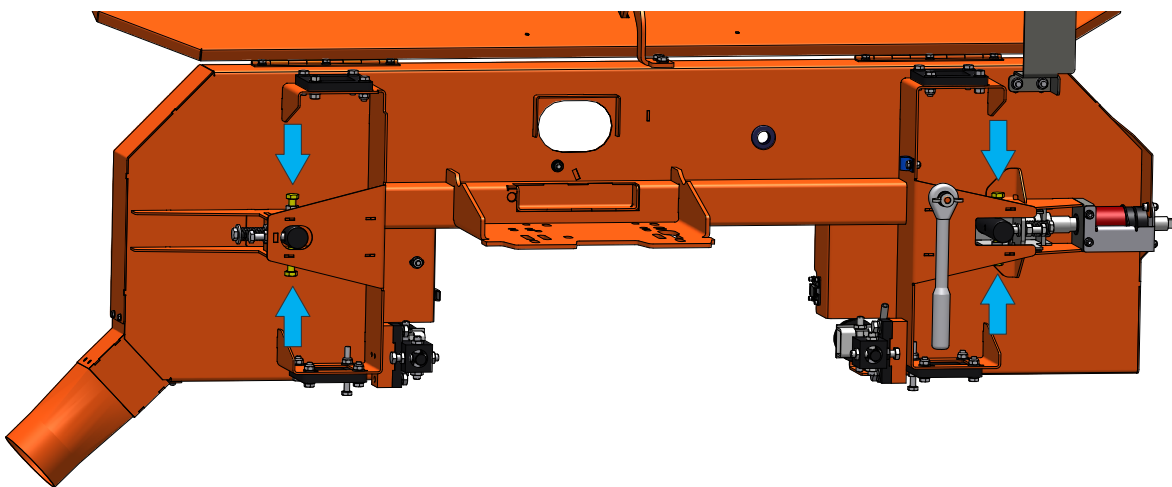


FIG. 3-9

### 3.11 Saw Head Adjustment

1. Check that the tensioned blade is parallel to a bed rail. To do this, measure the distance between the blade and the bed rail on both sides of the saw head. If the two measurements are not the same, adjust the saw head in relation to the bed on one or both sides, as necessary.
2. To adjust the saw head, move the threaded rod (on which the lift cable is installed) up or down. To move the saw head up, loosen the lower jam nut and tighten the upper nut. For the user's safety, the lift cable bracket with the cable locking screw must be tightened all the way. After adjustment, the lift cable locking screw should be in the same position as shown on the figure below.
3. When adjusting the saw head, be careful not to loosen the upper nut completely as it can cause the saw head to lower.

See figure 3-10. The figure below shows the screws for positioning the blade on the blade wheels.

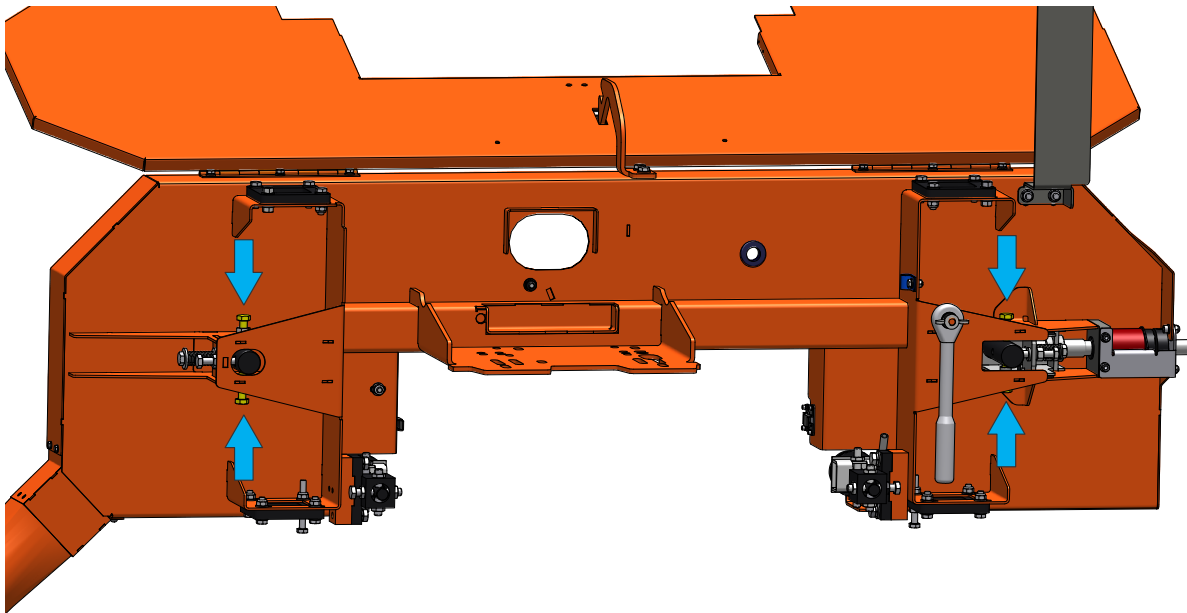


FIG. 3-10

### 3.12 Blade Deflection

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

1. Position the saw head so that the blade is above a bed rail. Measure the actual distance with a tape from the top of the rail to the bottom of the blade.

See figure 3-11.

Use the jam nuts to adjust the roller

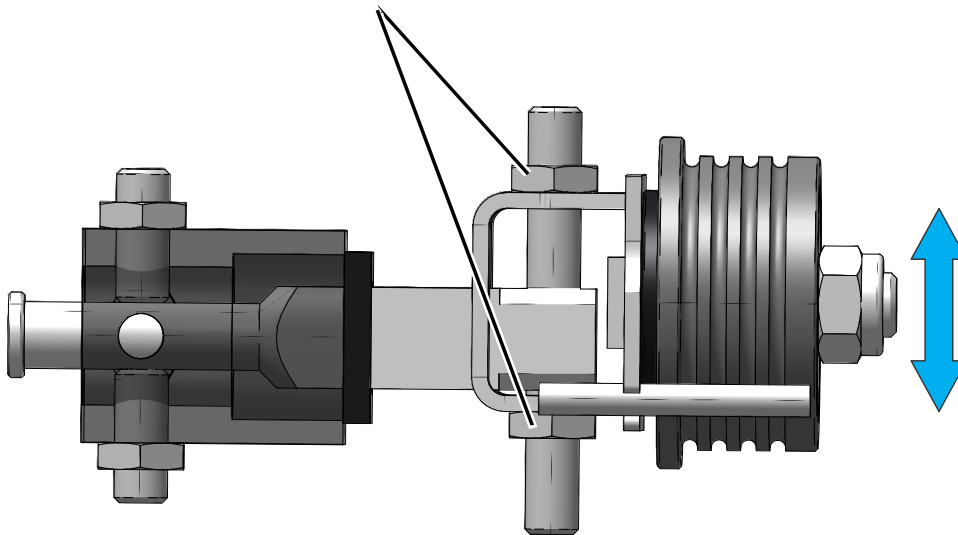


FIG. 3-11

2. Loosen the bottom jam nut and tighten the top jam nut until the blade guide deflects the blade down 3 - 4 mm.
3. Repeat for the other blade guide.
4. **NOTE:** Be sure the blade guard clears the blade. It should be checked with the blade guard all the way in and all the way out.

### 3.13 Blade Guide Vertical Adjustment

Check that the blade guides does not tilt the blade up or down. A Blade Guide Alignment Tool is provided to help you measure the vertical tilt of the blade.

1. Attach the alignment tool to the blade. Position the tool close to a blade guide roller. Be sure the tool does not rest on a tooth or burr, and is lying flat against the blade..

See figure 3-12.

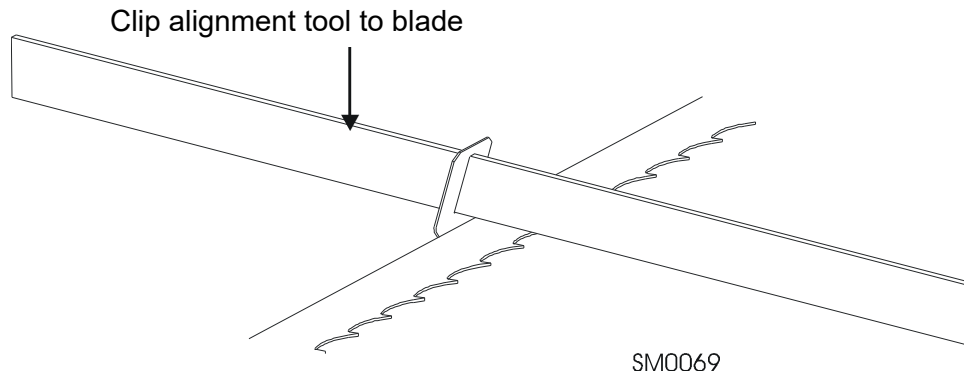


FIG. 3-12

2. Measure the distance from the bottom of the tool to the bed rail.
3. Move the saw head so that the front end of the tool is positioned above the bed rail.
4. Measure again the distance between the tool and bed rail.
5. The two measurements should be the same. If they are not, loosen one side set screw of the guide assembly and adjust the blade guide in the vertical plane using the screws shown in Figure 3-12.

See figure 3-13.

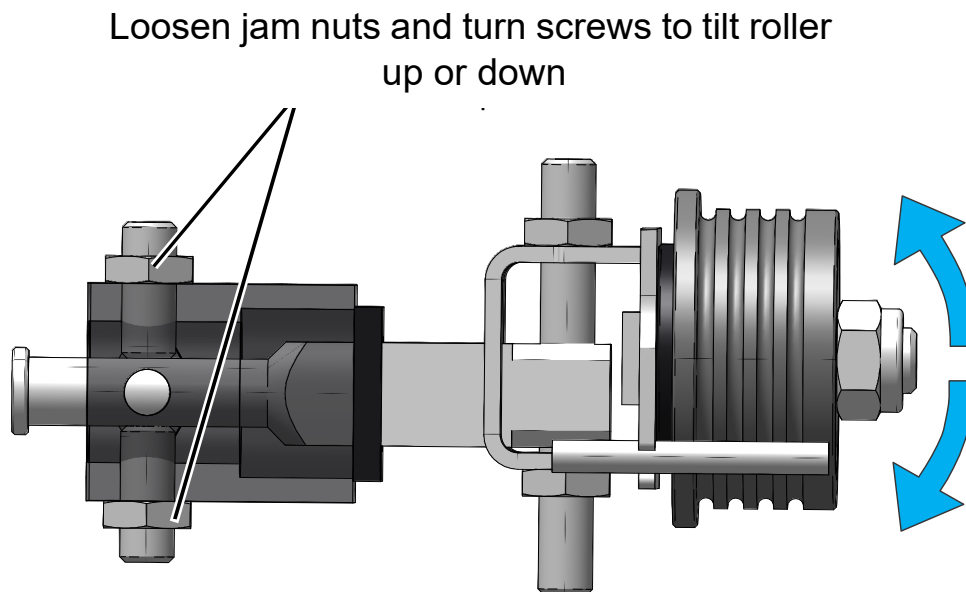


FIG. 3-13

6. Move the saw head in the cutting direction so the back end of the tool is over the bed rail. Measure the distance between the tool and the bed rail.

7. This measurement should equal the two earlier measurements. If it is not the same, adjust the blade guide using the screws shown in the figure above.
8. Move the tool close to the other blade guide and repeat the adjustment procedure described above.

**NOTE:** If any adjustments to blade guide tilt were made, make sure the blade deflection is correct (3 mm).

**NOTE:** After adjusting the blade guides, start the blade drive for a moment. Then stop the blade and check again if the blade guides are properly positioned.

### 3.14 Blade Guide Spacing Adjustment

**HINT:** To adjust the spacing between the roller flange and the blade, loosen one top and one side set screw only. This will ensure horizontal and vertical adjustments to the blade guide tilt are maintained when the set screws are retightened.

1. Adjust the blade guide so the blade guide roller flange is approximately 1.5 - 3.0 mm from the back of the blade.
2. Loosen one side and one top set screw shown. Tap the blade guide forward or backward until properly positioned.

See figure 3-14.

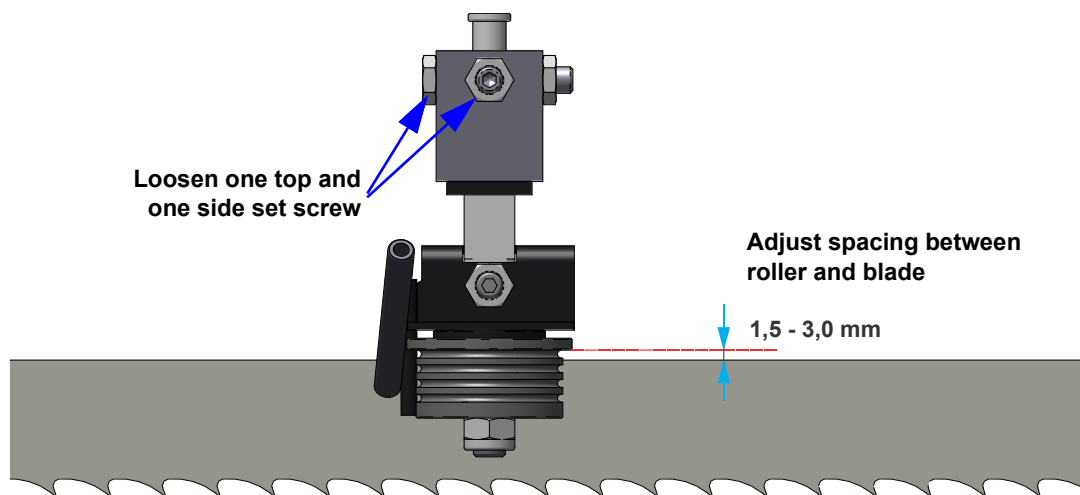


FIG. 3-14

3. Tighten the set screws.
4. Repeat the above adjustment procedure for the other blade guide.

**NOTE:** After adjusting the blade guide spacing, start the blade drive for a moment. Then stop the blade and recheck the spacing.



### 3.15 Blade Guide Horizontal Adjustment

See figure 3-15.

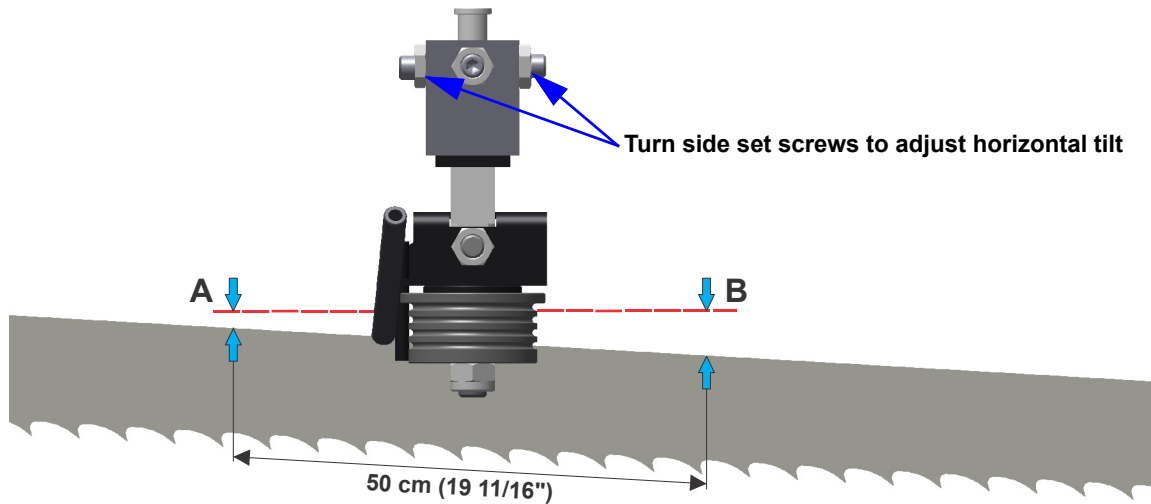


FIG. 3-15

1. Place the Blade Guide Alignment Tool against the face of a blade guide roller and center it on the roller as shown above.
2. Measure between the back edge of the blade and the tool at one end of the tool ("B").
3. Measure between the back edge of the blade and the other end of the tool ("A").
4. The blade guide roller should be parallel to the blade ( $A=B$ ) or slightly tilted in the horizontal plane as shown in Figure 4-13 ( $A=B-6$  mm). If this condition is not met, adjust the roller in the horizontal plane using the side set screws on the blade guide.
5. Repeat the above steps for the other blade guide.

**NOTE:** Once the blade guides have been adjusted, any cutting variances are most likely caused by the blade.

### 3.16 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.

See figure 3-16.

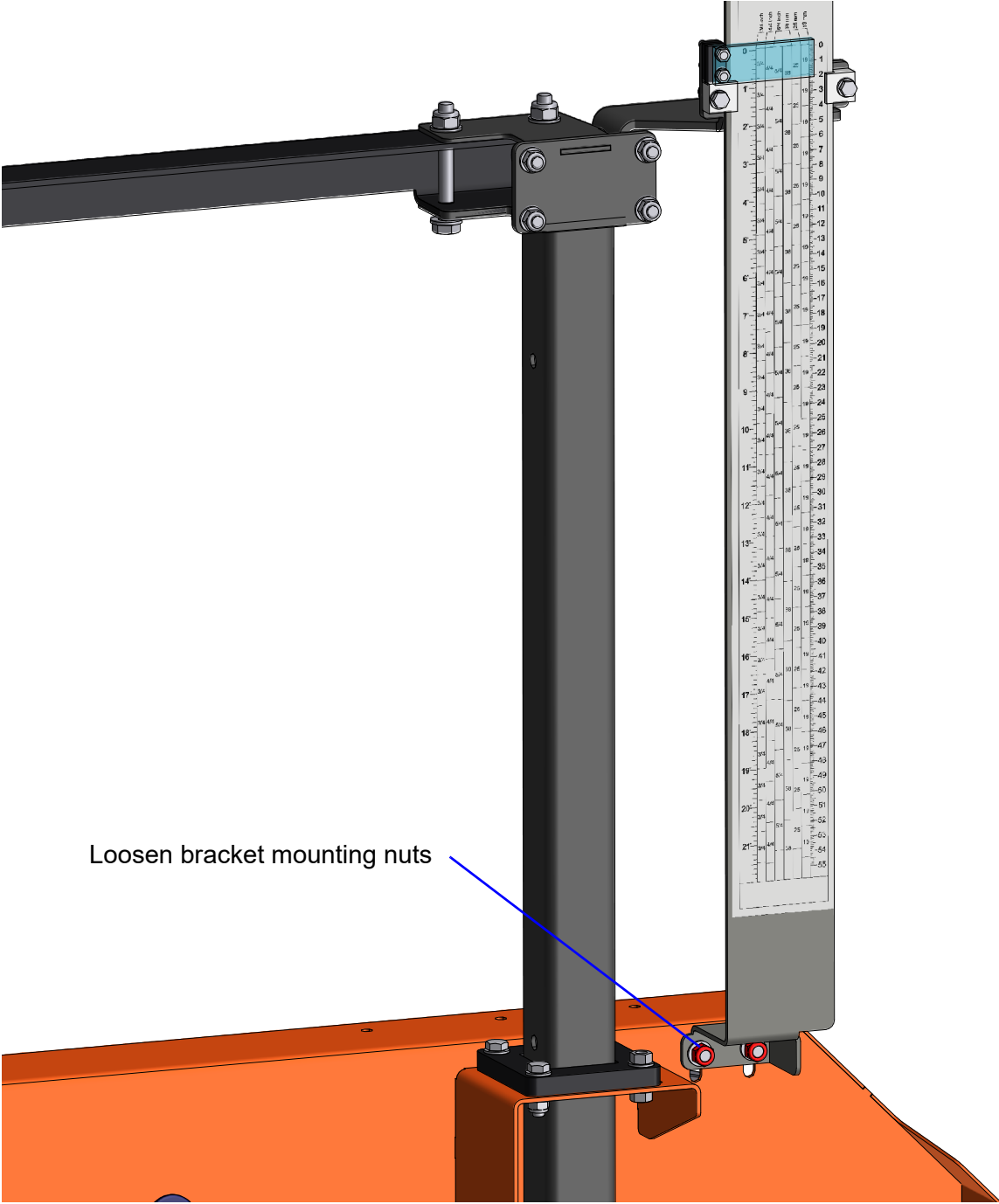


FIG. 3-16

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.
2. Loosen the scale bracket mounting bolts and nuts, adjust the scale position until the scale indicator reads the distance measured in the previous step. Retighten the bracket mounting bolts and nuts.

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

### 3.17 Engine/Motor Drive Belt Adjustment

1. On sawmills equipped with the electric motor, the drive belt is adjusted by adjusting the tensioner screw nuts (see the figure below)

See figure 3-17.

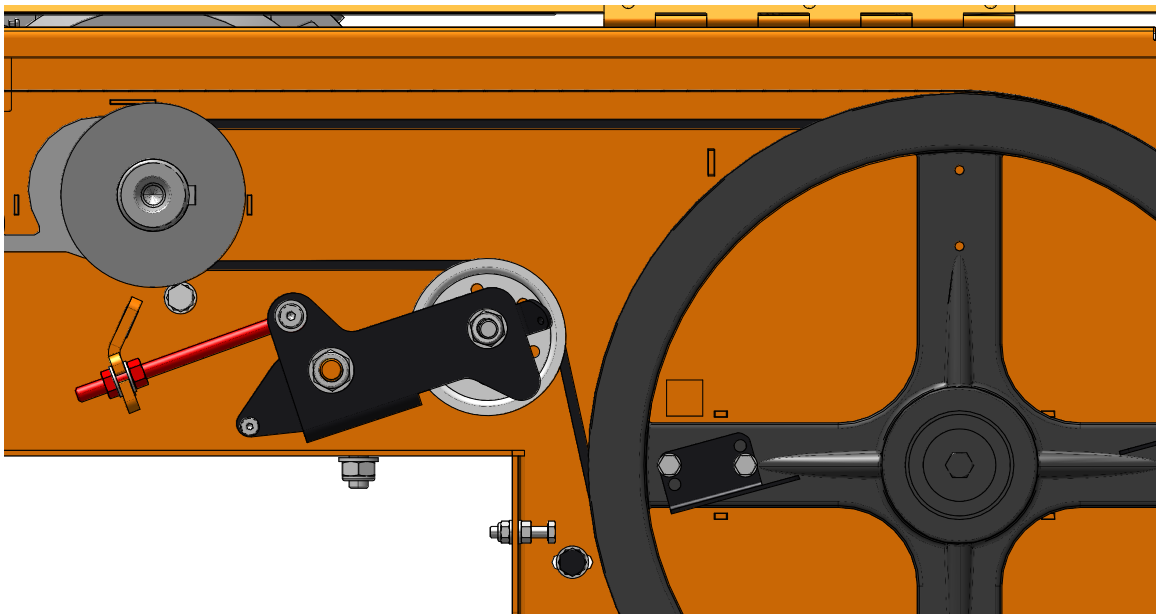


FIG. 3-17

2. To adjust the drive belt on sawmills with the gas engine, increase or reduce the steel cable connecting the tensioner handle with the belt tensioner. If necessary, adjust also the length of the throttle cable connecting the tensioner with the engine throttle. The drive belt is tensioned properly if the drive pulley is fully engaged when the tensioner handle is in the down position. The throttle cable is adjusted properly if the engine runs at full rotational speed (3600 r.p.m.) when the tensioner handle is pushed down. When the tensioner handle is released, the engine should return to idle and the drive pulley should stop spinning.

See figure 3-18.

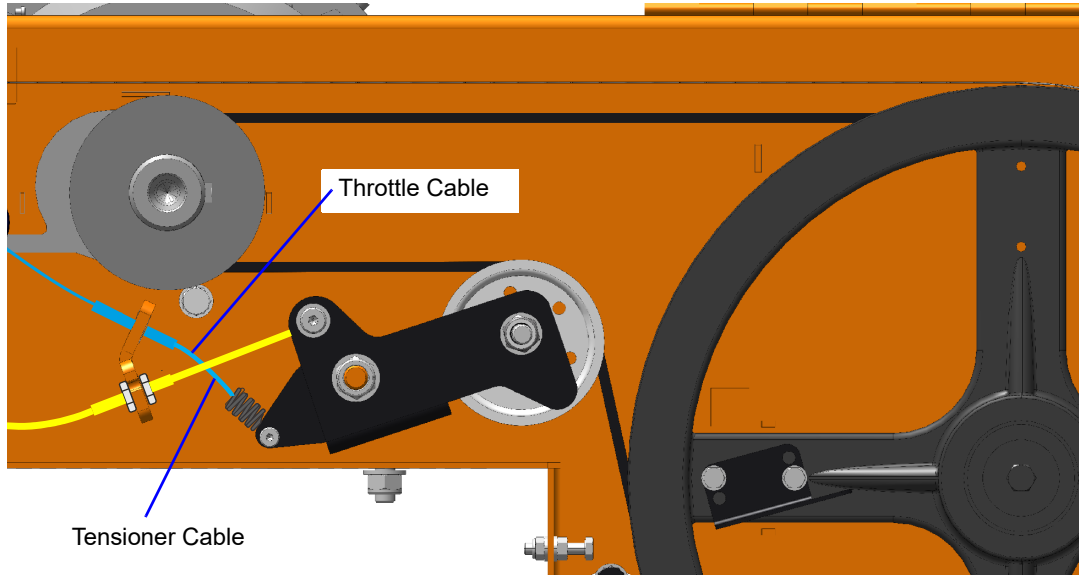






FIG. 3-18

### 3.18 Starting the Engine/Motor


See the engine/motor manual supplied with your machine for starting and operating instructions.

-  **IMPORTANT!** When starting the machine for the first time, check that main motor rotation direction is as indicated by the arrow located on the motor body. If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket. Setting the phases in the phase inverter correctly will ensure correct rotation directions of all sawmill motors (it concerns sawmills with electric motors).
-  **DANGER!** Make sure all guards and covers are in place and secured/closed before operating the sawmill. Failure to do so may 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 may result in serious injury.
-  **WARNING!** Always wear eye, ear, respiration and foot protection as well as safety clothing when operating the sawmill. Failure to do so may result in serious injury.


### 3.19 Loading, Turning and Clamping Logs

#### To load a log:

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

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

2. Lower the log clamp completely and move it toward the loading side of the sawmill frame.

 **CAUTION!** Be sure the log clamp is all the way down before loading a log onto the bed. Failure to do so may result in machine damage.

3. Raise the side supports on the sawmill bed to prevent the log from falling off the side of the bed.
4. Position the log parallel to the sawmill bed.
5. Use a cant hook to roll the log onto the sawmill bed. Position the log against the side supports.


If your sawmill is not equipped with the loading ramps, use other log loading equipment to load the log onto the sawmill bed. You can also use boards to do this.

#### To turn a log:

1. Use a cant hook to spin the log against the side supports until it is turned the way you want it for the first cut

#### To clamp a log:

1. Position the log clamps against the log, far enough down so they are below your cuts on a given side of the log. Using the clamp handle, move the log firmly against the side supports.
2. Be sure to leave the crank in the bottom position to avoid damage to the blade during sawing operation.

 **CAUTION!** The log clamp should be mounted in such a place to clamp log in its middle part.

See figure 3-19.

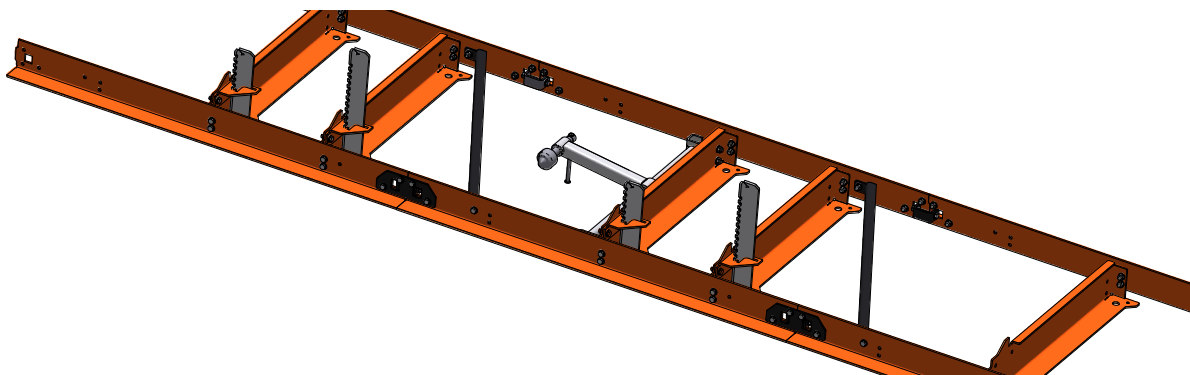


FIG. 3-19

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 height of your last cut on a given side of the log.

### To level a log:

Shim one end of the log (e.g. using an optional leveling wedge “A”) until the heart of the log measures the same distance from the bed rails at each end of the log.

See figure 3-20.

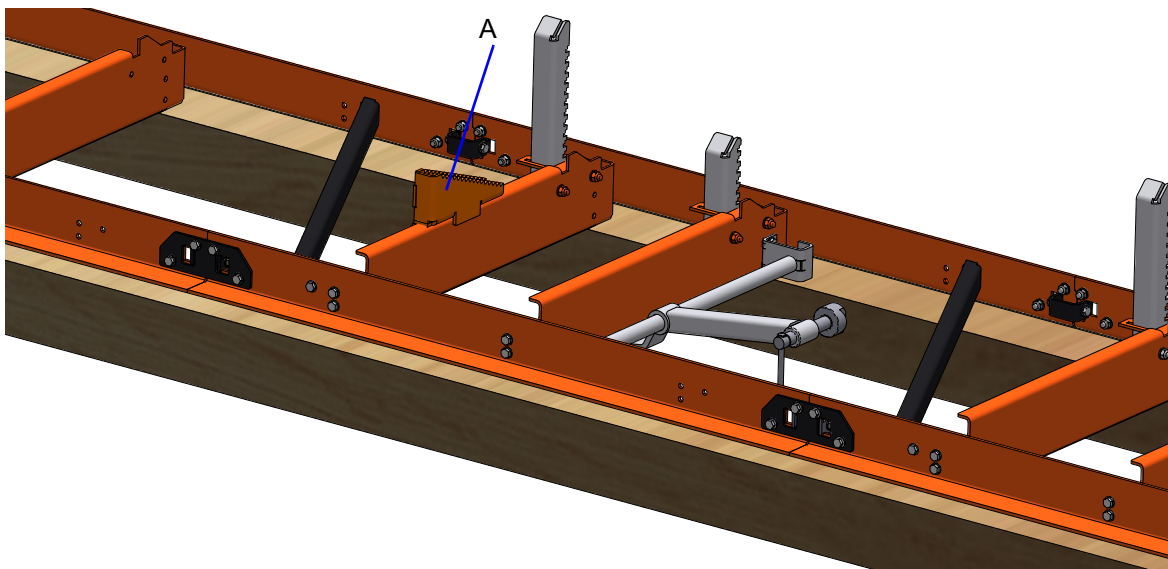


FIG. 3-20

## 3.20 Up/Down Operation

1. Install a blade, if needed, and check for correct blade tension.
2. Using the crank handle, set the saw head to the desired height (the blade height scale shows the height of the blade above bed rails). One full turn of the crank handle moves the saw head 12.21 mm. If you rotate the crank handle by one tooth on the disc, the saw head will be raised/lowered 0.18 mm.

See figure 3-21. Use the crank handle to raise or lower the saw head.

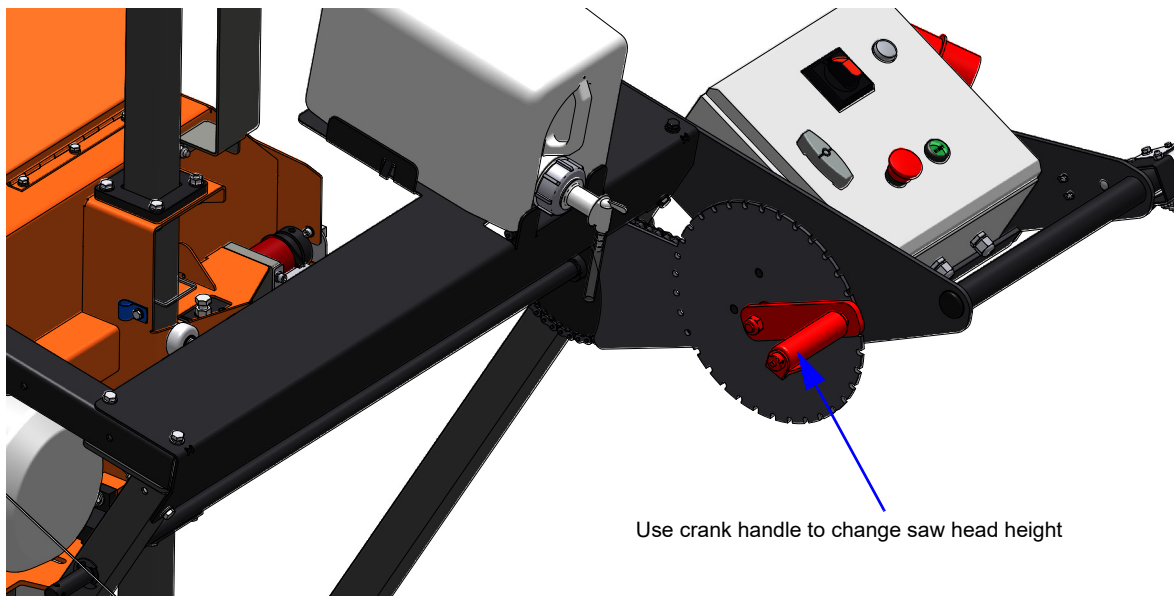




FIG. 3-21

 **CAUTION!** DO NOT try to force the saw head above the 50 cm mark or below the 2.54 cm mark. Damage to the up/down system may result.

### 3.21 Blade Drive Operation

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

Be sure the blade housing cover is closed and secured before starting the engine or motor. Use the rubber latches to fasten the blade housing cover shut. If the blade housing cover is not closed and secured, the safety switch located on it makes starting the motor/engine impossible. If you open the cover during sawmill operation, the blade engine/motor will be stopped.

#### For Sawmills with the Electric Motor

1. Clear any loose objects from the area of the blade, motor, and drive belt.
2. Make sure the clamps and side supports are positioned low enough for the blade to pass over them. Make sure the log is clamped securely.
3. Start the motor. To do this, turn the main switch to the "I" position and turn the key. Then push and hold the safety handle and start the blade motor by pressing the green button on the electric box.

See figure 3-22.

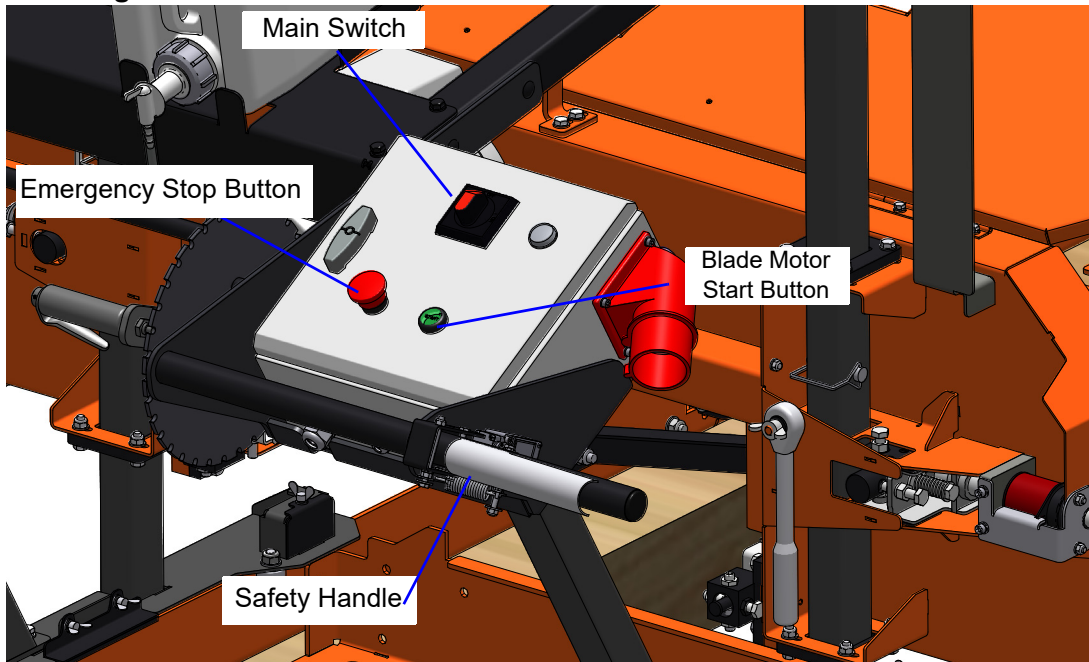


FIG. 3-22





**CAUTION!** If at any time you need to immediately stop the blade motor, press the emergency stop button located on the electric box.

4. To turn off the blade motor, release the safety handle.



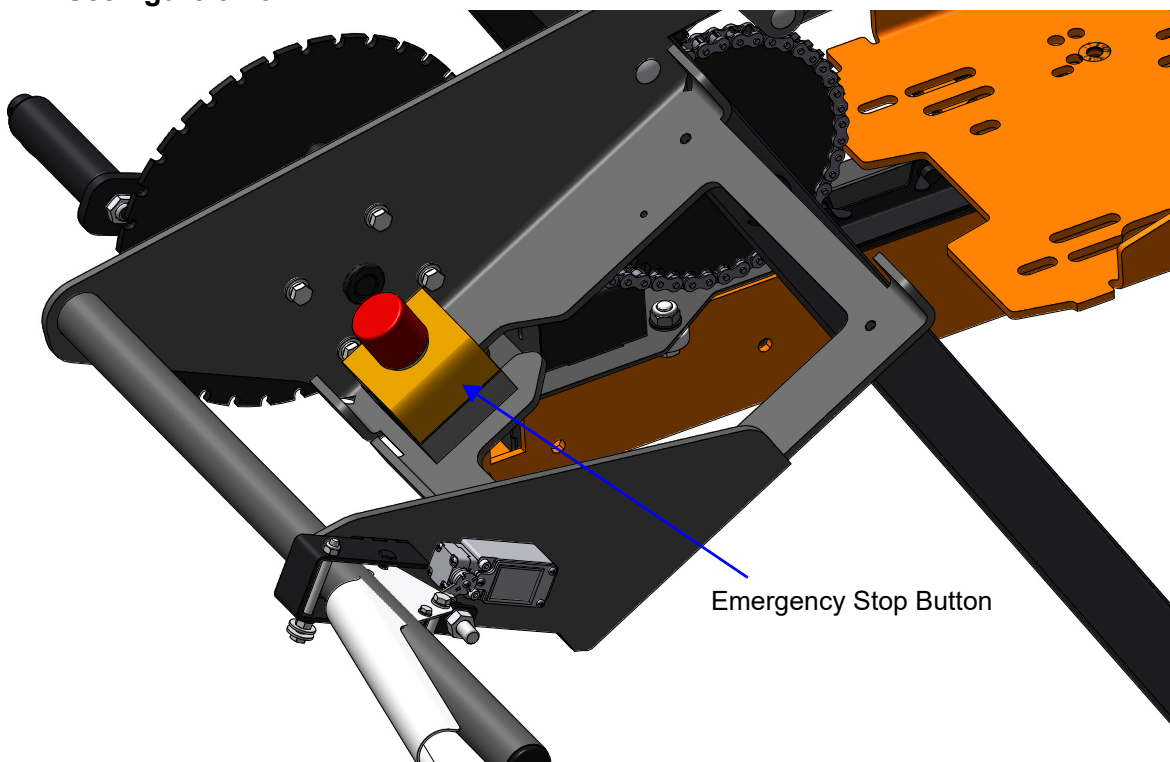
### 3.22 Gas Engine Operation (G9)

 **WARNING!** Do not start the engine if the drive belt tensioner handle is ENGAGED. Always be sure the blade is disengaged and all persons are out of the path of the blade before starting the engine.


 **IMPORTANT!** Read the engine manual for instructions and safety precautions before operating the engine.

1. Clear any loose objects from the area of the blade, engine, and drive belt.
2. Make sure the clamps and side supports are positioned low enough for the blade to pass over them. Make sure the log is clamped securely.

See figure 3-23.



RYS. 3-23.

 **CAUTION!** If at any time you need to immediately stop the blade engine, press the emergency stop button located on the operator's handle.

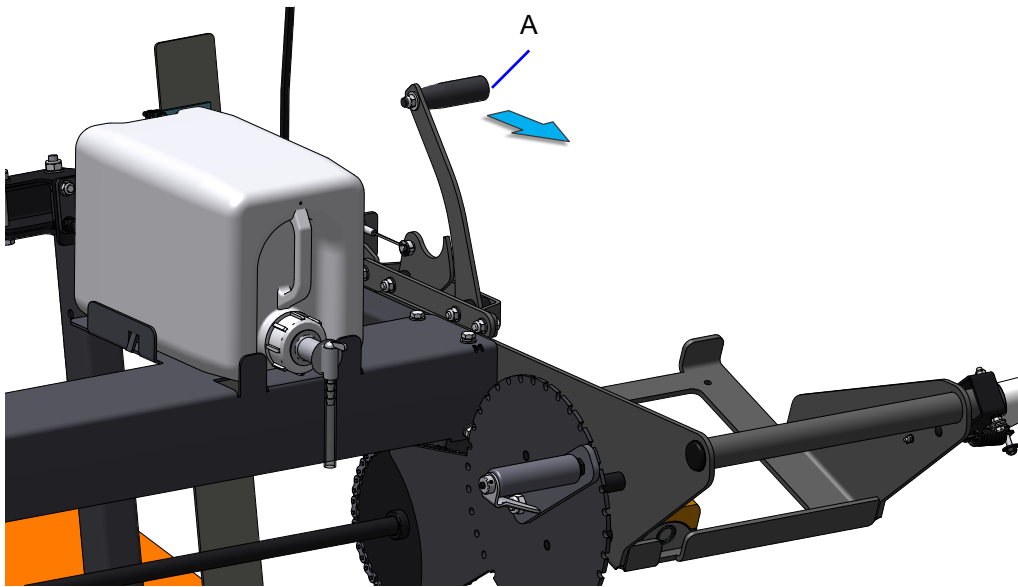
3. Open the fuel supply valve and turn on the ignition by moving the ignition/fuel lever to the "ON" position.
4. **Cold engine:** Close the engine choke by moving the choke lever to the "ON" position. Disengage the tensioner handle (by moving it away from you).
5. **Warm engine:** Disengage the tensioner handle (by moving it away from you). A warm engine usually does not require choke on.

## 3 Sawmill Operation

### Gas Engine Operation (G9)

6. Pull the engine starter cord slowly until you feel resistance, then pull the cord quickly to start the engine.
7. **Cold engine:** When the engine starts, slowly open the choke all the way by moving the choke lever to the "OFF" position.
8. Press and hold the safety handle (CE sawmills only).
9. Engage the tensioner handle (A) by pushing it toward you as shown below.

See figure 3-24.



**RYS. 3-24.**

**NOTE:** Let the engine idle for about 1-3 minutes (depending on ambient temperature) to warm up before starting the sawing operation.

### Engine Shutoff

1. Disengage the tensioner handle (by moving it away from you) to stop the blade.
2. The engine should run with no load for 15 seconds. Stop the engine by moving the ignition/fuel lever to the "OFF" position.



**CAUTION!** When stopping the engine, reduce the load slowly. Do not stop the engine suddenly as it may cause the temperature to raise abnormally.

### 3.23 Feed Operation

The feed operation is performed by pushing the saw head manually. The speed at which the saw head travels should be as steady as possible. Be sure the saw head will not hit any bed components while it is being moved forward or backward.

**HINT:** To get a straight cut in the first part of the log, 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 blade and drive belt wear, and also produces a wavy cut.



**CAUTION!** Be sure to stop the blade when returning the saw head. 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.

### 3.24 Cutting the Log

The following steps guide you through normal operation of the LX50 Start 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. Set the blade to the desired height. Make sure that the blade will clear the clamps and side supports.
3. Make sure all covers and guards are in place and secured. Start the motor/engine.
4. Feed the blade into the log slowly. 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!
5. As you get to the end of the log, slow down the feed rate. When the teeth exit the end of the log: release the safety handle to stop the blade (electric sawmill version), or disengage the tensioner handle and set the throttle lever in SLOW position (gas sawmill version). Remove the slab that you have just cut from the log.
6. Return the saw head to the front of the sawmill Always disengage the blade before returning the saw head for the next cut.
7. 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.
8. If the leveling wedge was used, remove it from the sawmill bed. Release the clamps and turn the log 90 or 180 degrees. Make sure the flat side of the log is placed against the side supports if the log was turned 90 degrees. If the log was turned 180 degrees, its flat side should rest on the bed rails. If the log was turned 90 degrees and it is necessary to level it on the bed, follow the leveling instructions below.

- Repeat the steps used to cut the first side of the log until the log is square. Then cut boards from the cant.

**Example:** Remember that the blade cuts a 2 mm (0.08") wide kerf. If you want to get 25 mm (1") thick boards, lower the carriage 27 mm (1 1/16") for each board.

### 3.25 Edging

The following steps guide you through edging boards on the LX50 sawmill.

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

### 3.26 Blade Height Scale

See figure 3-25. The blade height scale is mounted on the vertical mast. It includes:

- a blade height indicator (A),
- a centimeter and inch scale(B).

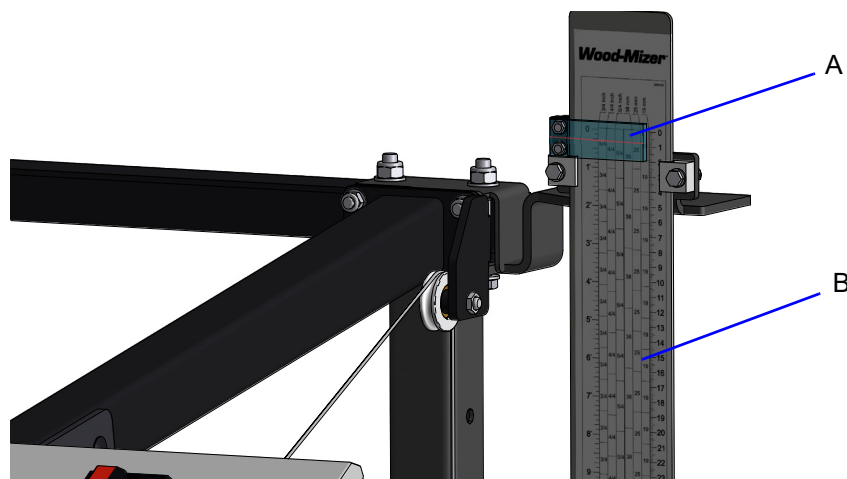


FIG. 3-25.

### Blade Height Indicator

Readings should be taken with eyes level with the indicator. This will allow to avoid the parallax error (different scale readings depending on the angle of vision).

### Scale

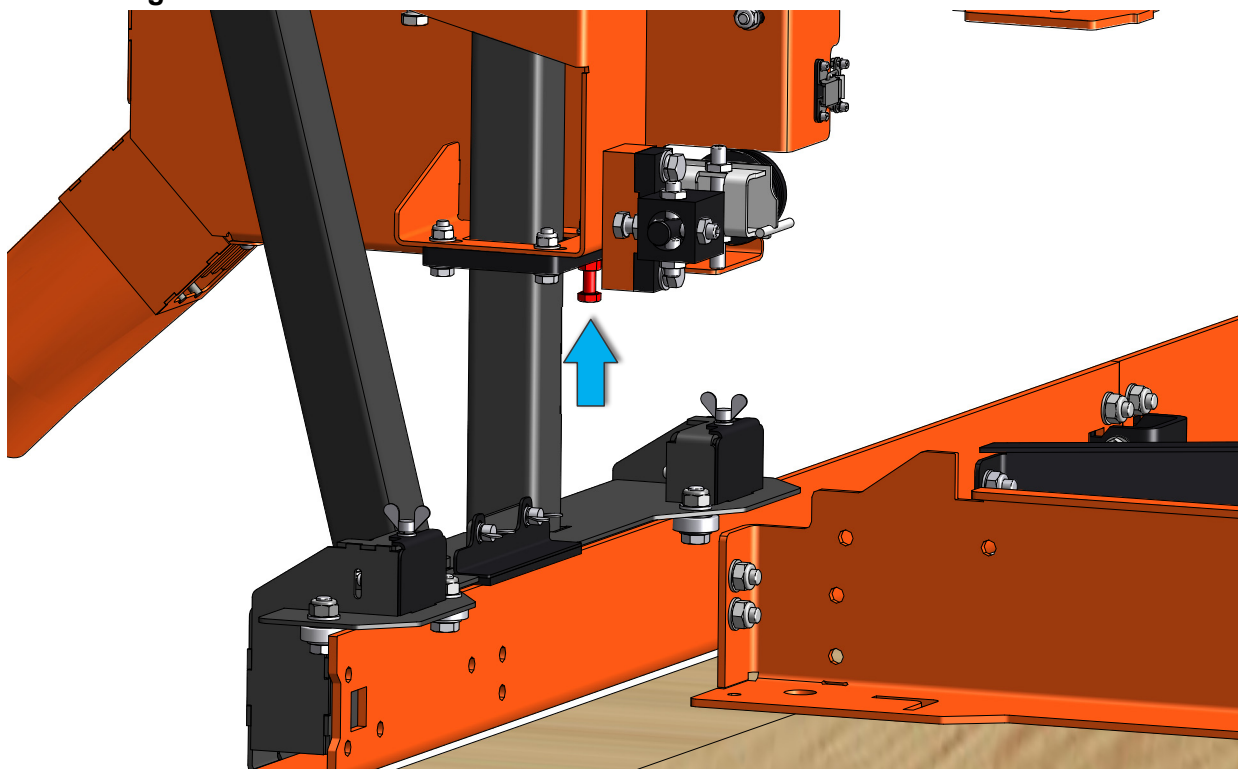
The blade height indicator shows how many centimeters the bottom of the blade is above the bed of the sawmill. If you know the height of your blade at each cut, you can determine the thickness of lumber you are sawing.

**Example:** You want to cut 1" (25 mm) random width boards from a log. Position the blade for the first cut. Move the saw head to an even measurement on the scale. Make a trim cut. Return the saw head for the second cut and lower it 27 mm below the original measurement. (The extra 2 mm allows for saw kerf and shrinkage of the lumber.)

## 3.27 Stop Bolt Adjustment

Adjust the saw head stop bolts so that the distance between the top of the bed rail and a down-set tooth of the blade is 25 mm.

See figure 3-26.



RYS. 3-26.

### 3.28 Water Lube System


The Water Lube System keeps the blade clean during sawing. 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 3-27. Open the valve on the water bottle to start water flow to the blade.



FIG. 3-27.

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. A squirt of liquid dishwashing detergent in the water bottle will help clean the blade when cutting wood with a high sap content.

 **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.

Before removing the blade, engage the clutch/brake lever (sawmills with the gasoline engine only). 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.

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.

### 3.29 Transporting the Sawmill

The assembled sawmill can be transported in an appropriately equipped pickup truck.

1. Move the saw head to one of the segments equipped with the stop block and secure it in place with the locking pin.
2. Divide the bed frame into the segments.
3. Slide the bed frame segments into the truck.
4. Use a forklift to load the saw head with the mast and bed segment into the truck and secure it with transport straps.



**WARNING!** Keep all persons out of the path of the saw head while loading and unloading the sawmill. Failure to do so may result in serious injury or death.

### 3.30 Troubleshooting



**DANGER!** Before performing any service to this machine, turn off the motor/engine and remove the key. Moving sawmill parts can cause serious injury or death.

PROBLEM	CAUSE	SOLUTION
<b>Blades dull quickly</b>	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 the blade.
	Poor sharpening techniques	Make sure the tips of teeth are sharpened properly.
<b>Blades break prematurely</b>	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edges of wheels.	Replace the blade wheel belts.
	Blade tension too tight	Tension blade to recommended specifications ( <a href="#">See "Tensioning the Blade."</a> )
<b>Blade does not track right on wheels</b>	Blade wheel improperly adjusted	Readjust ( <a href="#">See "Tracking the Blade."</a> )
	Flat/worn blade wheel belts	Replace the belts.
<b>Drive Belts Wear Prematurely or Jump</b>	Engine/motor and drive pulleys out of alignment	Align the pulleys.
<b>Boards thick or thin on ends or in the middle of board</b>	Stress in log which causes log to not lay flat on 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.
	Incorrect tooth set	Resharpen and reset blade.
	Bed rails misaligned	Realign the bed.



<b>Height adjustment jumps or stutters when moving up or down</b>	Lift cable improperly adjusted	Adjust the lift cable.
	Vertical wear pads are too tight.	Adjust pads.
	Lift cable too loose	Replace/adjust lift cable.
<b>Lumber is not square</b>	Vertical side supports not square to bed	Adjust side supports.
	Blade not parallel to bed rails	Adjust bed rails.
	Sawdust or bark between log/cant and bed	Remove particles.
	Tooth set problem	Resharpen and reset blade.
<b>Sawdust builds up on track</b>	Excessive lubrication	Apply white lithium grease.
	Worn wipers	Adjust wipers to firmer contact track or replace them.
	Track is sticky	Clean track and apply silicone spray.
<b>Wavy cuts</b>	Excessive feed	Reduce feed speed.
	Improperly sharpened blade (This will be the problem 99% of the time!)	Resharpen blade.
	Blade guides improperly adjusted	Adjust blade guides.
	Sap buildup on blade.	Use Water Lube.
	Tooth set problem	Resharpen and reset blade.

## SECTION 4 MAINTENANCE



**WARNING!** Before removing any cover or guard, always turn off the motor/engine and wait until all parts have stopped moving. Failure to do so may result in serious injury or death

### 4.1 Maintenance Performed as Needed

#### *Mast Track, Rollers and Wipers*

Properly maintaining the mast track surfaces and the track rollers 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 forward/backward movement of the saw head.

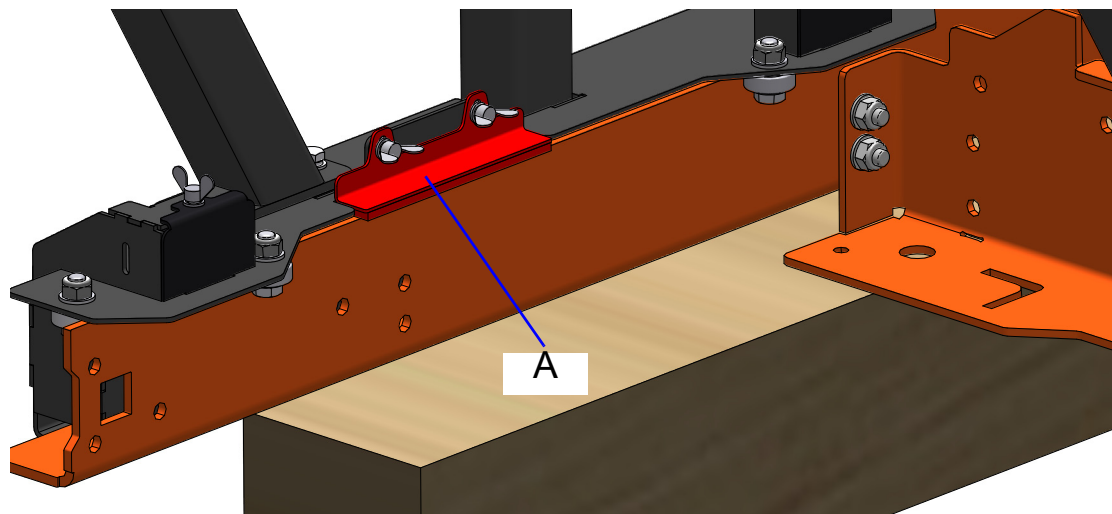


**CAUTION!** Keep mast track surfaces free of rust. Formation of rust on the mast track surfaces can cause rapid deterioration of these surfaces.

Apply white lithium grease to the mast track surfaces. Oil lubrication will help protect these surfaces from corrosive elements such as acid rain and moisture. This lubrication is also essential for proper functioning and durability of the forward/backward feed system.

Make sure the track wipers (A) touch the track surfaces and are free of sawdust buildup. [See figure 4-1.](#)

See figure 4-1.



**FIG. 4-1**

After each use of the sawmill, remove sawdust from the track surfaces, bed rails and track rollers. Use a light-grade sandpaper or emery cloth to sand off any rust and other adhering particles from the mast track surfaces (B). [See figure 4-2.](#)

See figure 4-2.

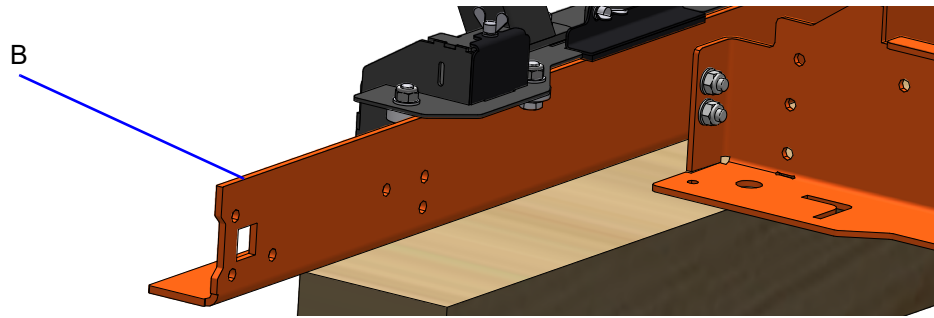


FIG. 4-2

## 4.2 General Maintenance

### ***Every 8 Hours of Sawmill Operation***

- Check the engine oil level. (See the Engine Manual.)
- Clean the track rollers, mast carriages and track wipers.
- After you have finished using the sawmill, lower the saw head all the way down so that the saw head rests on the stop bolts and the lift cables remain not tensioned.
- Inspect blade wheel belts for wear or damage. Replace if damaged.
- Inspect the sawmill parts for damage.
- Open the blade housing cover and brush any sawdust buildup from the housing, cover and V-belts.

### ***Weekly (every 160 hours of sawmill operation)***

- Clean and lubricate blade tensioner screw.

See figure 4-3.

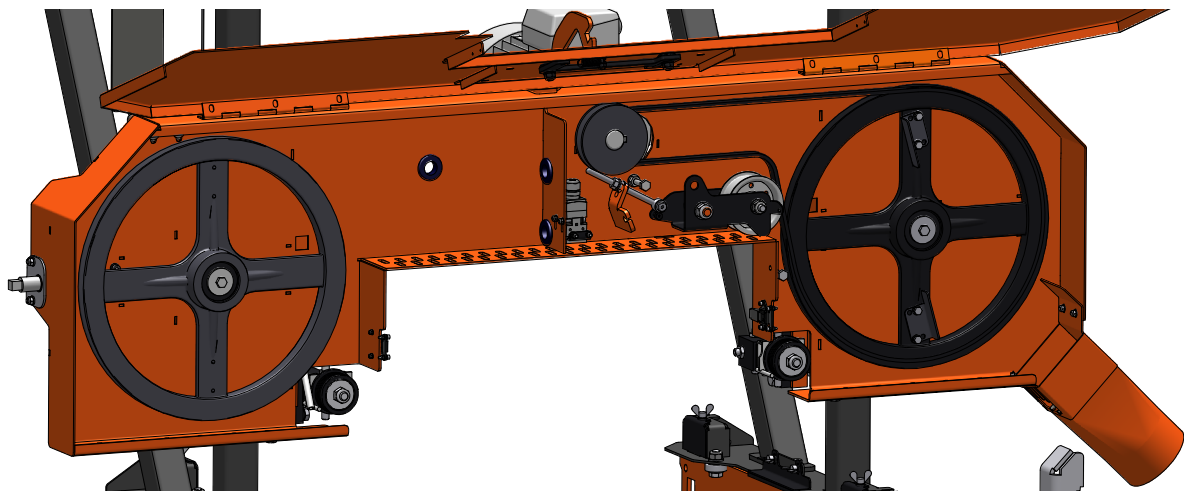


FIG. 4-3

### Monthly (every 160 hours of sawmill operation)

- Apply white lithium grease to the lift cables on both sides of the saw head.



**CAUTION!** Check if the lift cables are in good condition. If either lift cable is damaged, immediately replace it with a new one.

See figure 4-4.

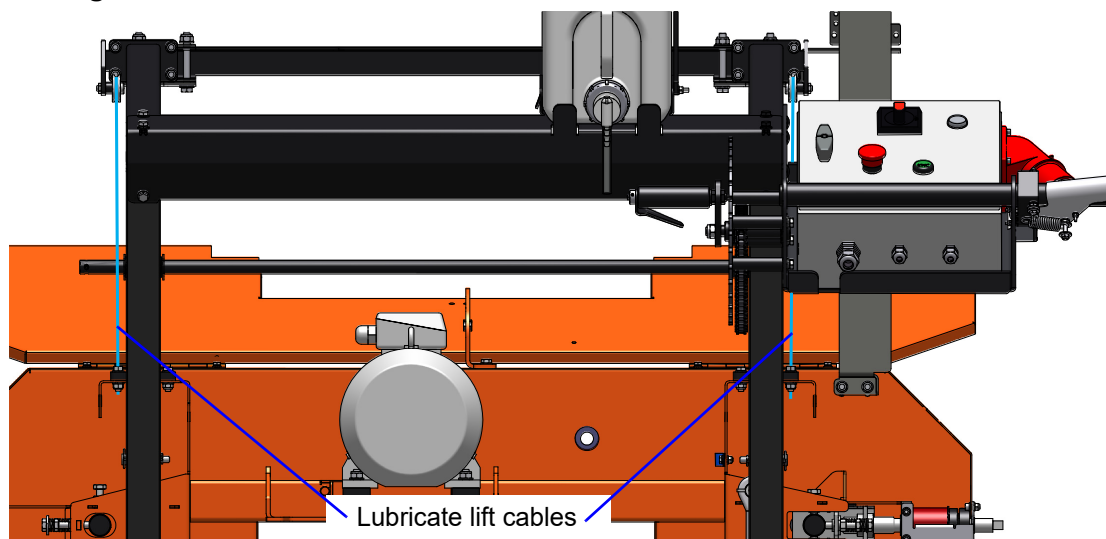


FIG. 4-4

## 4.3 Motor/Engine Maintenance

Refer to the motor/engine manufacturer's manual for maintenance intervals and procedures regarding the motor/engine.

## WOOD-MIZER LX50 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REF- ERENCE	TOTAL HOURS OF OPERATION									
		<i>FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.</i>									
		50 HRS	100 HRS	150 HRS	200 HRS	250 HRS	300 HRS	350 HRS	400 HRS	450 HRS	500 HRS
Clean & lubricate mast	Viz Část 4.1										
Check blade wheel belts for wear.	Viz Část 4.2										
Lubricate blade tensioner screw.	Viz Část 4.2										

## WOOD-MIZER LX50 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REF- ERENCE	TOTAL HOURS OF OPERATION									
		<i>FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.</i>									
		550 HRS	600 HRS	650 HRS	700 HRS	750 HRS	800 HRS	850 HRS	900 HRS	950 HRS	1000 HRS
Clean & lubricate mast	Viz Část 4.1										
Check blade wheel belts for wear.	Viz Část 4.2										
Lubricate blade tensioner screw.	Viz Část 4.2										

## WOOD-MIZER LX50 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REF- ERENCE	TOTAL HOURS OF OPERATION									
		<i>FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.</i>									
		1050 HRS	1100 HRS	1150 HRS	1200 HRS	1250 HRS	1300 HRS	1350 HRS	1400 HRS	1450 HRS	1500 HRS
Clean & lubricate mast	Viz Část 4.1										
Check blade wheel belts for wear.	Viz Část 4.2										
Lubricate blade tensioner screw.	Viz Část 4.2										

## WOOD-MIZER LX50 MAINTENANCE LOG

(Check Engine And Option Manuals For Additional Maintenance Procedures)

PROCEDURE	MANUAL REF- ERENCE	TOTAL HOURS OF OPERATION									
		<i>FILL IN THE DATE AND THE MACHINE HOURS AS YOU PERFORM EACH PROCEDURE. A SHADED BOX INDICATES MAINTENANCE IS NOT NEEDED AT THIS TIME.</i>									
		1550 HRS	1600 HRS	1650 HRS	1700 HRS	1750 HRS	1800 HRS	1850 HRS	1900 HRS	1950 HRS	2000 HRS
Clean & lubricate mast	Viz Část 4.1										
Check blade wheel belts for wear.	Viz Část 4.2										
Lubricate blade tensioner screw.	Viz Část 4.2										



**EC declaration of conformity  
according to EC Machinery Directive 2006/42/EC, Annex II, 1.A**

Manufacturer:

Wood-Mizer Industries Sp. z o. o.  
114 Nagórna; 62-600 Koło, Poland  
Tel. +48 63 26 26 000

This declaration of conformity is issued under the sole responsibility of the manufacturer.

Following machine in our delivered version complies with the appropriate essential safety and health requirements of the EC Machinery Directive 2006/42/EC based on its design and type, as brought into circulation by us. In case of alteration of the machine, not agreed by us, this declaration is no longer valid.

**We, the undersigned herewith declare, that:**Designation of the machine: Sawmill  
Model: LX50SA, LX50SC  
Type: .....  
Serial Number: .....**Is in conformity with the following  
EC directives:**EC Machinery Directive 2006/42/CE  
EC Electromagnetic Compability Directive  
2014/30/CE**And is in conformity with the following  
Harmonized Standards:**PN-EN 1807-2:2013-08  
PN-EN ISO 13849-1:2016-02  
PN-EN 60204-1:2018-12

Notified Body according to annex IV:

Sieć Badawcza Łukasiewicz –  
Krakowski Instytut Technologiczny  
ul. Zakopiańska 73  
30-418 Kraków

Notification No:

1455

EC type - examination certificate no:

1455-MD-065/22

Responsible for Technical Documentation:

Piotr Adamiec / Engineering Manager  
Wood-Mizer Industries Sp. z o.o.  
62-600 Koło, 114 Nagórna Street, Poland  
Tel. +48 63 26 26 000

Place / Date / Authorized Signature:

Koło, 31.08.2022



Title:

Engineering Manager



**EC declaration of conformity  
according to EC Machinery Directive 2006/42/EC, Annex II, 1.A**

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EC Electromagnetic Compability Directive  
2014/30/CE

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Place / Date / Authorized Signature:

Koło, 31.08.2022



Title:

Engineering Manager