

**Safety, Operation, Maintenance, &
Parts Manual**

Transfer Deck TD2

rev.A1.07

Safety is our #1 concern!

Form #1191

Models Effected:

TD2

TD2-Orange



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

California
Proposition 65 Warning



WARNING: Breathing gas/diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an enclosed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to **www.P65warnings.ca.gov**.



WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection.

For more information go to **www.P65Warnings.ca.gov/wood**.

Active Patents assigned to Wood-Mizer, LLC

Wood-Mizer, LLC has received patents that protect our inventions which are a result of a dedication to research, innovation, development, and design. Learn more at: woodmizer.com/patents

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Table of Contents	Section-Page
SECTION 1 SAFETY	1-1
1.1 Safety Symbols.....	1-1
1.2 Safety Instructions.....	1-1
SECTION 2 GENERAL INFORMATION	2-1
2.1 Transfer Deck Components.....	2-1
2.2 Overall Dimensions.....	2-2
SECTION 3 INSTALLATION & SETUP	3-3
3.1 Air Installation.....	3-3
3.2 Setup.....	3-4
3.3 Electrical Installation.....	3-5
3.4 Sensor Switches Setting.....	3-6
3.5 Board Stop Adjustment.....	3-6
SECTION 4 OPERATION	4-1
4.1 Control Box Operation.....	4-1
SECTION 5 REPLACEMENT PARTS	5-1
5.1 Table Assembly.....	5-1
5.2 Board Stop.....	5-3
5.3 Airbag and Frame.....	5-4
5.4 Air Filter and Regulator.....	5-6
5.5 TD Brace.....	5-7
5.6 Kicker & Air Cylinder.....	5-8
5.7 Kicker Valve/Solenoid.....	5-9
5.8 Control Box.....	5-10
5.9 Photo Sensors.....	5-11
SECTION 6 ELECTRICAL INFORMATION	6-1
6.1 Electrical Diagrams.....	6-1
6.2 Electrical Component List.....	6-1


SECTION 1 SAFETY

1.1 Safety Symbols

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

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

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

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

NOTICE indicates vital information.

1.2 Safety Instructions

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



WARNING! Clean sawdust from all guards, vents, control boxes, or any area where sawdust may gather after every shift. Failure to do so may result in fire, causing death or serious injury.



OBSERVE SAFETY INSTRUCTIONS



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

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

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

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



KEEP TRANSFER DECK AND AREA AROUND TRANSFER DECK CLEAN



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

CAUTIONS FOR TRANSFER DECK SETUP

WARNING! Securely fasten the feet of the transfer deck to the floor before operating the machine.

CHECK TRANSFER DECK BEFORE OPERATION



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

KEEP PERSONS AWAY



WARNING! Keep all persons out of the path of moving equipment and boards while operating transfer deck.



USE PROPER PROCEDURE WHEN CONDUCTING MAINTENANCE

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

DANGER! Hazardous voltage inside the control box and at the motor can cause shock, burns, or death. Disconnect and lock out power supply before servicing! Keep all electrical component covers closed and securely fastened during operation.



WARNING! Consider all electrical circuits energized and dangerous.

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

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

SECTION 2 GENERAL INFORMATION

2.1 Transfer Deck Components

The Transfer Deck (TD2) enables you to change the direction of material flow. The transfer deck is also equipped with the kicker system allowing you to separate boards and cants. The following instructions will guide you in installation, operation, and alignment of the Transfer Deck.



WARNING! Keep all persons out of the path of moving equipment and boards while operating transfer deck.

The main components of the Transfer Deck are shown below.

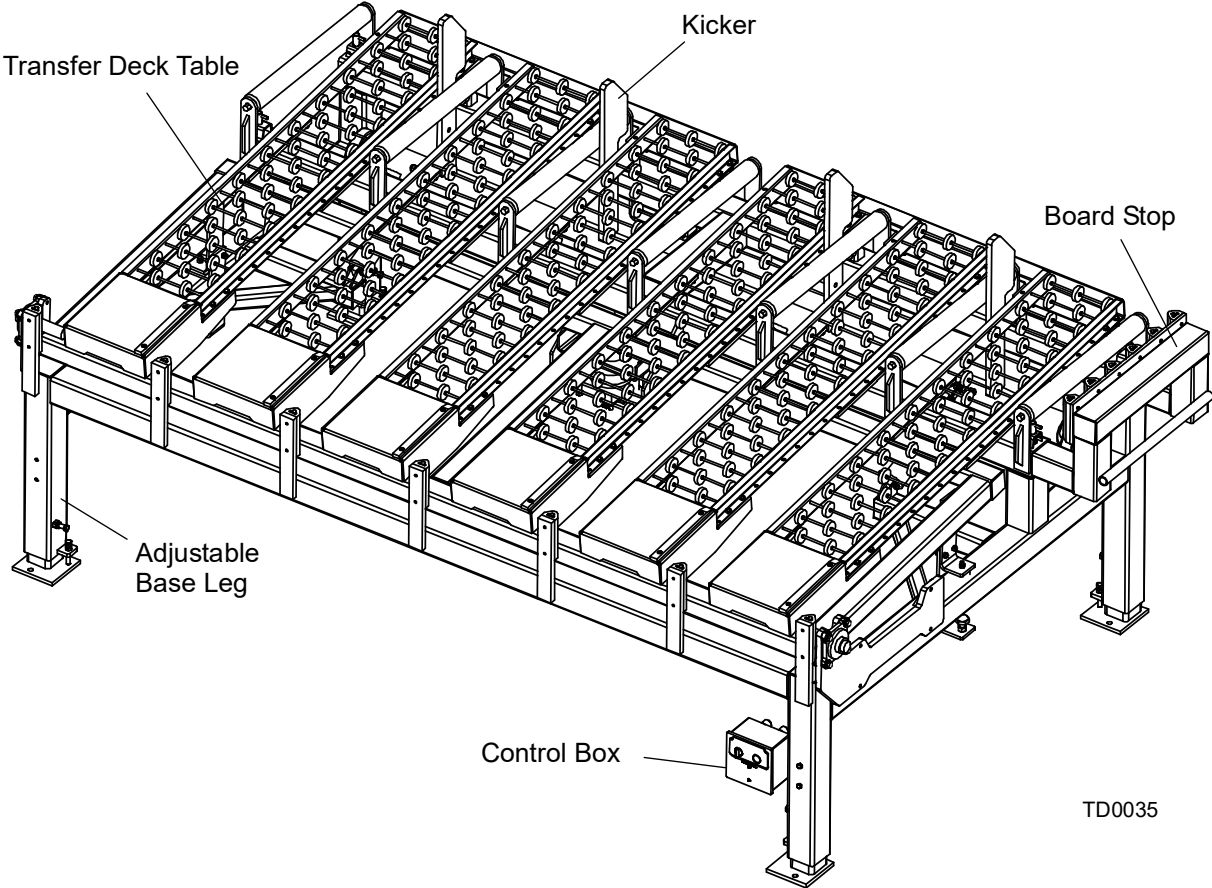


FIG. 2-1 TRANSFER DECK (TD2)

2.2 Overall Dimensions

The overall dimensions of the Transfer Deck (TD2) are shown below.

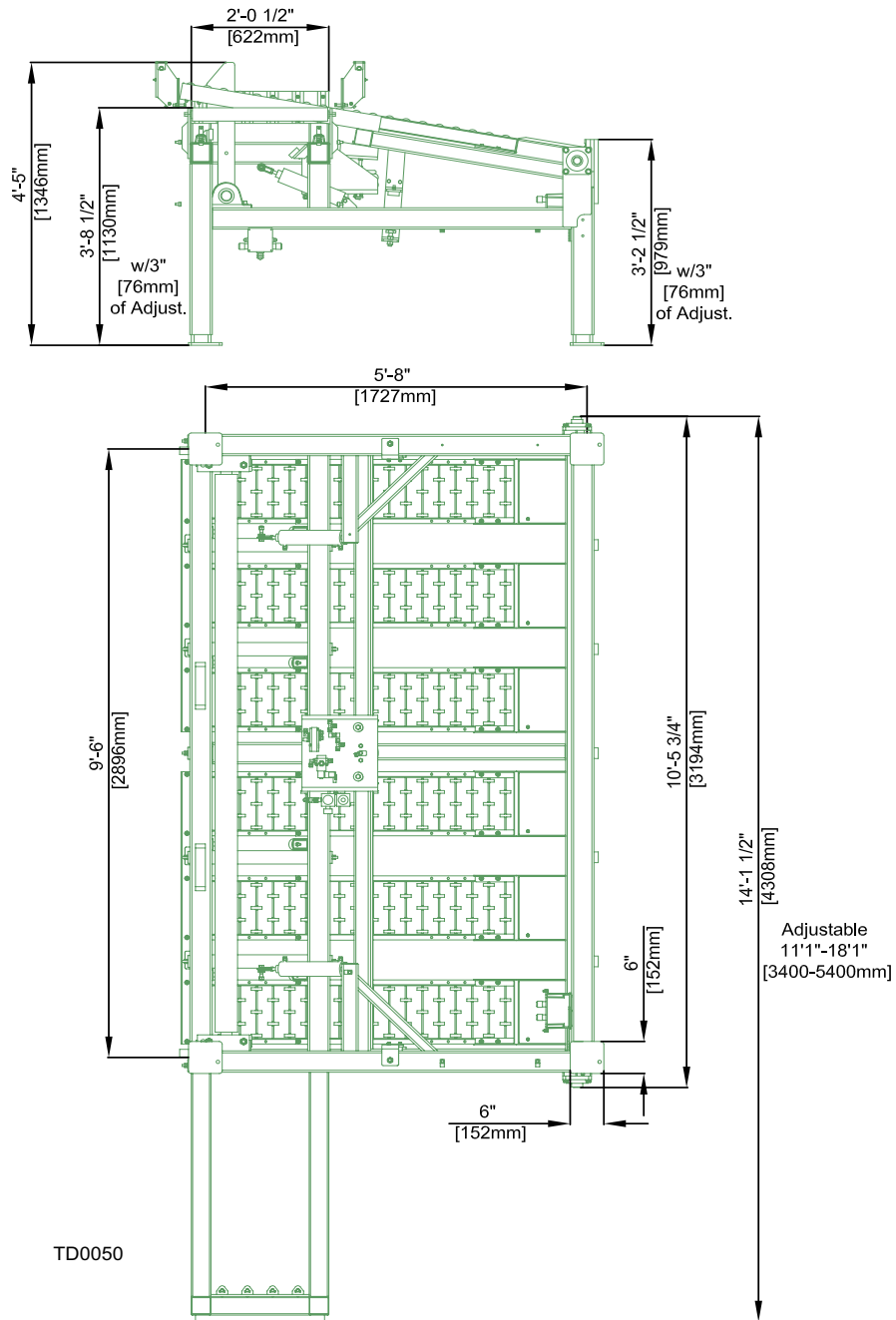


FIG. 2-2 TRANSFER DECK (TD2)

SECTION 3 INSTALLATION & SETUP

3.1 Air Installation

The transfer deck air system diagram is shown below.

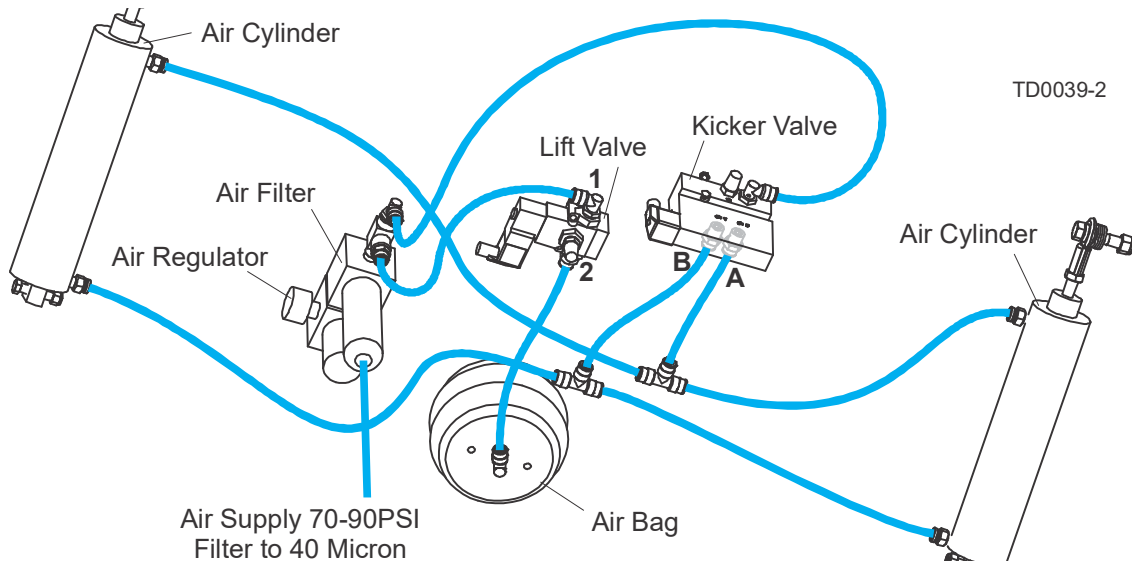


FIG. 3-1


NOTE: Wood-Mizer highly recommends using the Transfer Deck together with the Wood-Mizer Incline Conveyor. After connecting the transfer deck table to the air supply, the transfer deck table automatically lowers when the board or cant gets between the electronic sensors on the incline conveyor belt. The transfer deck table automatically raises when the board or cant leaves the incline conveyor and there is no object on the incline conveyor belt between the electronic sensors.

To operate the transfer deck with the incline conveyor, connect the air supply to the transfer deck air supply line.

NOTE: Make sure each hose fits tight on the fitting before operating the unit.

3.2 Setup

Prepare a firm, level area where the transfer deck can be anchored before operating the unit. A cement pad with 1/2" diameter anchor bolts is recommended.

 **WARNING!** Securely fasten the feet of the transfer deck to the floor before operating the unit.

NOTE: If you use the Wood-Mizer Incline Conveyor, the distance between the transfer deck and conveyor should be approximately 25" (635 mm).

The top of the conveyor drive roller should be approximately 2" (50mm) higher than the top of the transfer deck rollers.

Make sure that lumber can easily get to the transfer deck table.

Adjust the legs so each leg is in contact with the ground.

Loosen the locking bolt.

Turn the adjustment bolt clockwise to raise, turn counterclockwise to lower the transfer deck frame.

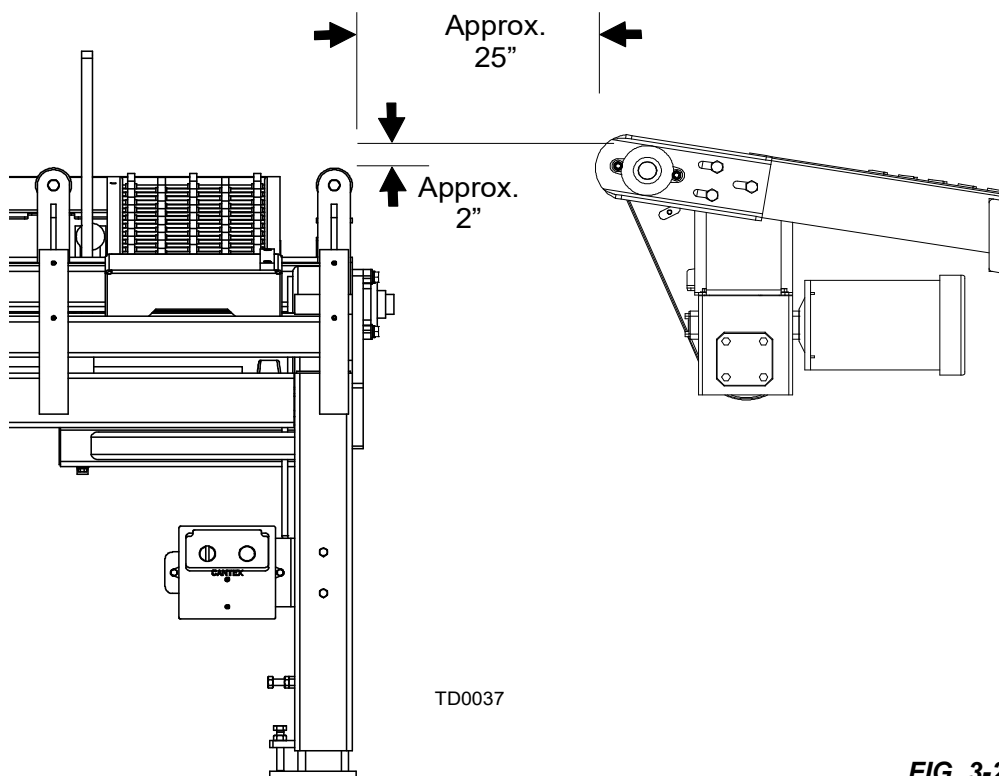


FIG. 3-2

Secure the leg with the locking bolt.

Tighten the jam nuts when the adjustment is complete.

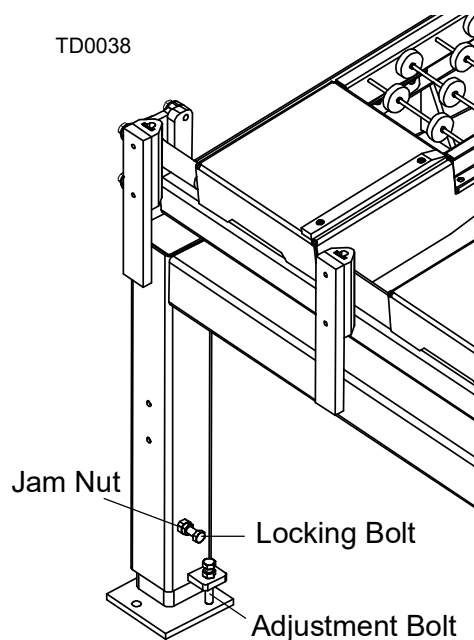


FIG. 3-3

3.3 Electrical Installation

This section explains how to connect the Transfer Deck and the Incline Conveyor to work together.



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.

To connect the transfer deck to the incline conveyor:

1. Route the air lift and kicker valve cables along the transfer frame.
2. Use the provided clamps to secure the cable in place.
3. Connect the cables to the air lift and kicker valves located under the transfer deck air bag. Mount the provided sensor power junction box to the cross tube on the Incline Conveyor with the two provided bolts.

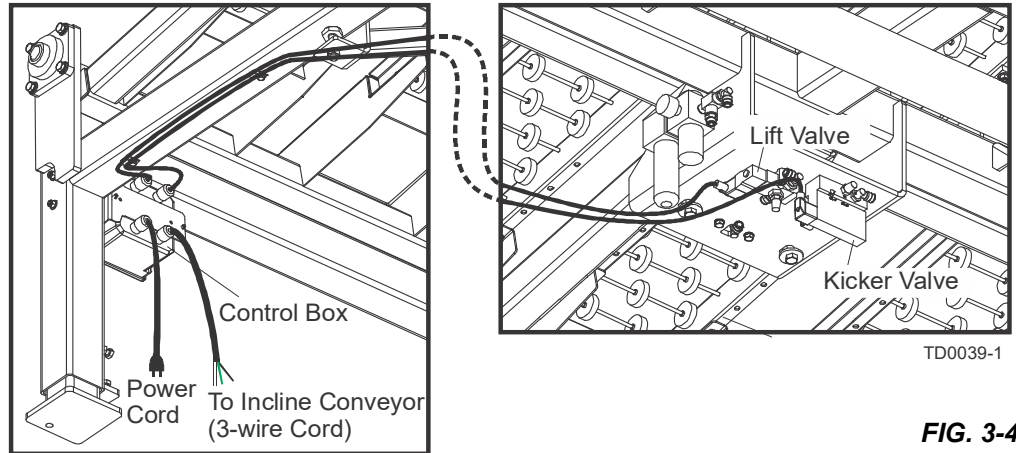


FIG. 3-4

4. Route the transfer deck cable to the sensor power junction box.
5. Route the cable through the cable connector in the bottom of the box.
6. Secure the cable to the frame and ground to make sure the operator has a clear path for all necessary movement around the machines.
NOTE: Connect the white wires from the transfer deck control box to the white wire terminal inside the power junction box; connect the green wires to the green wire terminal; then connect the black wire to the black wire terminal inside the power junction box installed on the incline conveyor.

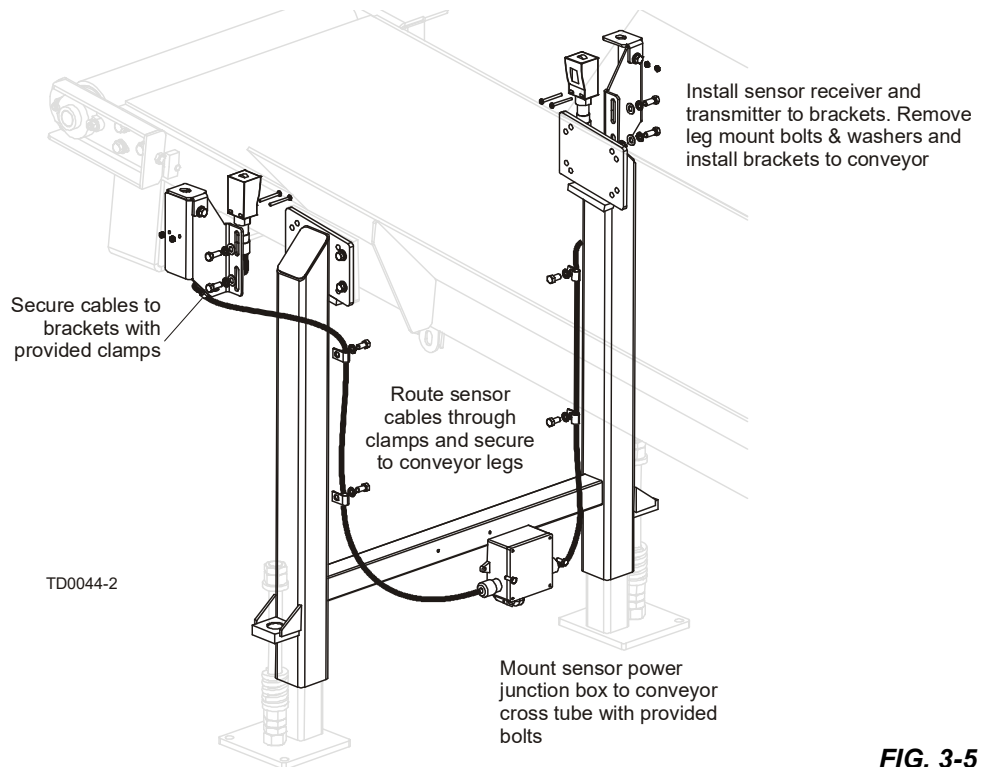


FIG. 3-5

7. Install the photoelectric sensors to the mounting brackets with the screws and nuts provided.
8. Secure the cables to the brackets with the clamps provided on the brackets.
9. Remove two of the conveyor leg mounting bolts on each side, install the sensors and replace the bolts and washers.

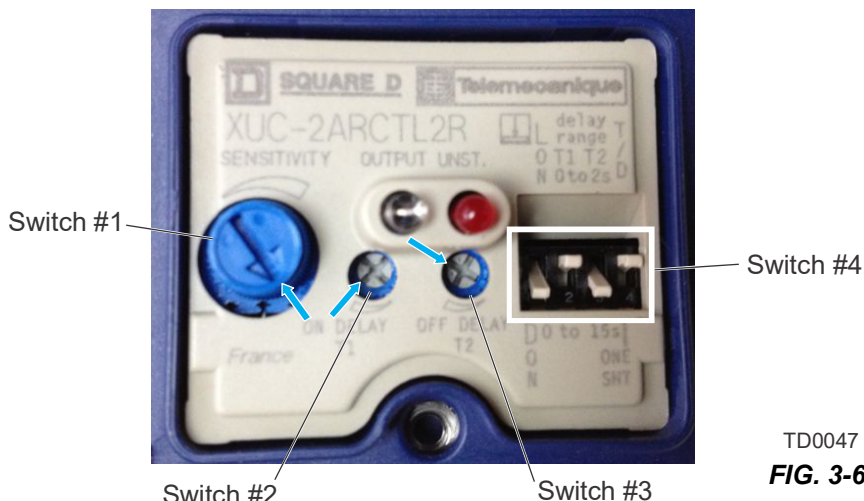
NOTE: A longer bolt is provided for use on older conveyors that use a thru-hole at the bottom leg mounting bolt location. Level the sensors to face each other and tighten the bolts to secure the sensor brackets. Use the provided clamps, lock washers and bolts to secure the sensor cables to the conveyor legs, drilling and tapping 3/8-16 holes as needed.

10. Plug the power cord from the transfer deck control box into a grounded 110V electrical receptacle.

3.4 Sensor Switches Setting

The settings for the sensor switches are provided below (reference the two dots on switches #2 and #3 for location):

- Switch #1 - full CW position as shown by an arrow (usually set at factory),
- Switch #2 - full CCW position as shown by an arrow (usually set at factory),
- Switch #3 - approximately 10-o'clock position as shown by an arrow below,
- Switch #4 - set the dip switches as shown below.



TD0047
FIG. 3-6

3.5 Board Stop Adjustment

The Board Stop Assembly can be mounted to either of the Transfer Deck sides. Install the board stop on the side opposite to the direction from which the lumber is flowing. The boards will stop as soon as they hit the board stop assembly.



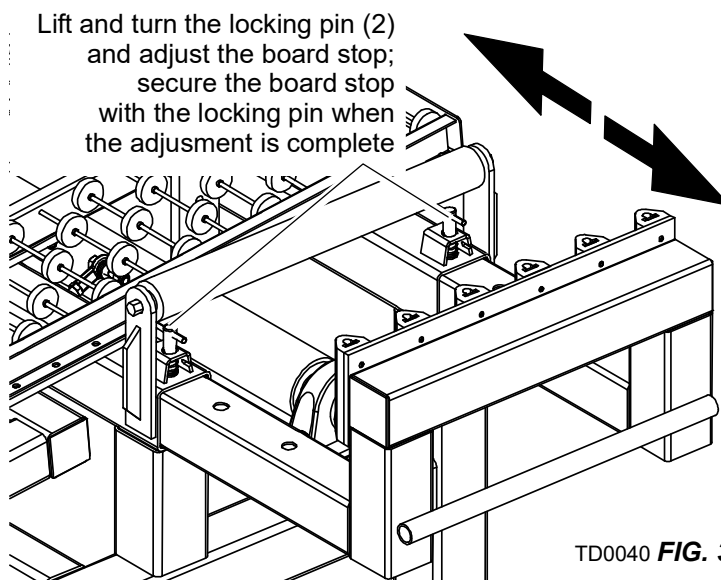
WARNING! Keep all persons out of the moving equipment and boards while operating transfer deck.

Adjust the accessory roller width to suit your application. To adjust the board stop:

1. Lift and turn the two pins securing the board stop in its closest-to-table position.

Move the board stop assembly so that it is long enough to make the lumber fit the transfer deck table. The maximum board dimension to be used with the transfer deck can not exceed 16 ft. (4.88m).

2. Secure the board stop assembly with the two locking pins when the adjustment is complete.



TD0040 **FIG. 3-7**

SECTION 4 OPERATION

4.1 Control Box Operation

The transfer deck is provided with all the necessary air hoses connected. To operate the transfer deck, make the appropriate connections. [See Section 3.1 Air Installation](#), for transfer deck air system diagram.

The transfer deck is designed to work with the incline conveyor. This manual explains how to operate the unit working together with the incline conveyor.

1. Use the up/down table switch located on the control box to operate the transfer deck option.
2. Turn the up/down table switch to the "AUTO" position to make the table lower when the lumber comes from the incline conveyor.

The table raises automatically when the lumber gets on the table and leaves the conveyor. The lumber slides down when the table raises.

3. Turn the up/down table switch to the "DOWN" position to lower the transfer deck table.
4. Use the "DOWN" position to keep the table down when operating the kicker.
5. Move the up/down table switch to the "JOG" position to raise the transfer deck table.
6. Release the switch to return to the "AUTO" position.
7. Use the "JOG" position when the lumber coming from the incline conveyor gets stuck between the transfer deck and conveyor.

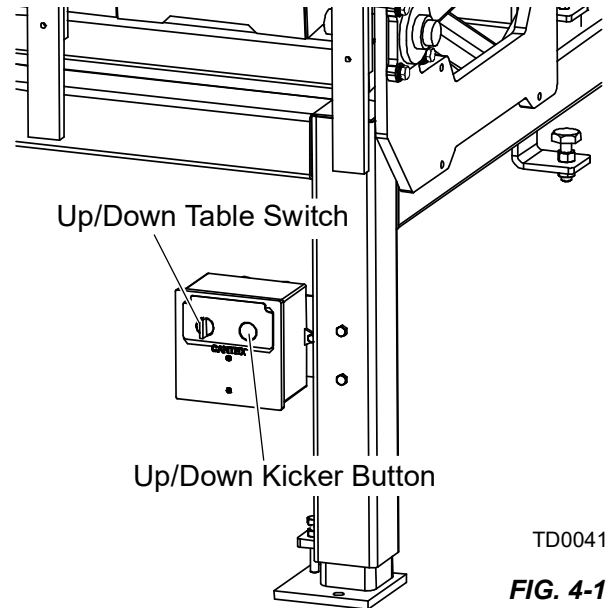
Operating the kicker

The transfer deck kicker is designed to help the operator separate different kind of lumber, e.g. cants and boards. Use the kicker whenever it is necessary to save your time and for convenience.

1. To separate cants from boards, turn the up/down table switch to the "DOWN" position to prevent the cants from sliding down the table.
2. Press the up/down kicker button to raise the kicker.

The kicker pulls the cant off the table. Release the up/down kicker button to lower the kicker.

NOTE: Have a cart or other collection system available next to the transfer deck to receive the cants as they are kicked off the table.

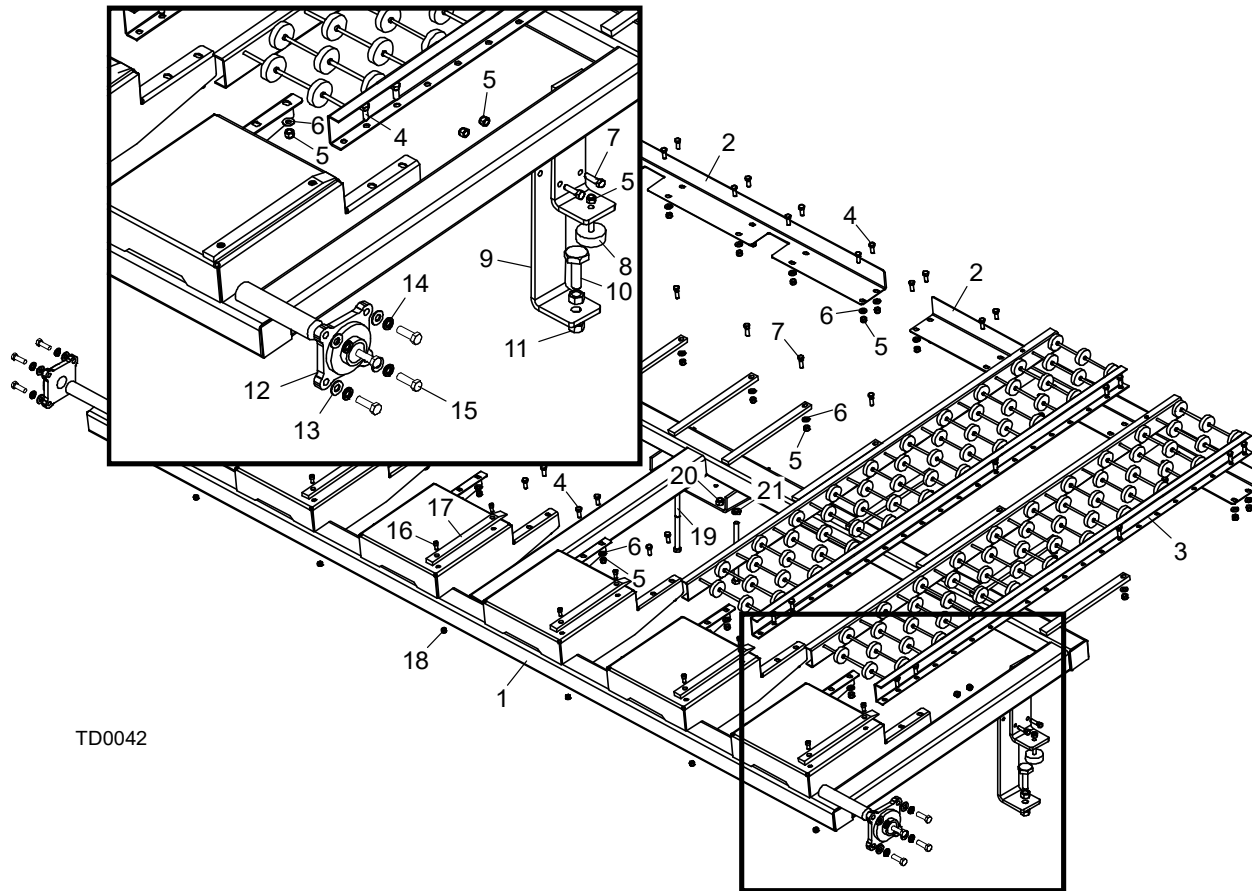


TD0041

FIG. 4-1

SECTION 5 REPLACEMENT PARTS

5.1 Table Assembly

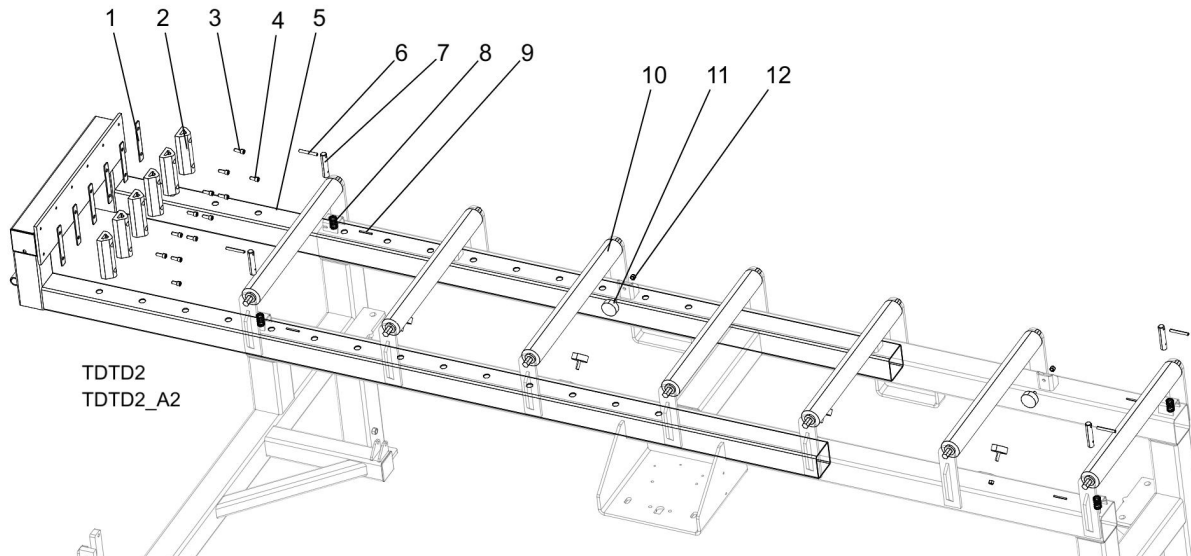


TD0042

REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	036380	FRAME WELDMENT, TD2 TABLE		1
2	036371	ANGLE, ROLLER SKATE		2
3	036418	CONVEYOR, ROLLER 5' MODIFIED		6
4	F05007-87	BOLT, 3/8-16 X 1" HEX HEAD GRADE 5		48
5	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		48
6	F05011-3	WASHER, 3/8 FLAT SAE		48
7	F05007-123	BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 5		16
8	034175	BUMPER, TABLE		2
9	034117	PLATE, LOWER TABLE STOP		2
10	S13006	BOLT, TABLE ADJUSTMENT		2
11	F05010-5	NUT, 5/8-11 HEX		4
12	034176	BEARING, 1 1/2" DIA. 4-BOLT FLANGE		2
13	F05011-2	WASHER, 1/2" SAE FLAT		8
14	F05011-9	WASHER, 1/2" SPLIT LOCK		8
15	F05008-33	BOLT, 1/2-13 X 1 1/2" HEX HEAD GRADE 5		8
16	F05006-63	SCREW, 5/16-18 X 3/4" SHC		12
17	036382	BAR, TD2 BOARD SLOW DOWN		6
18	F05010-58	NUT, 5/16-18 NYLON HEX		12

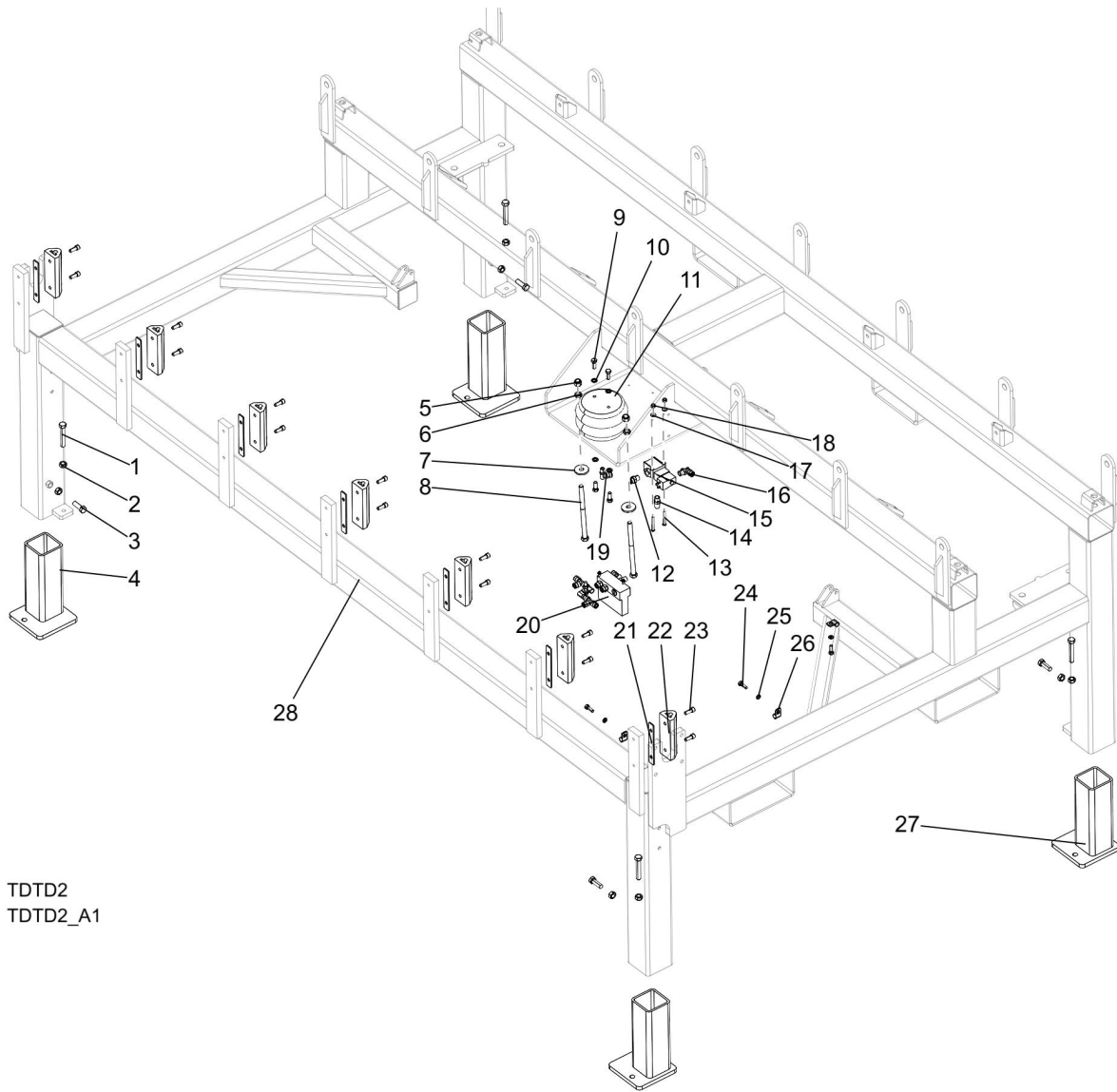
REF	PART #	DESCRIPTION	COMMENTS	QTY.
19	F05008-69	BOLT, 1/2-13 X 8" HEX HEAD GRADE 5		2
20	F05010-31	NUT, 1/2-13 HEX JAM		2
21	F05010-8	NUT, 1/2-13 HEX NYLON LOCK		2

5.2 Board Stop



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	034160	Stop Assy, Board		1
1	034158	Plate, Rubber Bolt		6
2	034153	Stop, Bottom Rubber		6
3	F05007-52	Bolt, 3/8-16x1 SH Cap BO		10
4	F05005-104	Bolt, 3/8-16x3/4 SHC BO		2
5	034147	Stop Wldmt, Board		1
	016148	Pin Assy, .75 Outrigger Pull		4
6	F05012-47	PIN, ROLL 5/16 X 2 1/2		1
7	016147	Pin, Outrigger Pull, .75		1
8	F05012-103	Pin, 3/16x1 3/4 Roll Zinc		4
9	016145	Spring, .92x1.5x.079 Compression		4
10	038167	Roller, 2 1/2x24-3/4 BF, Galvanized		7
11	034175	Bumper, Table		8
12	F05010-10	Nut, 3/8-16 Hex Nyl Lock		8

5.3 Airbag and Frame



TDTD2
TDTD2_A1

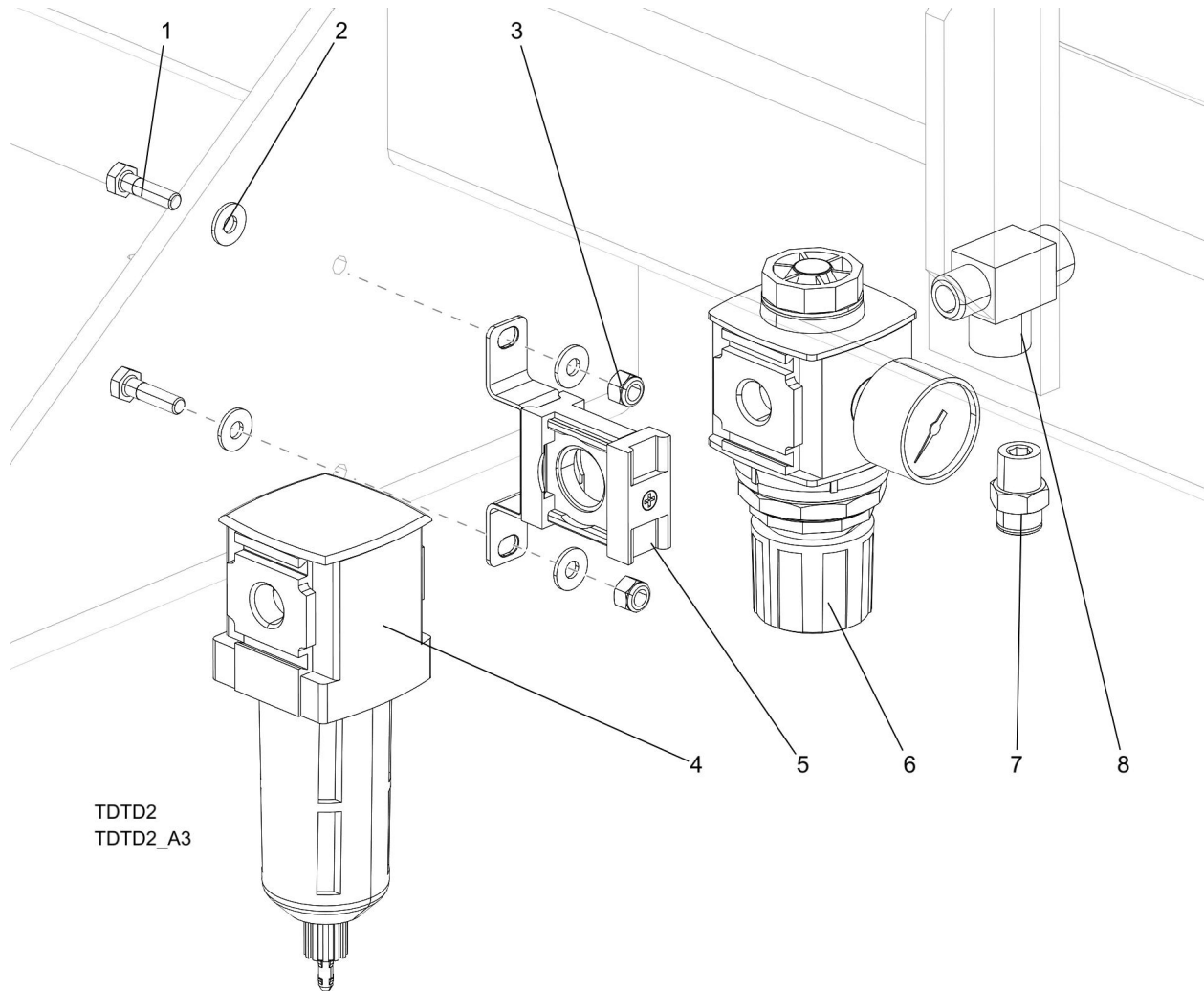
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05008-7	Bolt, 1/2-13x3 Hex Head Full Thread Zinc		4
2	F05010-35	NUT, 1/2-13 FREE HEX, ZINC		8
3	F05008-33	Bolt, 1/2-13x1 1/2 HH Gr5		4
4	W21342-1	Leg, Wldmt, MGR Adjust Base		2
5	F05010-8	Nut, 1/2-13 Nyl Hex Lock		2
6	F05010-31	Nut, 1/2-13 Zinc Jam		2
7	014632	Washer, .52x1.69		2
8	F05008-69	BOLT, 1/2-13X8 HEX HEAD GR5, ZN		2
9	F05007-87	Bolt, 3/8-16x1 Gr5 HH		4
10	F05011-4	Washer, 3/8 Split Lock		4
11	016980	Bag, Air		1

5 Replacement Parts

Airbag and Frame

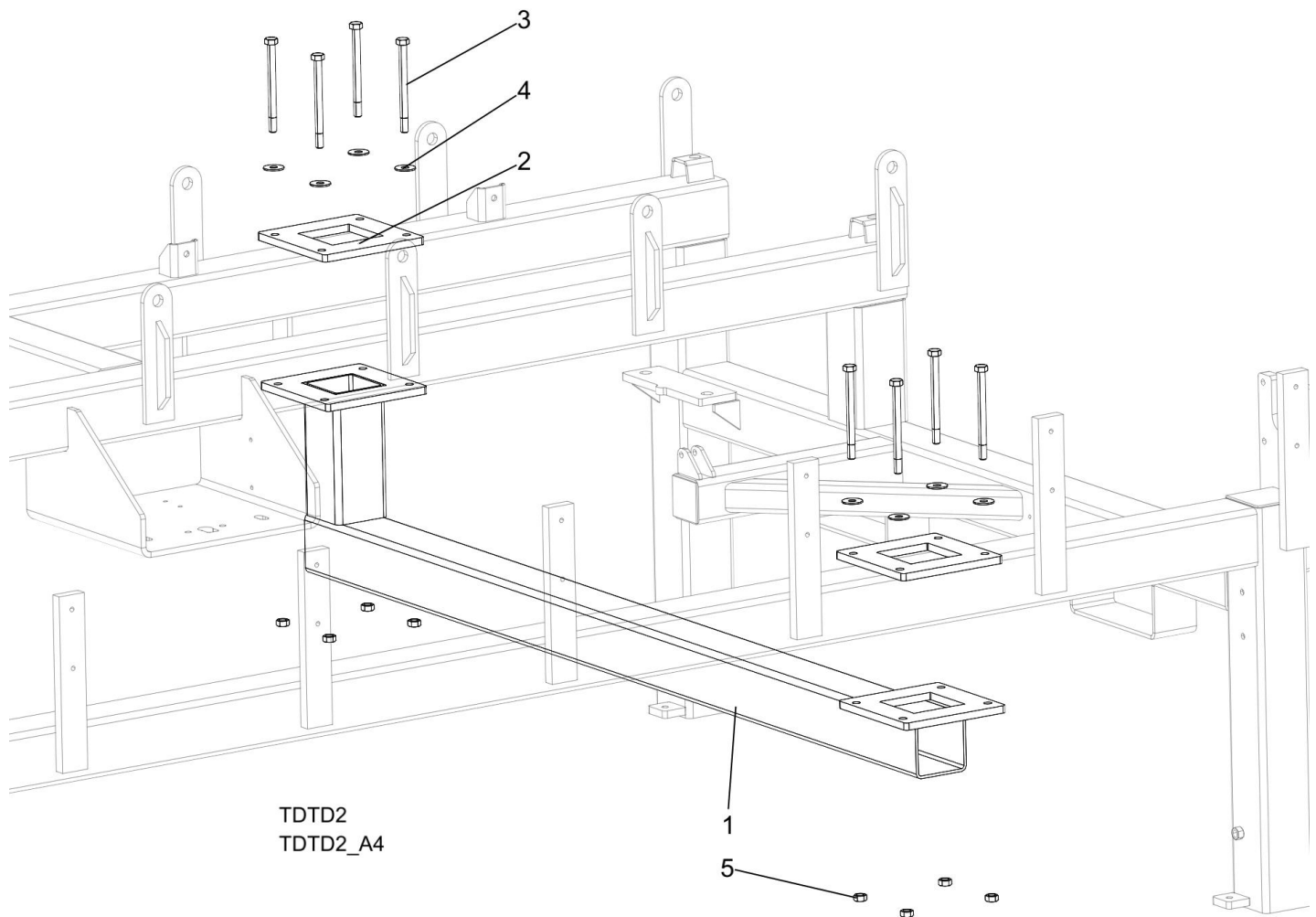
REF	PART #	DESCRIPTION	COMMENTS	QTY.
12	P21527	Fitting, 3/8 NPT-3/8" Straight Air		1
13	F05005-164	Bolt, 1/4-20x2 SBHC BO		2
14	P21528	Muffler, CEC-3 3/8 IN NPT Air		1
15	042659	Valve Assy, Blow-Off		1
16	P21526	Fitting, 3/8NPT-3/8In 90 Deg Air		1
17	F05011-11	Washer, 1/4 SAE Flat		2
18	F05010-69	Nut, 1/4-20 Nylock		2
19	P21521	Fitting, 1/4 IN NPT-3/8 in 90 Deg Air		1
20	036097	Solenoid Assy, Transfer Deck		1
21	034158	Plate, Rubber Bolt		7
22	034153	Stop, Bottom Rubber		7
23	F05007-52	Bolt, 3/8-16x1 SH Cap BO		14
24	F05006-1	Bolt, 5/16-18x1 HH Gr2		3
25	F05011-13	Washer, 5/16 Split Lock		3
26	P07584	Clamp, 1/2EMT Coated		3
27	W21342	Leg Wldmt, MGR Adjust Base		2
28	036365	Frame Wldmt, TD2		1

5.4 Air Filter and Regulator



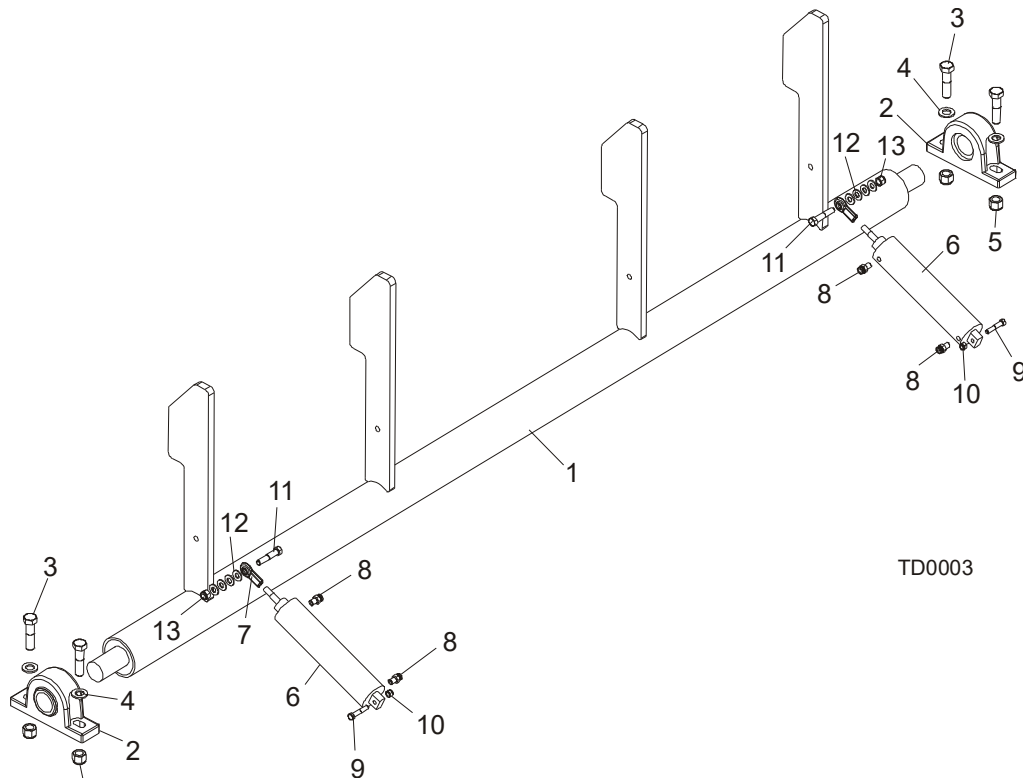
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05005-101	BOLT, 1/4-20 X 1 HEX HEAD GR5		2
2	F05011-11	Washer, 1/4 SAE Flat		4
3	F05010-69	Nut, 1/4-20 Nylock		2
4	036750	Filter, Air F18-03-SK00		1
5	036752	Bracket, Air Filter/Regulator		1
6	036751	Regulator, Air R18-03-F0G0		1
7	P21527	FITTING, 3/8 NPT-3/8" STRGHT AIR		1
8	016822	Fitting, 3/8NPT Male Run Tee		1

5.5 TD Brace



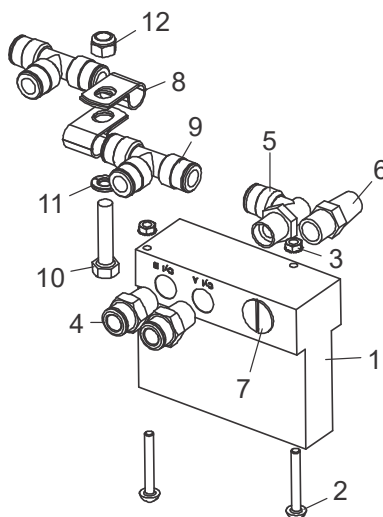
REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	130857	Wldmt, TD Lift Brace		1
2	130858	Plate, TD Lift Clamp		2
3	F05008-107	Bolt, 1/2-13x6 HH Gr5		8
4	F05011-68	Washer, 1/2 Standard Flat		8
5	F05010-35	Nut, 1/2-13 Free Hex, Zinc		8

5.6 Kicker & Air Cylinder



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	034159-1	TUBE ASSEMBLY, KICKER (GRAY)		1
	034159	TUBE ASSEMBLY, KICKER (ORANGE)		1
1	034126-1	Tube Weldment, Kicker (Gray)		1
	034126	Tube Weldment, Kicker (Orange)		1
2	P11107	Bearing, Pillow Block		2
3	F05013-5	BOLT, HEX HEAD 3/4-10 X 3" GRADE 5		4
4	F05011-62	WASHER, 3/4" SAE FLAT		4
5	F05010-103	NUT, 3/4-10 NYLON LOCK		4
	016982	ASSEMBLY, AIR CYLINDER		2
6	016977	Cylinder, 2 1/2" x 8" Air		1
7	016979	End, 1/2-20 Rod		1
8	P21559	Fitting, 1/4" NPT x 3/8" Tube Straight		2
9	F05007-124	Bolt, 3/8-16 x 2" Hex Head Grade 5		1
10	F05010-10	Nut, 3/8-16 Nylon Lock		1
11	F05008-74	Bolt, 1/2-13 x 2 1/2" Hex Head Grade 5		1
12	F05011-2	Washer, 1/2" SAE Flat		4
13	F05010-8	Nut, 1/2-13 Hex Nylon Lock		1

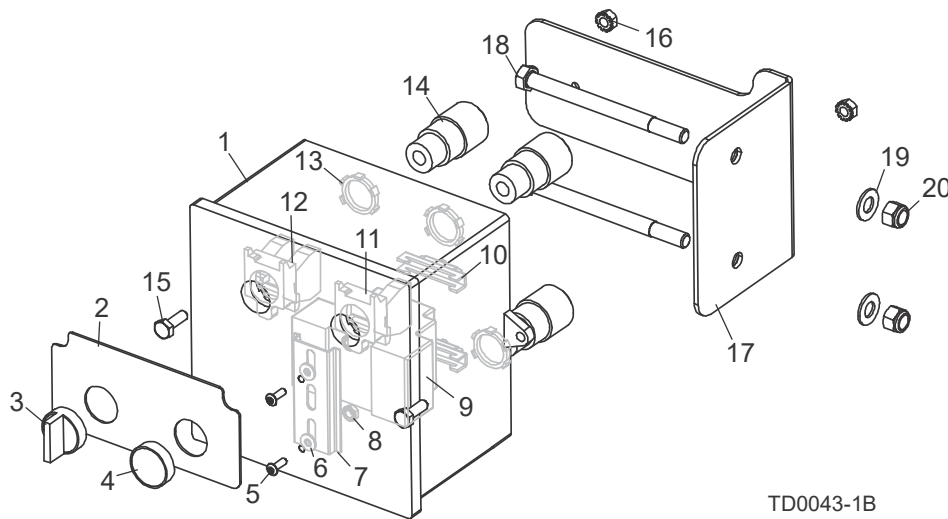
5.7 Kicker Valve/Solenoid



TD0043-2

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	036097	SOLENOID ASSEMBLY, TRANSFER DECK (KICKER VALVE)		1
1	050159	Valve, Solenoid 24VDC 5.4W		1
2	F05004-71	Bolt, #8-32 x 1 1/2" Slotted Round Head		2
3	F05010-41	Nut, #8-32 Self-Locking		2
4	P21527	Fitting, 3/8" NPT x 3/8" Tube		2
5	P21526	Fitting, 3/8" NPT x 3/8" Tube 90° Elbow		1
6	P21528	Fitting, 3/8" NPT Air Muffler		1
7	036060	Fitting, 1/2" NPT Slotted Plug		1
8	P07584	CLAMP, 1/2" COATED EMT		2
9	P21529	FITTING, 3/8" TUBE 'T'		2
10	F05008-96	BOLT, 5/16-18 X 1 1/2" HEX HEAD GRADE 5		1
11	F05011-13	WASHER, 5/16" SPLIT LOCK		1
12	F05010-58	NUT, 5/16-18 HEX NYLON LOCK		1
	R01869-4	HOSE, 1/2" AIR		8.75 ft.

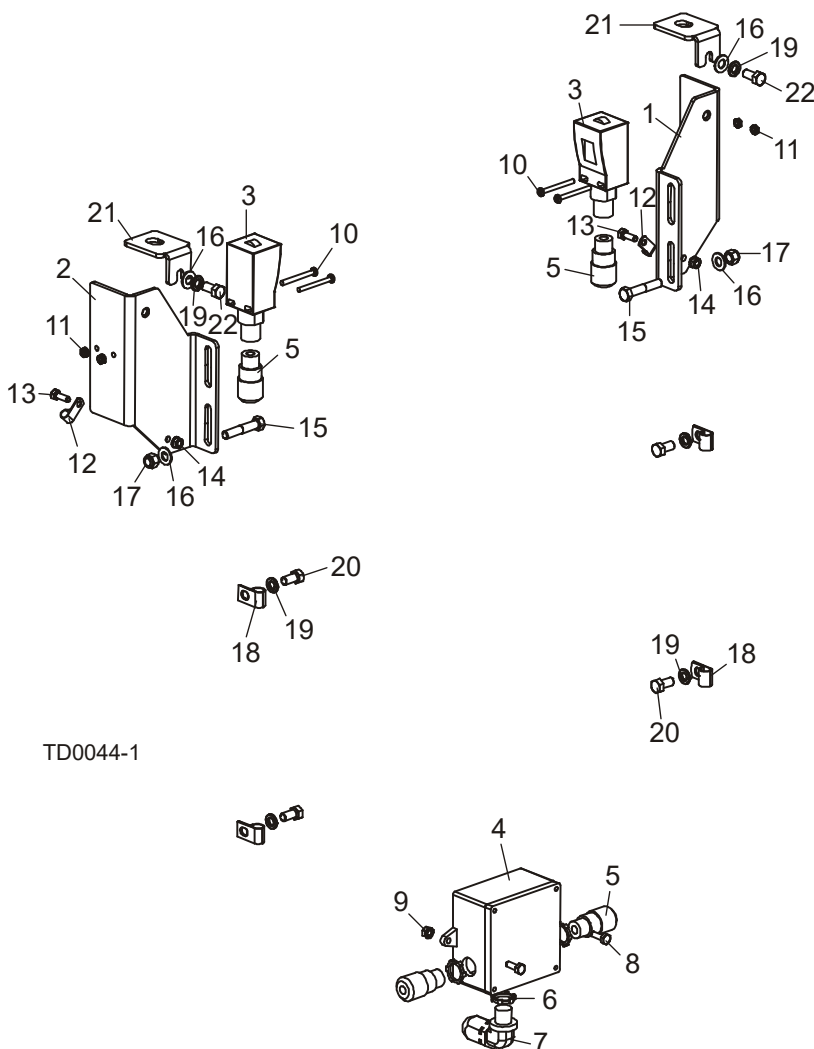
5.8 Control Box



TD0043-1B

REF	PART #	DESCRIPTION	COMMENTS	QTY.
	050184	CONTROL BOX ASSEMBLY, TRANSFER DECK		1
1	050183	Enclosure, 6 X 6 X 4 Plastic		1
2	052278	Decal, Transfer Deck Control (AWMV)		1
3	050199	Switch Head, 22 mm 2 Man 1 Mom Toggle		1
4	050197	Switch Head, 22mm Mom Flush Blue ZB4		1
5	F05004-64	Bolt, #8-32 x 1/2" Socket Button Head Stainless Steel		2
6	F05011-41	Washer, #8 SAE Flat		2
7	024474-3	Rail, 35mm x 7.5mm x 3" DIN		1
8	F05010-41	Nut, #8-32 Self-Locking		2
9	050365	Power Supply, 24VDC 1.0A Switcher		1
10	E22707	Clamp, DIN Rail		2
11	025242	Switch Body, 1NO 22mm ZB4		1
12	050527	Base, 1 NC 1 NO Contact ZB4		1
13	E20461	Nut, 1/2" #141 Lock		4
14	E23492	Connector, Flex .125-.375 Cord 1/2 Hub		4
15	F05005-1	Bolt, 1/4-20 X 3/4" Hex Head		2
16	F05010-9	Nut, 1/4-20 Hex		2
	024923	Cable, 5M Form A DIN 24VDC w/LED PUR Lift Cable		1
	025233	Cable, 10M Form C DIN 24VDC w/LED PUR Kicker Cable		1
17	038724	BRACKET, CONTROL BOX MOUNT		1
18	F05007-109	BOLT, 3/8-16 X 4 3/4" HEX HEAD GRADE 5		2
19	F05011-3	WASHER, 3/8" SAE FLAT		2
20	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		2

5.9 Photo Sensors



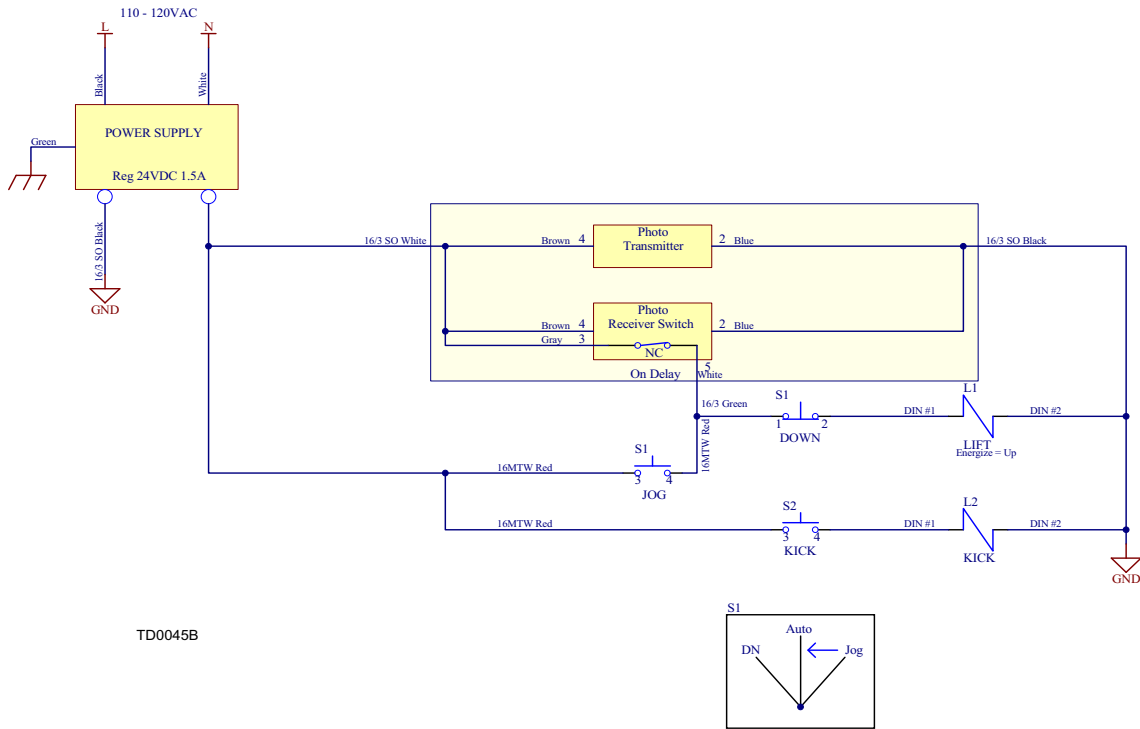
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	050076	CONTROL SYSTEM, TRANSFER DECK ELECTRIC		1
1	006316	Bracket, Photo Sensor Mount Left		1
2	006317	Bracket, Photo Sensor Mount Right		1
	053126	Sensor Assembly, Transfer Deck Control		1
3	053125	Sensor, 240V 3A Photoelectric Receiver/Transmitter		1
4	050179	Box, 4x4x2 Plastic Enclosure		1
5	E23492	Connector, Flex Str. .125-.375 Cord 1/2 Hub		4
6	E20461	Nut, 1/2" #141 Lock		3
7	050202	Connector, Flex 90° .125-.375 Cord 1/2 Hub		1
8	F05005-1	Bolt, 1/4-20 x 3/4" Hex Head Full Thread		2
9	F05010-9	Nut, 1/4-20 Self-Locking Hex		2
	052293	Junction Block, 3-Position Wire Clamp		3
10	F05004-229	Screw, #10-24 x 2" Phillips Pan Head		4
11	F05010-14	Nut, #10-24 Self-Locking Hex		4

REF	PART #	DESCRIPTION	COMMENTS	QTY.
12	050201	Clamp, 3/8" Cable 1/4" Mount		2
13	F05005-1	Bolt, 1/4-20 x 3/4" Hex Head Full Thread		2
14	F05010-9	Nut, 1/4-20 Self-Locking Hex		2
15	F05007-124	Bolt, 3/8-16 x 2" Hex Head Grade 5		2
16	F05011-3	Washer, 3/8" SAE Flat		4
17	F05010-10	Nut, 3/8-16 Hex Nylon Lock		2
18	024155	Clamp, 1/4" Cable 13/32" Mount		4
19	F05011-4	Washer, 3/8" Split Lock		6
20	F05007-27	Bolt, 3/8-16 x 3/4" Hex Head		4
21	006315	Cap, Sensor Mount		2
22	F05007-118	Bolt, 3/8-16 x 3/4" Hex Head Grade 5		2

SECTION 6 ELECTRICAL INFORMATION

6.1 Electrical Diagrams

See Figure 6-1. The electrical diagram is shown below.



TD0045B

FIG. 6-1

6.2 Electrical Component List

Component	Part No.	Description
L1 (Lift)	042659	Solenoid Assembly, Transfer Deck (Lift Valve)
L2 (Kick)	050159	Valve, Solenoid 24V DC 5.4W
Power Supply	050365	Power Supply, 24VDC 1.0A Switcher
Photo Transmitter/ Receiver	053125	Sensor, 240V 3A Photoelectric (Receiver/Transmitter)
S1 (Lift)	050199	Switch Head, 22 mm 2 Man 1 Mom Toggle
	050527	Base, 1 NC 1 NO Contact ZB4
S2 (Kick)	050197	Switch Head, 22mm Mom Flush Blue ZB4
	025242	Switch Body, 1NO 22mm ZB4