

# Wood-Mizer<sup>®</sup>

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

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**MP100 E5**

**rev. A1.00 - A1.05**

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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.

*March 2010*

*Form #1705*

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**Wood-Mizer**  
8180 West 10th Street  
Indianapolis, Indiana 46214

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## SECTION 1 INTRODUCTION

### 1.1 Getting Service

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

#### *General Contact Information*

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

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

**Office Hours:** All times are Eastern Standard Time.

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

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

Wood-Mizer will accept these methods of payment:

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

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

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

# 1

## Introduction

### *Wood-Mizer Locations*

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#### **Wood-Mizer Locations**

##### **USA World Headquarters**

*Serving North & South America, Oceania, East Asia*

Wood-Mizer LLC  
8180 West 10th Street  
Indianapolis, IN 46214

Phone: 317.271.1542 or 800.553.0182  
Customer Service: 800.525.8100  
Fax: 317.273.1011  
Email: [infocenter@woodmizer.com](mailto:infocenter@woodmizer.com)

##### **Canadian Headquarters**

*Serving Canada*

Wood-Mizer Canada  
396 County Road 36, Unit B  
Lindsay, ON K9V 4R3

Phone: 705.878.5255 or 877.357.3373  
Fax: 705.878.5355  
Email: [ContactCanada@woodmizer.com](mailto:ContactCanada@woodmizer.com)

##### **Brazil Headquarters**

*Serving Brazil*

Wood-Mizer do Brasil  
Rua Dom Pedro 1, No: 205 Bairro: Sao Jose  
Ivoti/RS CEP:93.900-000

Tel: +55 51 9894-6461/ +55 21 8030-3338/ +55 51  
3563-4784  
Email: [info@woodmizer.com.br](mailto:info@woodmizer.com.br)

##### **Europe Headquarters**

*Serving Europe, Africa, West Asia*

Wood-Mizer Industries Sp z o.o.  
Nagorna 114  
62-600 Kolo, Poland

Phone: +48.63.26.26.000  
Fax: +48.63.27.22.327

##### **Branches & Authorized Sales Centers**

For a complete list of dealers, visit [www.woodmizer.com](http://www.woodmizer.com)



## **1.2 Machine Description**

The Wood-Mizer moulder is designed for moulding lumber. The machine must not be used for other purposes.

The moulder is equipped with one horizontal cutter adapted for mounting planing knives as well as moulding knives.

By using the machine correctly, you will obtain a perfectly smooth surface and a high degree of accuracy.

The moulder should be operated only by an adult who has read and understood the entire operator's manual.

The machine is built to be durable and easy to operate and maintain.

The moulding head should be moved by using the feed crank to ensure operator safety and best accuracy. The operator must not try to push the moulding head by hand.

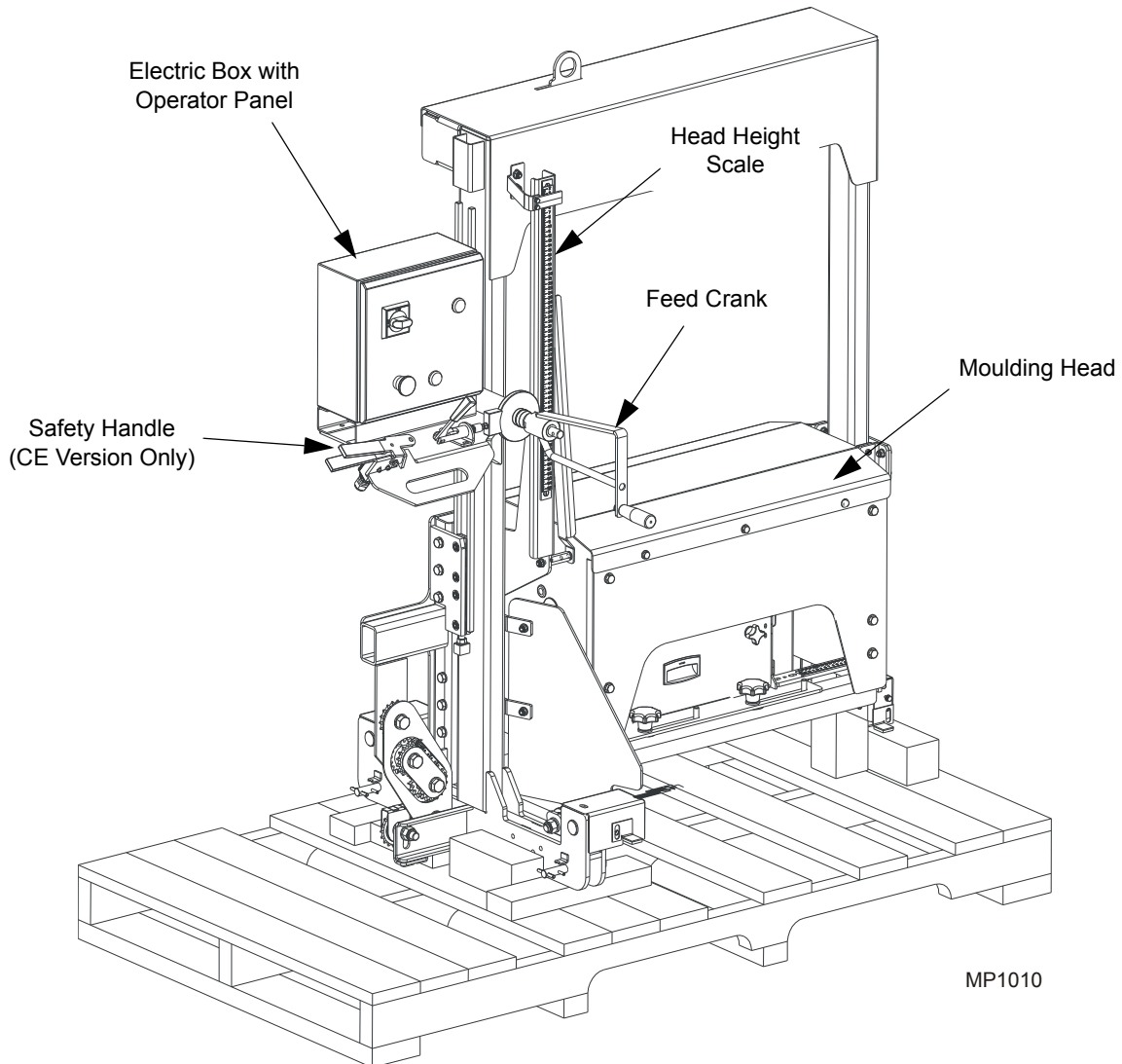
## **1.3 Machine and Site Preparation**

The Wood-Mizer moulder is delivered on a pallet. Due to the weight, it has to be transported with auxiliary carrier equipment and in accordance with general safety rules.

The moulder must be installed in the workplace as instructed in the operator's manual. To ensure safe operation of the machine, the workplace dimensions should be 10 ft. x 33 ft. (3m x 10m). If your machine is equipped with additional bed sections, prepare an appropriately larger work area. The workplace must be protected from rain and snow.

## 1.4 Moulder Components

See Figure 1-1. The major components of the moulder are shown below.



MP1010

**FIG. 1-1**

## SECTION 2 SAFETY

### 2.1 Safety Symbols

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



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



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



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



**IMPORTANT!** indicates vital information.

**NOTE:** gives helpful information.



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

### 2.2 Safety Instructions

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

#### OBSERVE SAFETY INSTRUCTIONS



**IMPORTANT!** Read the entire Operator's Manual before operating this machine. 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 this machine. This machine 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, and operation of your moulder. All owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.

### WEAR SAFETY CLOTHING



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

**WARNING!** Always wear gloves and eye protection when handling moulder knives. Failure to do so may result in serious injury.



**WARNING!** Always wear eye, ear, respiration, and foot protection when operating or servicing this machine..



### KEEP MOULDER AND AREA AROUND CLEAN



**DANGER!** Maintain a clean and clear path for all necessary movement around the moulder and lumber stacking areas. Failure to do so will 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 MOULDER BEFORE OPERATION



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



**WARNING!** Always shut off the motor to stop the knives whenever the machine is not in use. Failure to do so may result in serious injury.



**WARNING!** Do not for any reason adjust the motor drive belts with the motor running. Doing so may result in serious injury.

## KEEP PERSONS AWAY

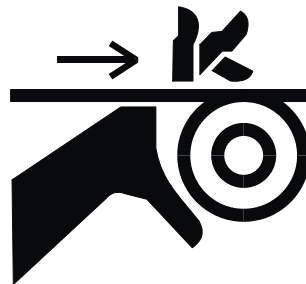


**DANGER!** Keep all persons at a safe distance of at least 3 meters from the machine when operating the moulder. Failure to do so will result in serious injury.

## KEEP HANDS AWAY

**DANGER!** Moving Parts Can Crush and Cut. Keep hands clear. Make sure all guards and covers are in place and secured before operating. 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!** Coastdown Required. Always shut off the motor and allow all moving parts to come to a complete stop before removing any guards or covers. Do NOT operate with any guards or covers removed.

**DANGER!** Before changing the knives or performing any service to the machine, disconnect the power cord from the electric box.

**IMPORTANT!** The knives housing cover is equipped with a safety key switch. As soon as you open the cover, the motor will be turned off and all moving parts will stop spinning. The safety switch should always be in proper working condition.

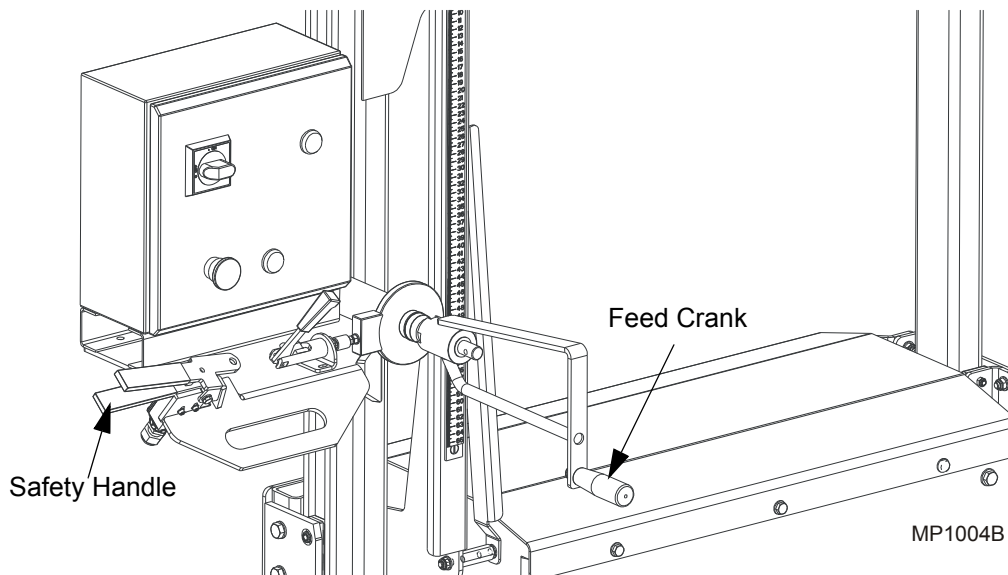
### MOULDER OPERATION



**CAUTION!** Always operate the moulder in good light conditions. The illumination at the operator position should be at least 300 lx. Never operate the moulder under the influence of alcohol or drugs.




**DANGER!** Always firmly hold the safety handle and the feed crank. Be aware that the moulding head can move towards you when you are working with hard wood or if the material is not secured properly. The planing head can be moved by using the crank only. Never push/pull the planing head manually.




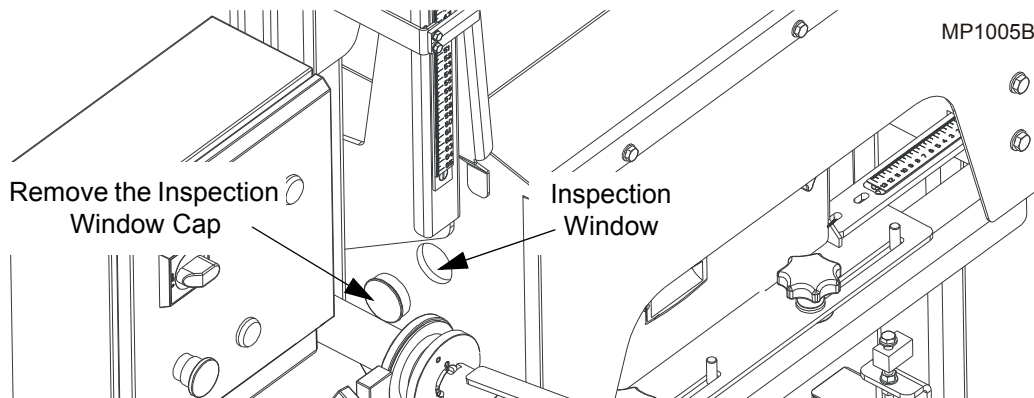
**FIG. 2-1**




**WARNING!** Be sure that the cutting knives are firmly mounted before starting the motor.

 **IMPORTANT!** When starting the machine for the first time, make sure that the cutter rotation direction is as indicated by the arrow located on the side cover. If the rotation direction is incorrect, invert the phases in the phase inverter located in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure the correct cutter rotation direction.

 **DANGER!** To check the cutter rotation direction, look at the motor fan when the motor is starting or stopping through the inspection window shown below. Do not for any reason check the rotation direction by touching the cutter using any tool or a piece of wood. Doing so may result in serious injury or death.



**FIG. 2-2**

 **DANGER!** It is allowed to mould/plane only in the direction shown below. Never try to mould/plane in the opposite

direction (when you return the head).

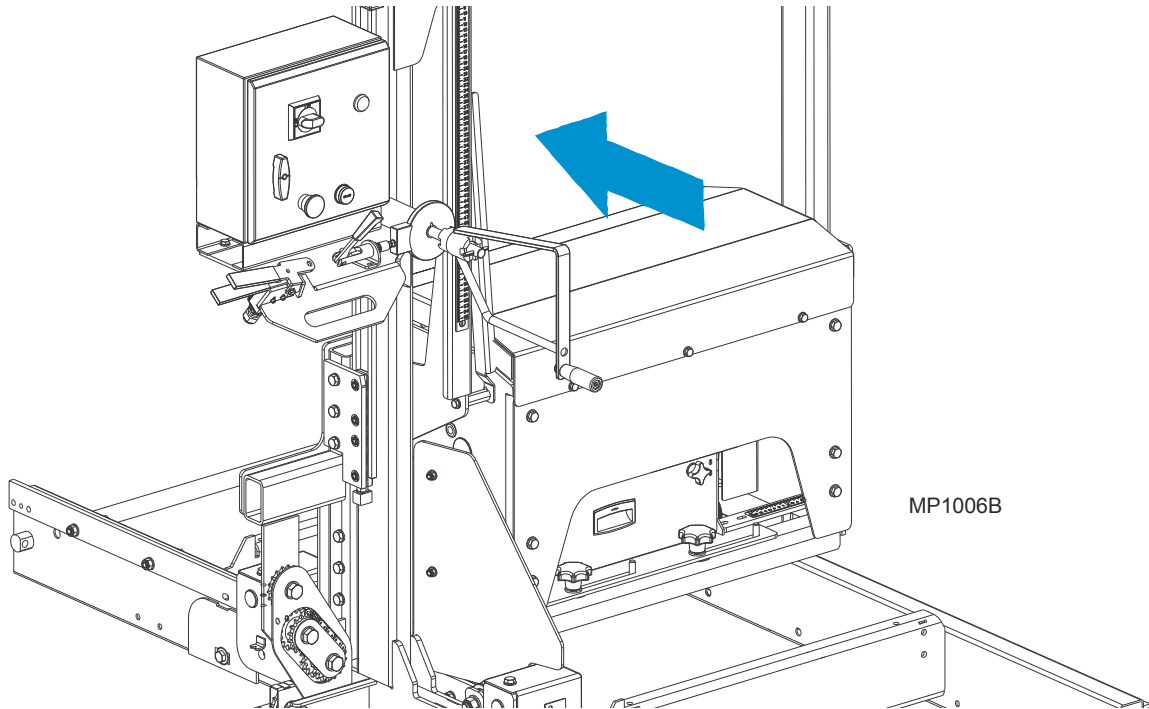


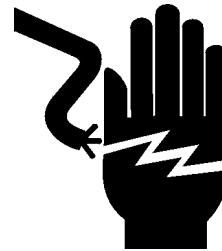
FIG. 2-3

### 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 machine 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.



**IMPORTANT!** The moulder is equipped with an emergency stop button. This button is used to immediately stop the motor in hazardous situations. The emergency stop button should always be in proper condition.

**IMPORTANT!** The machine must not be modified by the owner. Use only original spare parts.

### KEEP SAFETY LABELS IN GOOD CONDITION



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

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




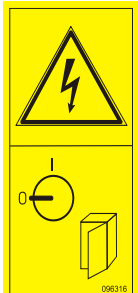
### FIRE-FIGHTING

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

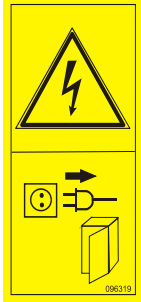




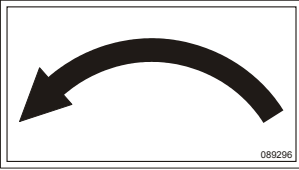
**SAFETY LABELS DESCRIPTION**

See Table 2-1. See the table below for safety labels description.

**TABLE 2-1**

Decals View	Decal No.	Description
	096317	CAUTION! Read thoroughly the manual before operating the moulder. Observe all safety instructions and rules when operating the machine.
	099220	Close guards prior to operating the machine.
	099221	CAUTION! Keep all persons a safe distance away from work area when operating the machine.
	096316	Do not open or close the electric box when the switch <b>is not</b> in the "0" position.

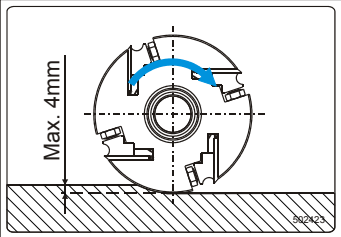

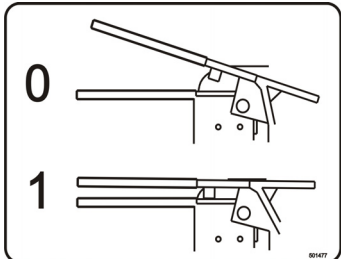
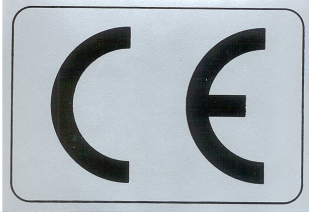
**TABLE 2-1**

	<p>096319</p>	<p>Always disconnect the power cord before opening the electric box.</p>
	<p>S12004G</p>	<p>Always wear eye protection equipment when operating this machine.</p>
	<p>S12005G</p>	<p>Always wear ear protection equipment when operating this machine.</p>
	<p>501465</p>	<p>Always wear safety boots when operating this machine.</p>
	<p>501467</p>	<p>Lubrication point</p>
	<p>089296</p>	<p>Rotation direction</p>

# 2

## Safety Safety Instructions

**TABLE 2-1**

	<p>502423</p>	<p>Maximum moulding depth</p>
	<p>087649 502481</p>	<p>Warning stripe</p>
	<p>501477</p>	<p>Safety handle. The blade is stopped when the handle is released (CE version only).</p>
	<p>P85070</p>	<p>CE certified machine (CE version only).</p>

**DANGER!** Lockout procedures must be used during:

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

**Maintenance hazards include:**

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

Failure to lockout may result in:

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

**To control maintenance dangers:**

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

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

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

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

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

Always follow safe operations practices in the workplace.

## **MOULDER LOCKOUT PROCEDURE**

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

### **Purpose:**

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

### **Responsibility:**

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

### **Preparation For Lockout:**

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

### **Sequence of Lockout Procedure:**

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

### **Restoring Equipment to Service**

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

### **Procedure Involving More Than One Person**

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

### **Rules for Using Lockout Procedure**

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

### **Owner's Responsibility**

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

## SECTION 3 MOULDER ASSEMBLY

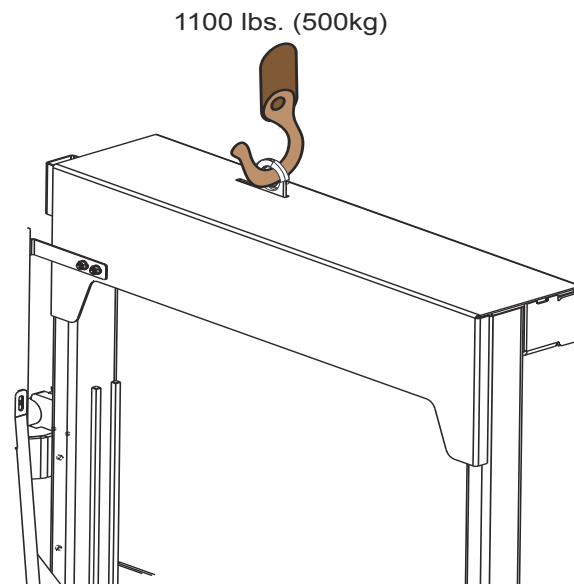
### 3.1 Unpacking the Moulder

1. Cut the bands holding the components together.
2. Remove the parts arranged inside the bed section.
3. Attach the winch hook to the bracket on the head. Using a forklift truck or a winch with lifting capacity of at least 1100 lbs. (500 kg), carefully lift the head and set it aside.



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

See Figure 3-1.

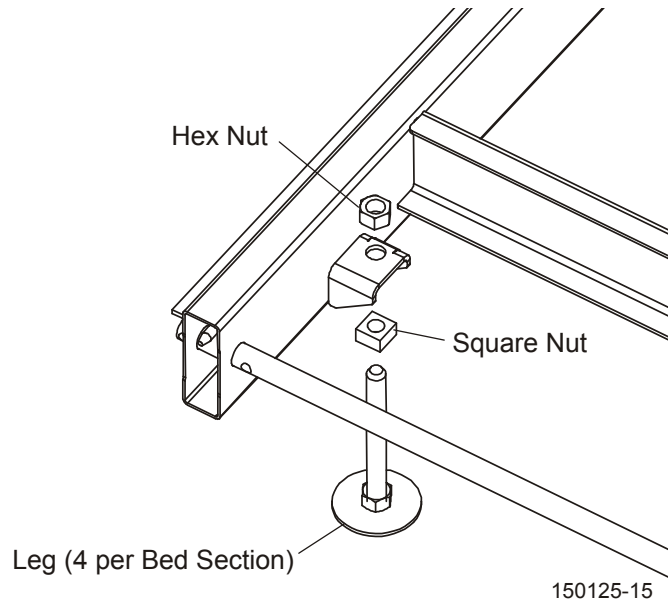


**FIG. 3-1**



### 3.2 Bed Section Leg Assembly

See **Figure 3-2**. Assemble four legs to each bed section. Mount each leg with a square nut and hex nut around the leg bracket (requires 1 5/16" wrench).



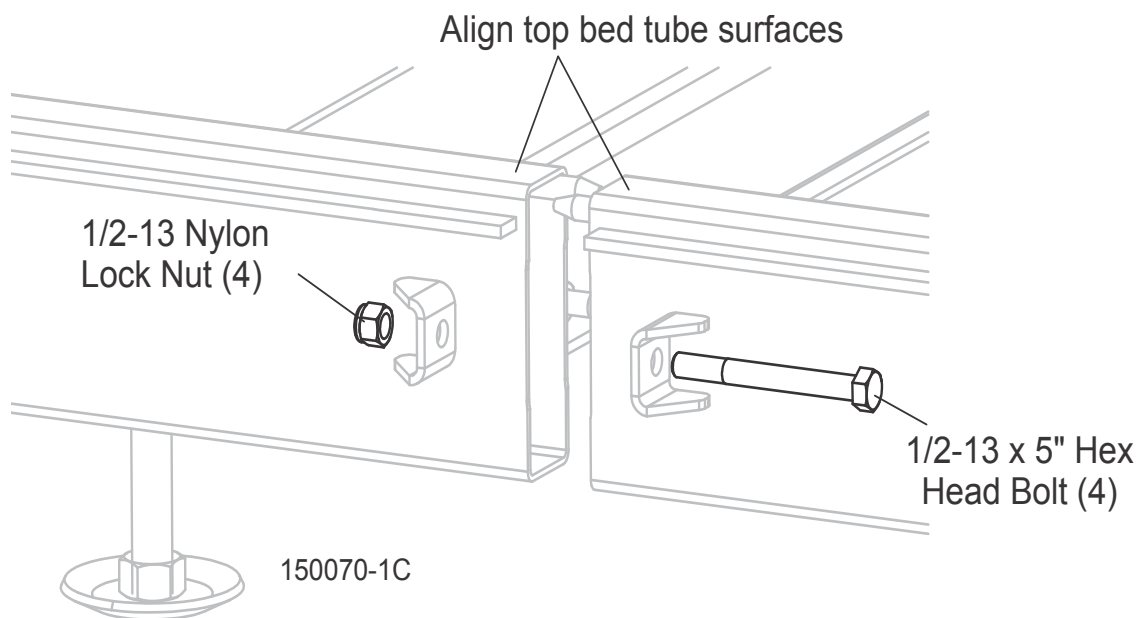
**FIG. 3-2**

### 3.3 Bed Section Assembly

**NOTE:** Disassemble any shipping straps from the bed sections before beginning.

Lay the bed sections end-to-end so the track portion of each section is on the same side. Slide the sections together and secure with four 1/2-13 x 5" hex head bolts and nylon lock nuts.

See Figure 3-3.

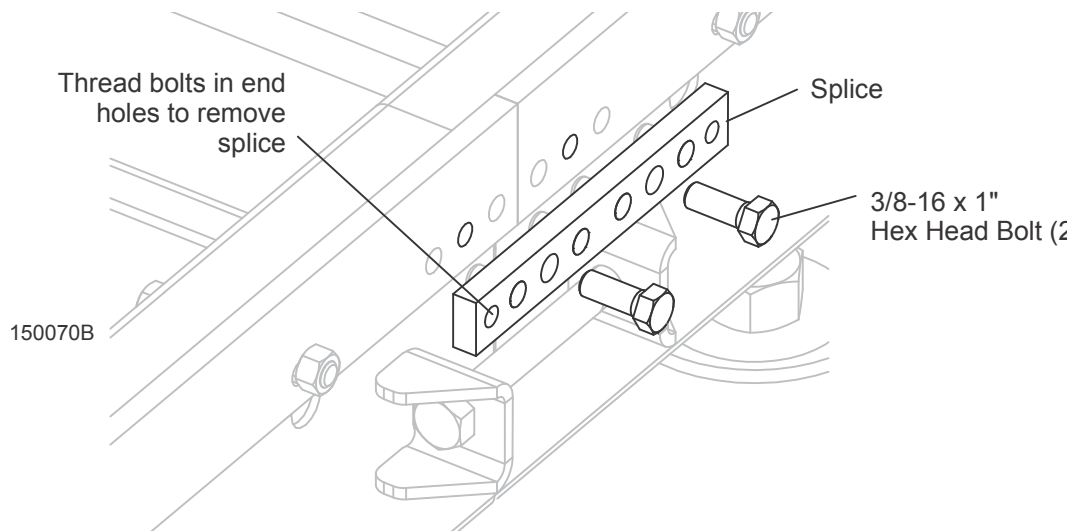


**FIG. 3-3**

Make sure the top surfaces of the outer side of the bed sections are aligned. It may be necessary to pry one bed section up or down until the surfaces are aligned, then tighten the bolts.

Insert the splice pins into the holes in the track rail and secure with two 3/8-16 x 1" hex head bolts.

See Figure 3-4.



**FIG. 3-4**

**TIP:** The threaded holes at the end of the splice are provided to help remove the splice if you wish to disassemble the sawmill. Remove the two splice bolts from the middle holes and thread into the end holes. Evenly turn the bolts clockwise to push the splice pins out of the track rail holes.

# 3 Moulder Assembly

## Log and Cant Clamp Assembly

### 3.4 Log and Cant Clamp Assembly

See Figure 3-5. Remove the bolt from each clamp assembly. Assemble a log clamp to a bed rail on each bed section and reinstall the bolts.

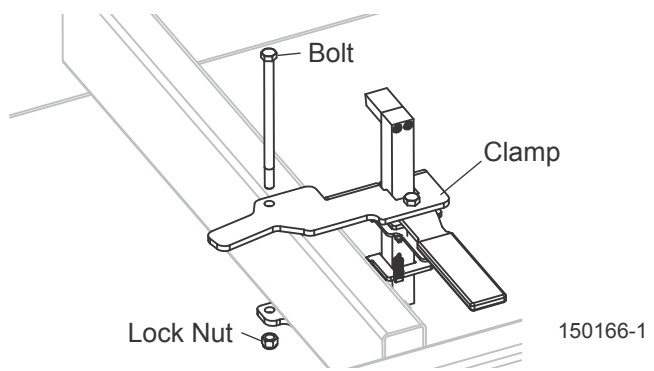


FIG. 3-5

See Figure 3-6. Install the optional cant clamp (if equipped) to the bed section. To install, drill four holes in the cross tube as shown below.

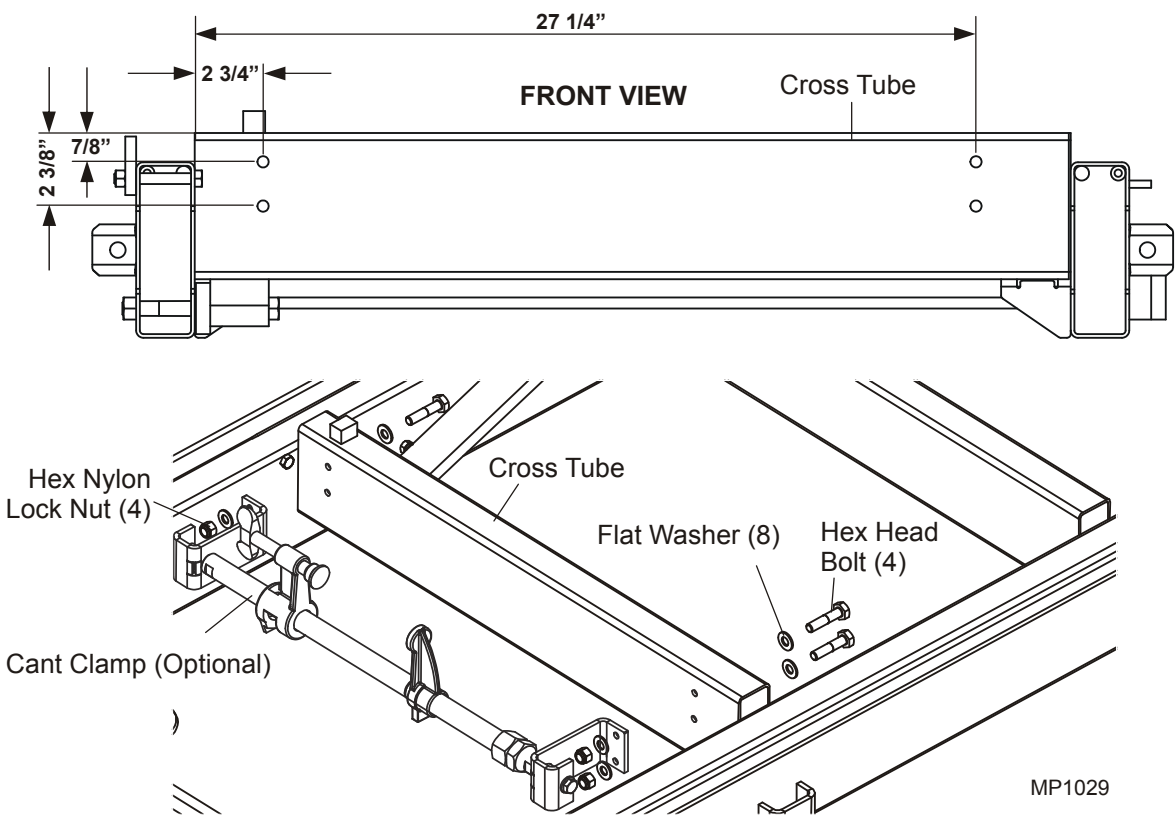


FIG. 3-6

### 3.5 Frame Leg Adjustment

See Figure 3-7. Use a 1 1/4" wrench to turn the hex nut and adjust each leg until the top of the leg is approximately 1" below the bed tube.

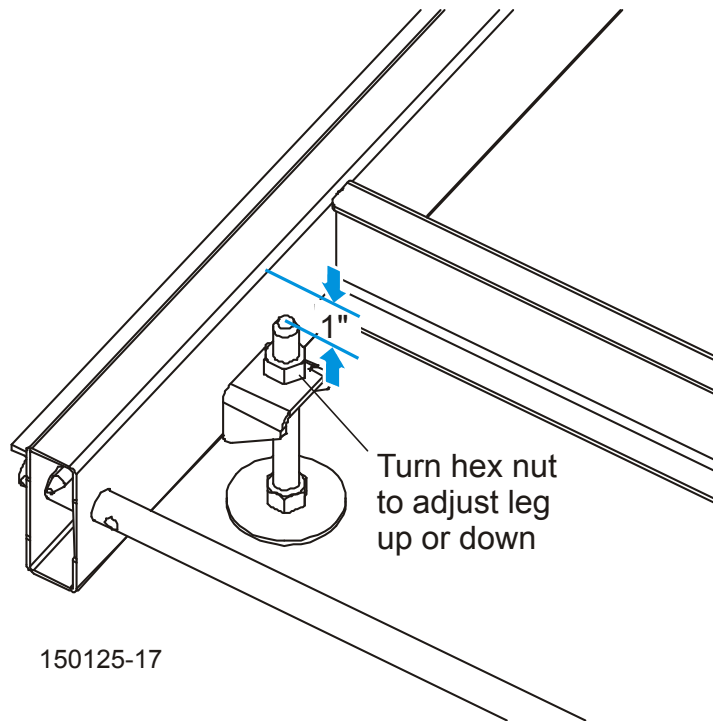


FIG. 3-7

## 3 Moulder Assembly

### Head Assembly

### 3.6 Head Assembly

1. Position the head at the end of the bed frame assembly. Carefully slide the head rollers onto the bed frame track. Keep the head square to the bed to avoid putting the track rollers in a bind.



**WARNING!** When setting the head on the bed frame, use extreme caution and keep all persons at a safe distance. Failure to do so may result in serious injury or death.

2. Install the middle track cover with a felt strip to using a 6.4 flat washer and M6x12 hex head bolt.

See Figure 3-8.

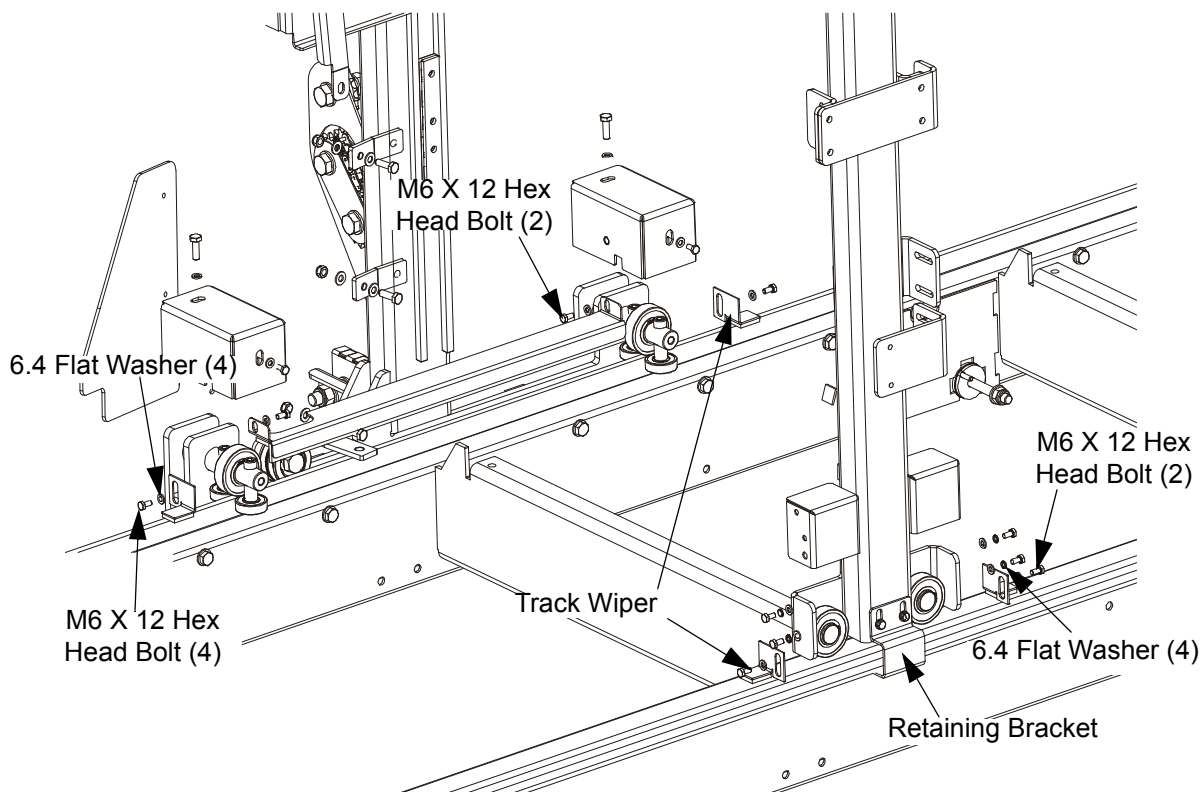


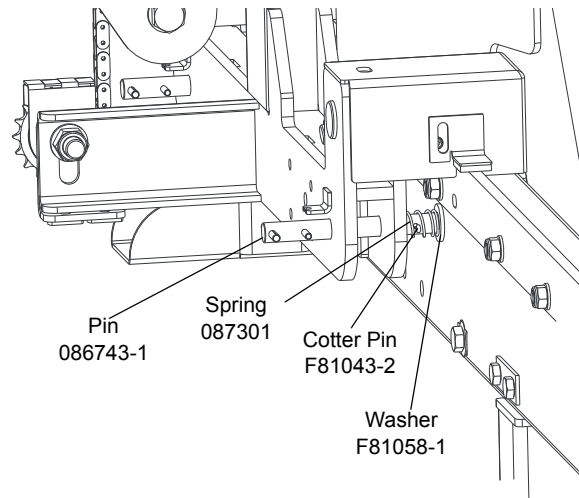
FIG. 3-8

3. Assemble the retaining bracket to the right side of the mast with two hex head bolts and flat washers.
4. Assemble the four track wipers to the left and right sides of the mast using the hex head bolt and flat washers.

**NOTE:** Before installing the felt wipers, soak the felt strips with lubricating fluid.

5. Assemble the mast safety pins.

See Figure 3-9.



**FIG. 3-9**

6. Install the PC operator guard.
7. Install the power cord bracket.

# 3 Moulder Assembly

## Feed Rope Assembly

### 3.7 Feed Rope Assembly

1. Install a feed rope mounting bracket at each end of the bed assembly using a 1/2-13 x 2 1/4" hex head bolt, spacer, flat washer and nylon lock nut. Be sure to use the brackets so they are angled toward the end of the frames as shown.

See Figure 3-10.

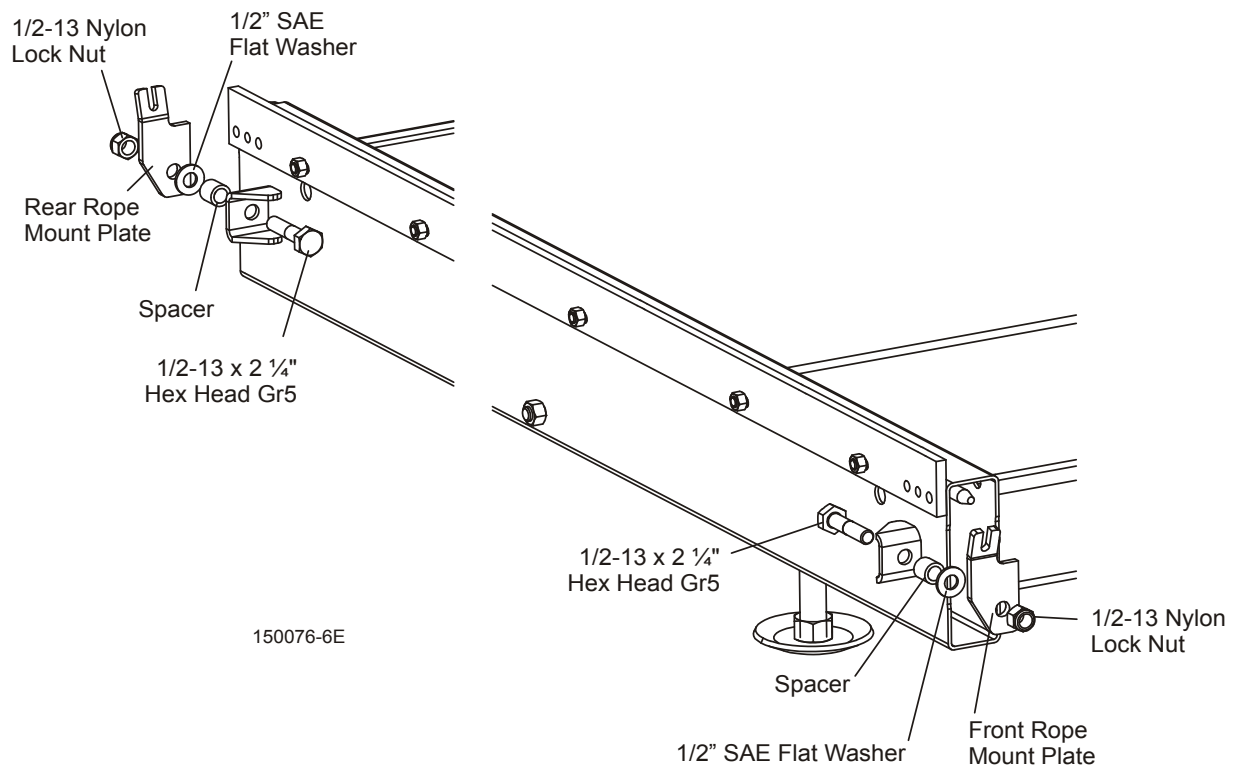
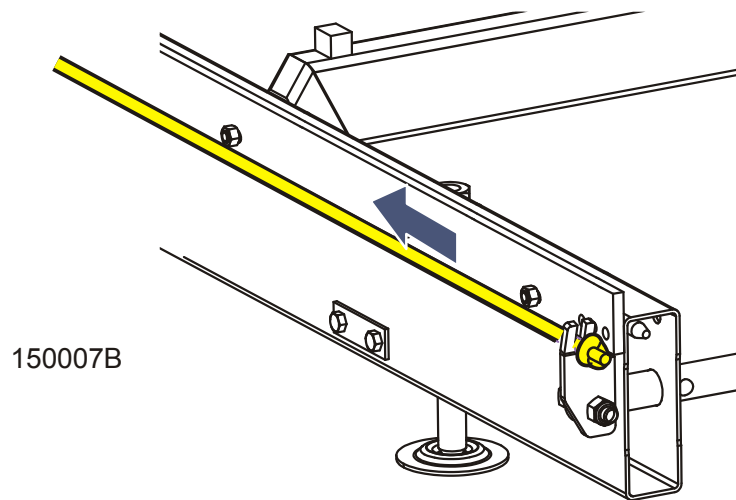


FIG. 3-10



2. Tie a knot in one end of the feed rope. Slip the knotted end of the rope into the front rope mount plate. Route the rope between the saw head carriage and bed frame tube.

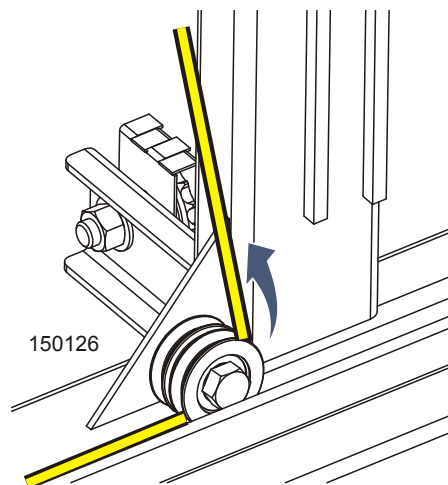
See Figure 3-11.



**FIG. 3-11**

3. Loop the rope counterclockwise around the lower feed pulley and route to the feed crank handle.

See Figure 3-12. Loop the feed rope around the outer groove of the lower pulley.



**FIG. 3-12**

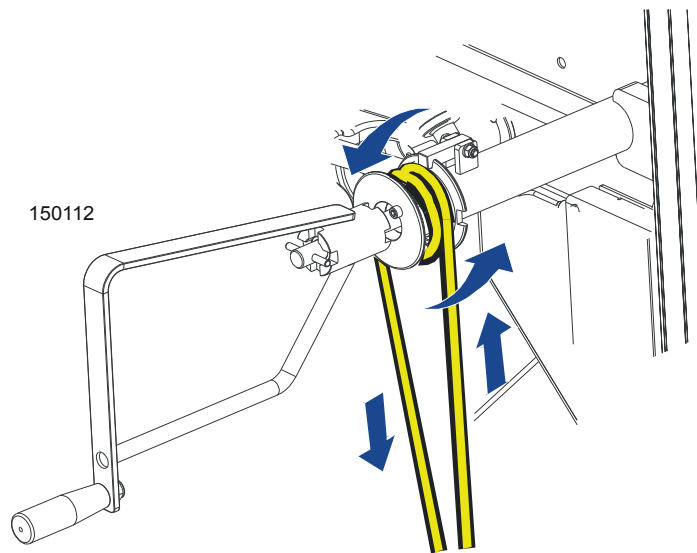
# 3

## Moulder Assembly

### Feed Rope Assembly

4. Loop the rope around the feed crank spool three times and route back down to the outer v-groove roller.

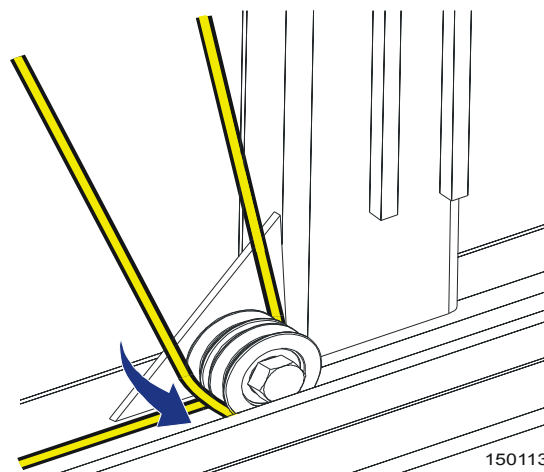
See Figure 3-13.



**FIG. 3-13**

5. Route the rope around the outer groove of the v-groove roller.

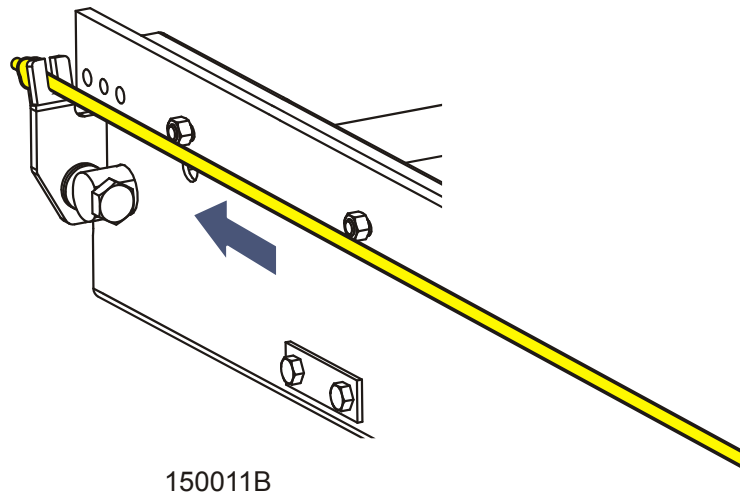
See Figure 3-14.



**FIG. 3-14**

6. Route the rope to the rear mounting bracket. Tie a knot in the end of the rope and insert into the mounting bracket. Position the knot in the rope so when installed to the rear bracket, the rope is tight.

**See Figure 3-15.**



**FIG. 3-15**

## SECTION 4 SETUP & OPERATION

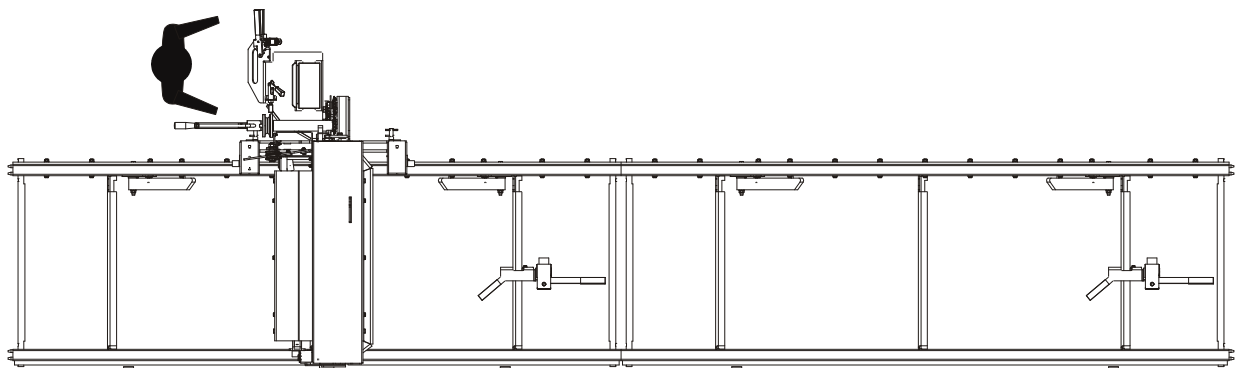
### 4.1 Moulder Setup



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

- Set up the moulder on firm, level ground and level the moulder frame. Secure the moulder to the ground to prevent moving during operation. A concrete foundation or pads and anchored bolts are recommended.
- The moulder should be operated under roof only.
- The moulder should always be operated with the sawdust collection system.
- The moulder should be operated in temperature range from 5 F to 104 F (-15° C to 40° C) only.
- The illumination at the operator's position should be at least 300lx.
- The moulder operator's position is shown below.

See Figure 4-1.



**FIG. 4-1**

- Have a qualified electrician install the power supply. The power supply must meet the specifications given in the table below.

See Table 4-1.

	Voltage	Fuse Disconnect	Suggested Wire Size
1-Phase Motor	230 VAC	50A	8 AWG
3-Phase Motor	460 VAC	15A	14 AWG

TABLE 4-1



**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 (fan guard). If the rotation direction is incorrect, invert the phases in the phase inverter in the power socket (electric box). Setting the phases in the phase inverter correctly will ensure correct rotation directions of all moulder motors.



**DANGER!** To check the cutter rotation direction, look at the motor fan when the motor is starting or stopping through the inspection window shown below. Do not for any reason check the rotation direction by touching the cutter using any tool or a piece of wood. Doing so may result in serious injury or death.

See Figure 4-2.

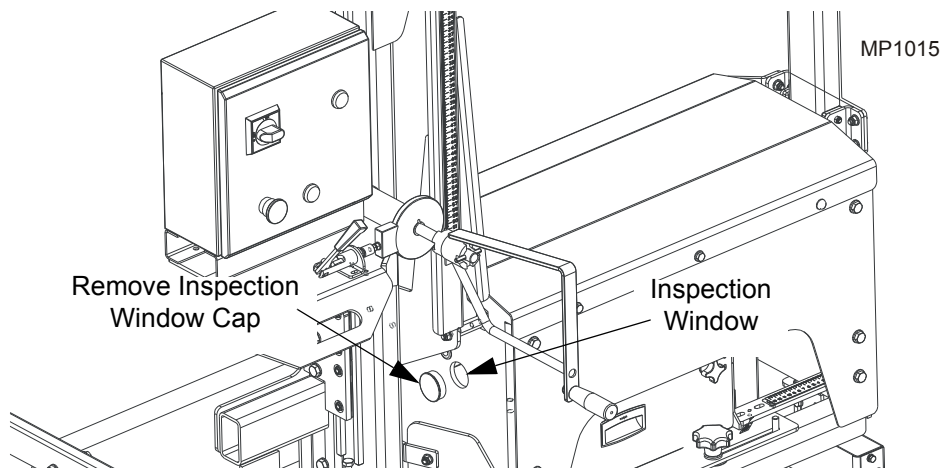


FIG. 4-2



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

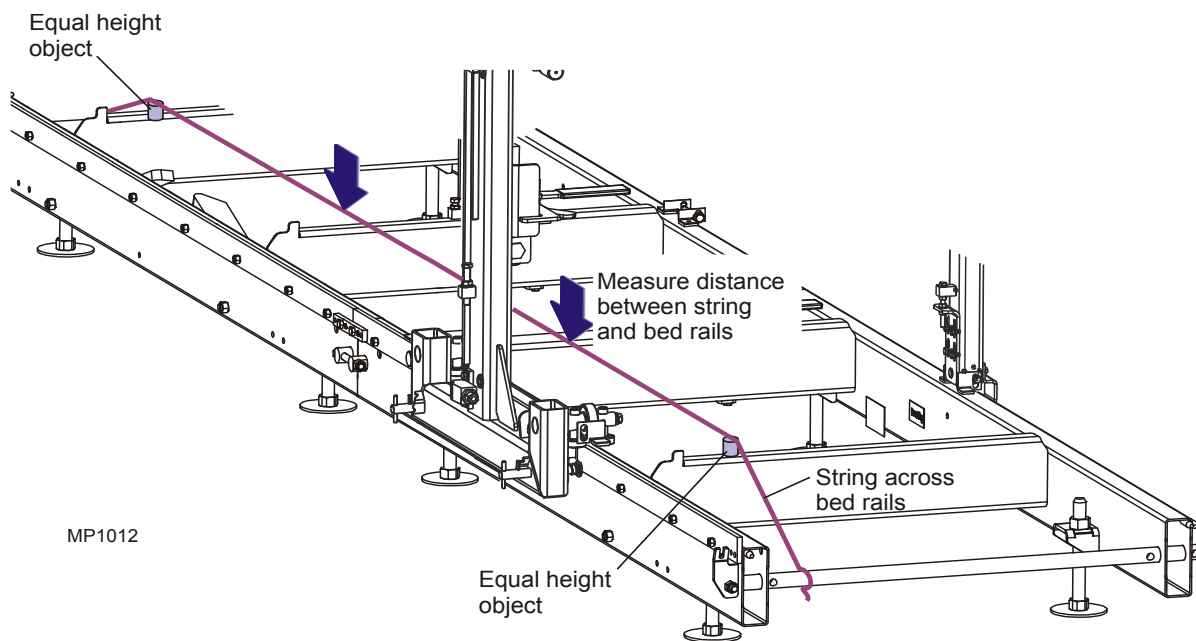
**NOTE!** The following setup procedure should be performed whenever the moulder is moved or reassembled. If sawing problems occur and misalignment is suspected, see Section 6 for complete alignment instructions.

# 4

## Operation Moulder Setup

1. Adjust the frame legs so the moulder appears level. If the moulder is on soft ground, use shims under the legs if necessary.
2. Run a string from the front bed rail to the rear bed rail near the operator's side of the frame. Place identical spacers between the string and the front and rear bed rails. Measure the distance between the string and the other bed rails. Adjust the frame legs until all bed rails measure the same distance from the string.

See Figure 4-3.

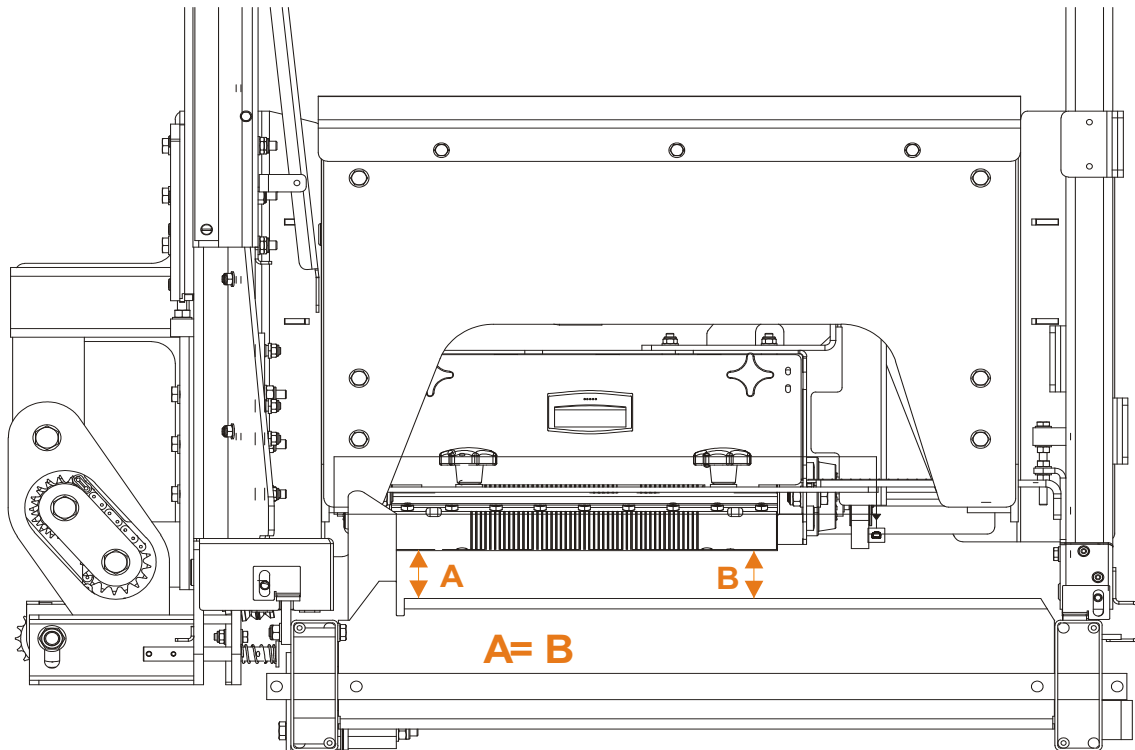


**FIG. 4-3**

3. Repeat the bed rail adjustment with the string at the other side of the moulder frame.

4. Move the head until it is positioned over the bed rail.
5. Measure the distance from the cutter to the bed rail in the places shown below. The dimensions A and B should be the same.

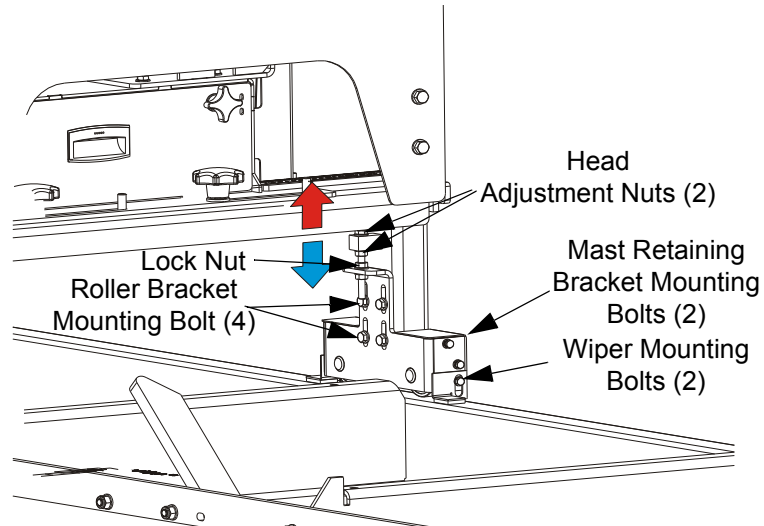
See Figure 4-4.



**FIG. 4-4**

6. If the dimensions A and B are not the same, adjust the head tilt as shown in the Figure 4-5.

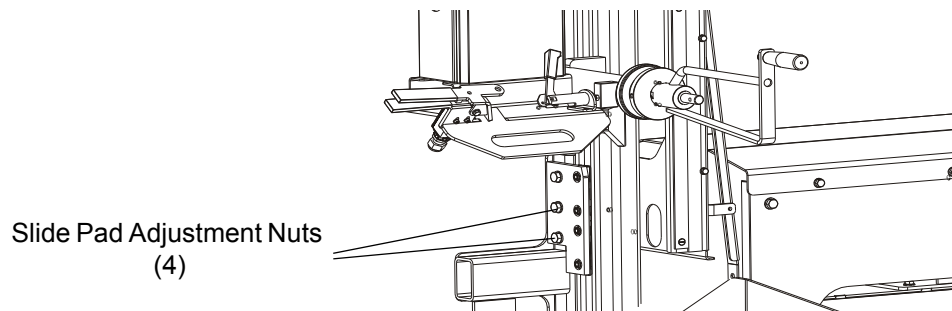
**See Figure 4-5.** To adjust the head tilt, loosen the four mounting bolts of the side roller bracket, the two wiper mounting bolts and the two mounting bolts of the mast retaining bracket. Use the head adjustment nuts to move the outside of the head up or down.



**FIG. 4-5**

7. Make sure the entire face of each slide pad makes contact with the mast. Use the adjustment nuts on both sides of the mast to adjust the slide pads if necessary.


**See Figure 4-6.**




**FIG. 4-6**





## 4.2 Mounting the Planing Knives

 **WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before mounting/dismounting the knives.

 **WARNING!** Always wear gloves and eye protection when mounting/dismounting the knives. The knives are very sharp. You can hurt yourself even when you touch any knife lightly.

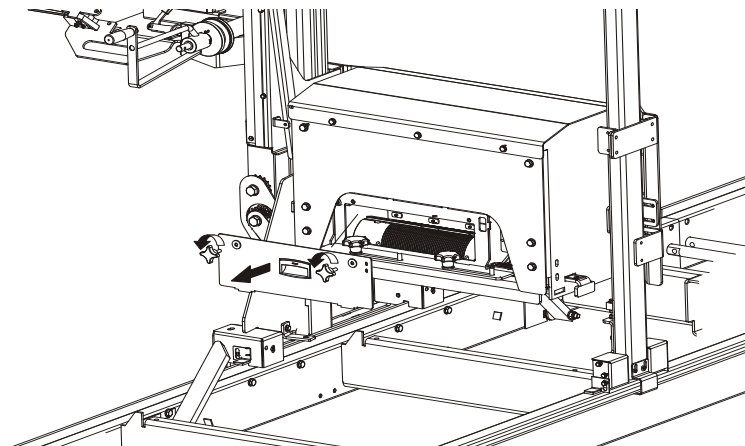


 **WARNING!** Before mounting the knives, make sure the knives, the mounting strip and the cutter sockets are immaculately clean. Any sawdust or resin inside the cutter may cause the knife to break. Damaged knives or mounting strip should be replaced immediately.

 **IMPORTANT!** The knives must be mounted in pairs. It is possible to mount only two knives in opposite sockets, but we recommend that the knives be mounted in all four sockets.

1. Remove the cutter cover.

See Figure 4-7.



**FIG. 4-7**

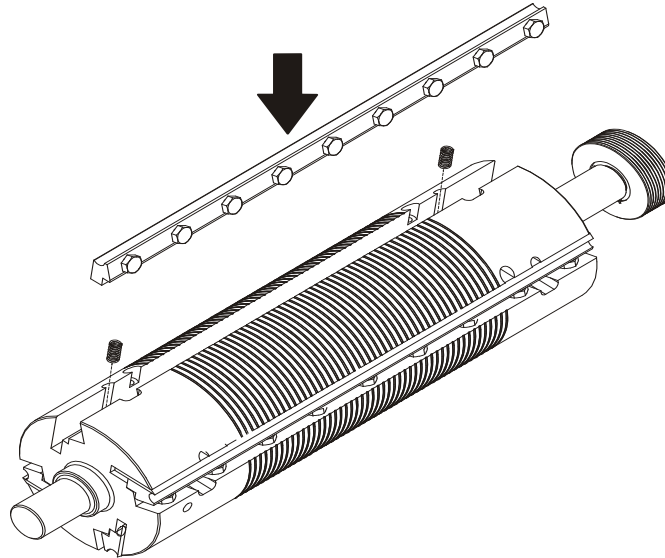
# 4

## Operation

### *Mounting the Planing Knives*

2. Clean thoroughly any dust, chips and debris from the cutter socket, the mounting strip and the knives. Insert the springs in the holes shown below. Next, screw in all mounting strip bolts and place the strip in the socket as shown below.

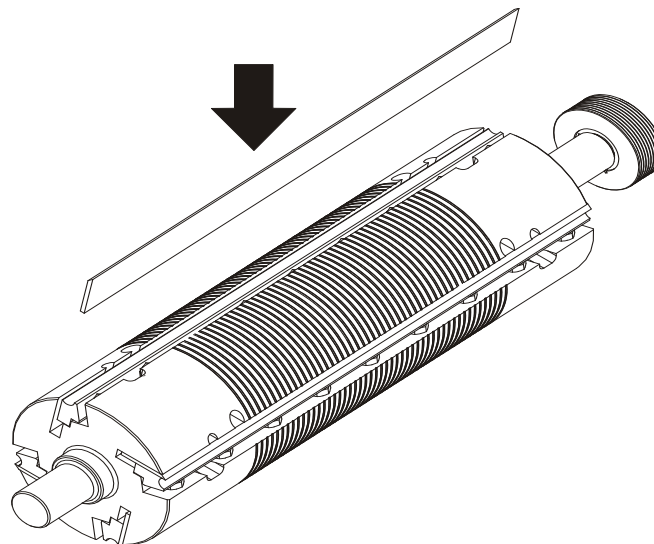
See Figure 4-8.



**FIG. 4-8**

3. Carefully slide the knife into the socket as shown below.

See Figure 4-9.



**FIG. 4-9**

- Place one of the alignment tools over the knife, on the left side of the cutter. Place the other alignment tool on the right side of the cutter as shown below. Each knife socket is equipped with a spring that lifts the knife and make the adjustment easier.

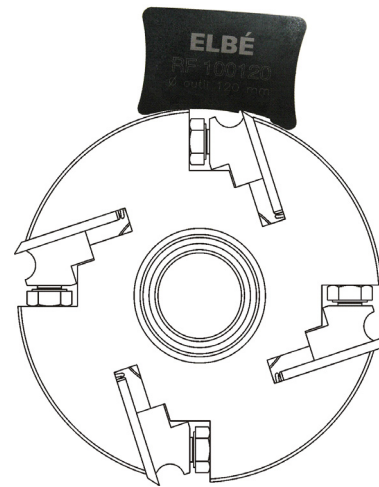





FIG. 4-9


- Tighten all mounting strip bolts starting from middle of the cutter, to the outside.
- Place the alignment tools over the remaining knives and repeat the adjustment procedure described above.

 **DANGER!** Make sure that all mounted knives are aligned identically. If they are not, it will cause vibrations of the cutter, resulting in personal injury.

 **DANGER!** Make sure that there are no tools left inside the cutter housing or on the frame.

 **DANGER!** Make sure that all knives mounting strips bolts are securely tightened.

To remove the knife from the cutter, loosen the mounting strip bolts. Carefully remove the knife.

 **DANGER!** Be very careful when loosening the mounting strip bolts of the knives already mounted, because the spring can push out the knife rapidly, causing injury.

### 4.3 Mounting the Moulding Knives



**WARNING!** Always shut off the motor and allow all moving parts to come to a complete stop before mounting/dismounting the knives.



**WARNING!** Always wear gloves and eye protection when mounting/dismounting the knives. The knives are very sharp. You can hurt yourself even when you touch any knife lightly.



**WARNING!** Before mounting the knives, make sure the knives, the mounting wedges and the cutter sockets are immaculately clean. Any sawdust or resin inside the cutter may cause the knife to break. Damaged knives or clamping wedges should be replaced immediately.



**IMPORTANT!** The knives should be mounted symmetrically. They should be mounted in the same position on the cutter.

1. Remove the cutter cover.

See Figure 4-10.

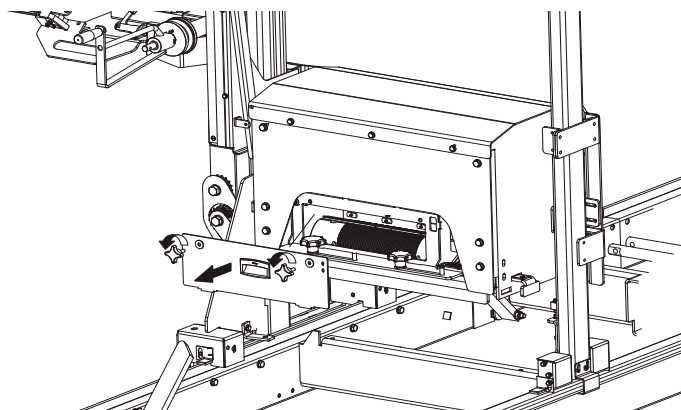
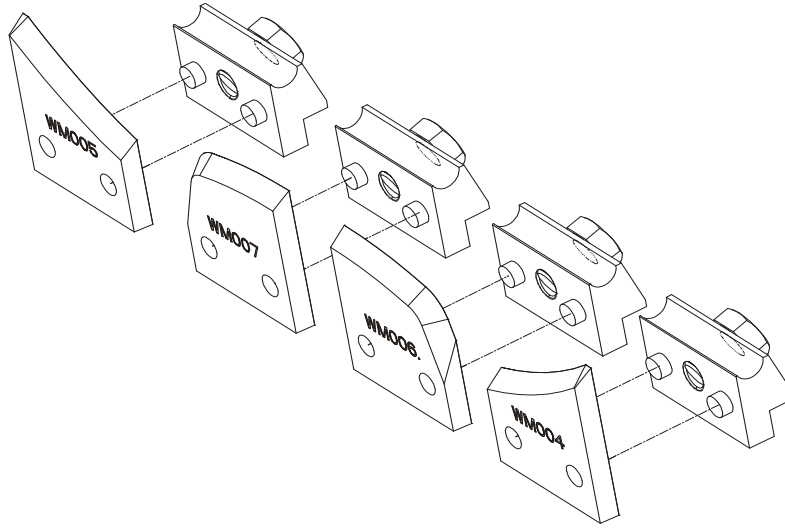


FIG. 4-10

2. Clean thoroughly any dust, chips and debris from the cutter socket, the clamping wedges and the knives. Remove the springs from the holes in the cutter. Screw in the bolts of the clamping wedges and assemble the knives to the clamping wedges as shown below.

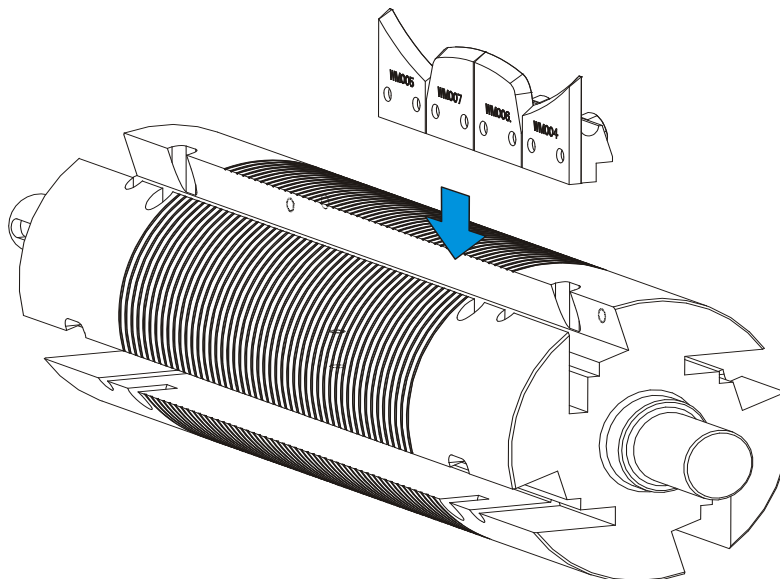
See Figure 4-11.



**FIG. 4-11**

3. Carefully insert the knives with the clamping wedges in the cutter socket as shown below.

See Figure 4-12.



**FIG. 4-12**

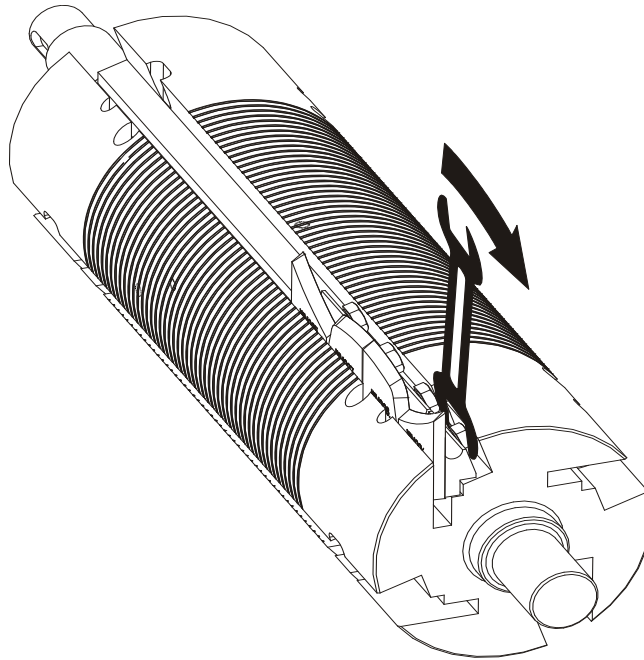
# 4

## Operation

### *Mounting the Moulding Knives*

4. Tighten the bolts of the clamping wedges. Be sure that the knives are touching each other.

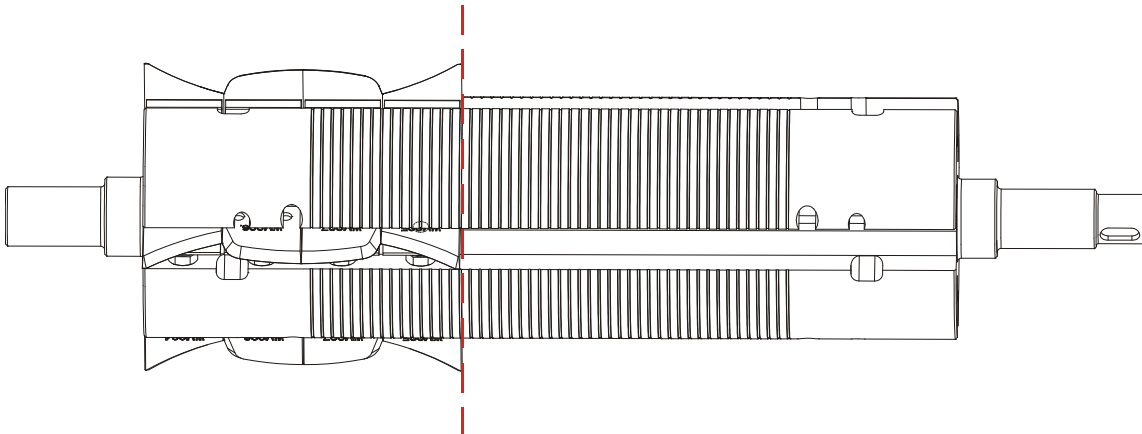
See Figure 4-13.






**FIG. 4-13**

5. Mount the three remaining sets of knives in the same way. Be sure that they are mounted exactly in the same position on the cutter - see the figure below.

See Figure 4-14.



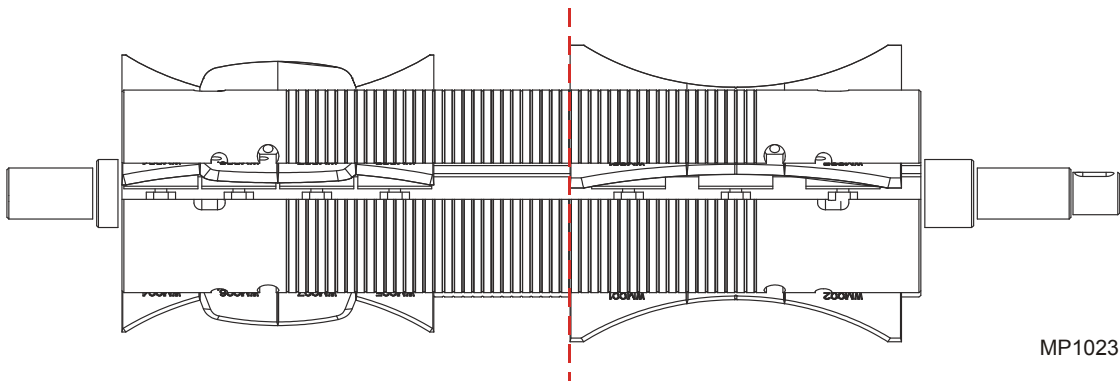
**FIG. 4-14**

-  **DANGER!** Make sure that all mounted knives are aligned identically. If they are not, it will cause vibrations of the cutter and may result in personal injury.
-  **DANGER!** Make sure that there are no tools left inside the cutter housing or on the frame.
-  **DANGER!** Make sure that all mounting strip bolts are securely tightened.

To remove the knives from the cutter, loosen the bolts of the clamping wedges. Carefully remove the knives.

It is also possible to mount the second set of knives on the cutter. Mount all four knives of this set in the same way as the previous set. Be sure that they are mounted exactly in the same position on the cutter - see the figure below.

See Figure 4-15.



MP1023

**FIG. 4-15**

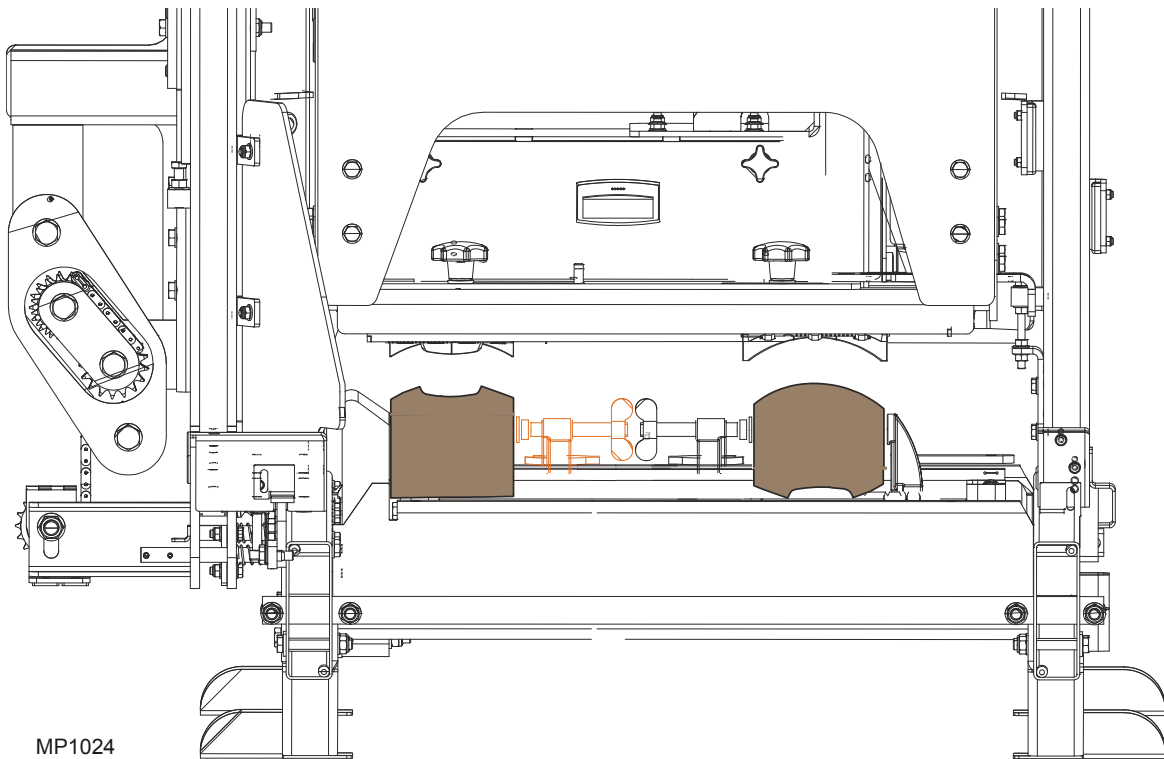
# 4

## Operation

### *Mounting the Moulding Knives*

Mounting two sets of knives with different profiles on the cutter is especially useful when the moulder/sawmill bed frame is equipped with additional clamp or clamps (see the figure below). Then it is possible to mould one side of the cant, rotate the cant by 180 degrees and place it in the optional clamps to mould the other side using the second set of knives.

**See Figure 4-16.**



**FIG. 4-16**



**DANGER!** Never try to plan/mould two cants at the same time!



## 4.4 Moulder Operation (MP100)

### Control Overview

See Figure 4-17. The controls of the moulder are shown below.

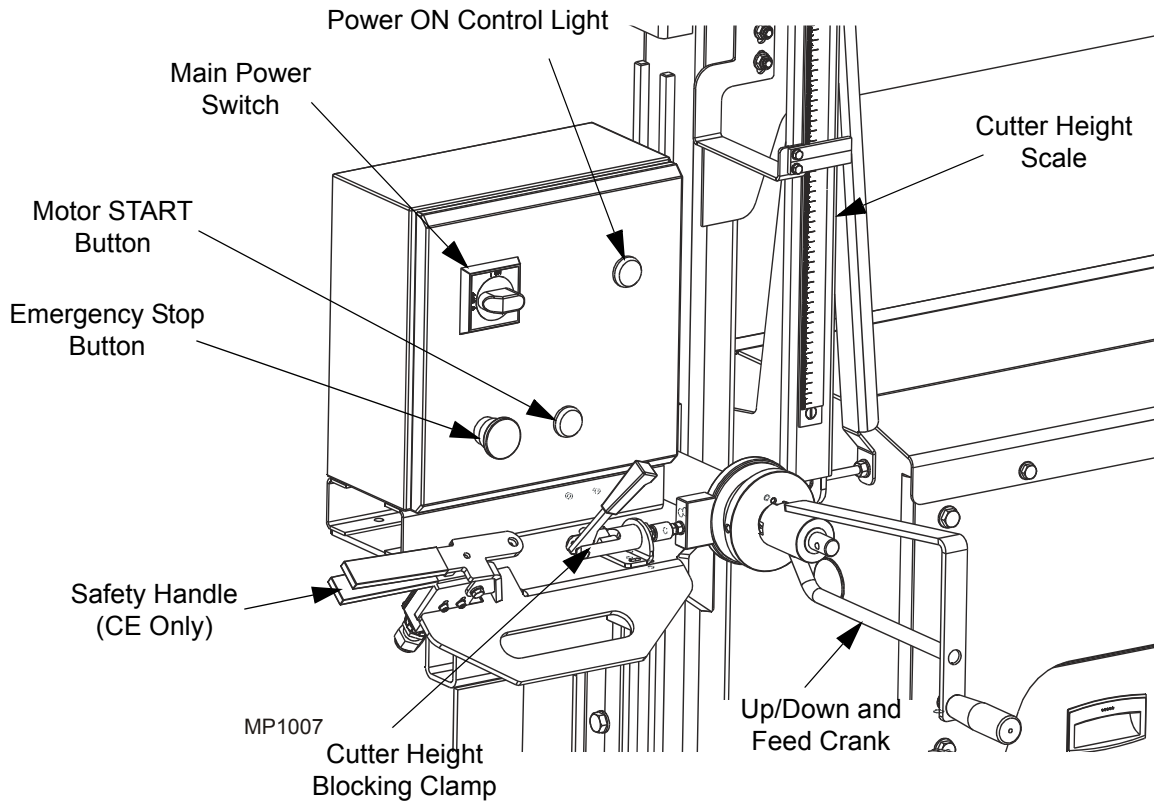


FIG. 4-17

#### 1. Safety Handle

Stops the cutter motor when released (CE version only).

#### 2. Motor START Button

Starts the cutter motor. The motor can be started only when the safety handle is being held.

#### 3. Main Disconnect Switch

Disconnects power from all electrical circuits of the machine.

**4. Power ON Control Light**

Indicates the power supply.

**5. Emergency Stop**

Push the emergency stop button to stop the cutter motor. Turn the emergency stop clockwise to release the stop. The machine will not restart until the emergency stop is released.

**6. Cutter Height Scale**

Indicates the cutter height.

**7. Cutter Height Locking Handle**

After setting the cutter height, secure the head in this position using the locking handle. **IMPORTANT!** Never start planing/moulding without locking the head.

**8. Up/Down and Feed Crank**

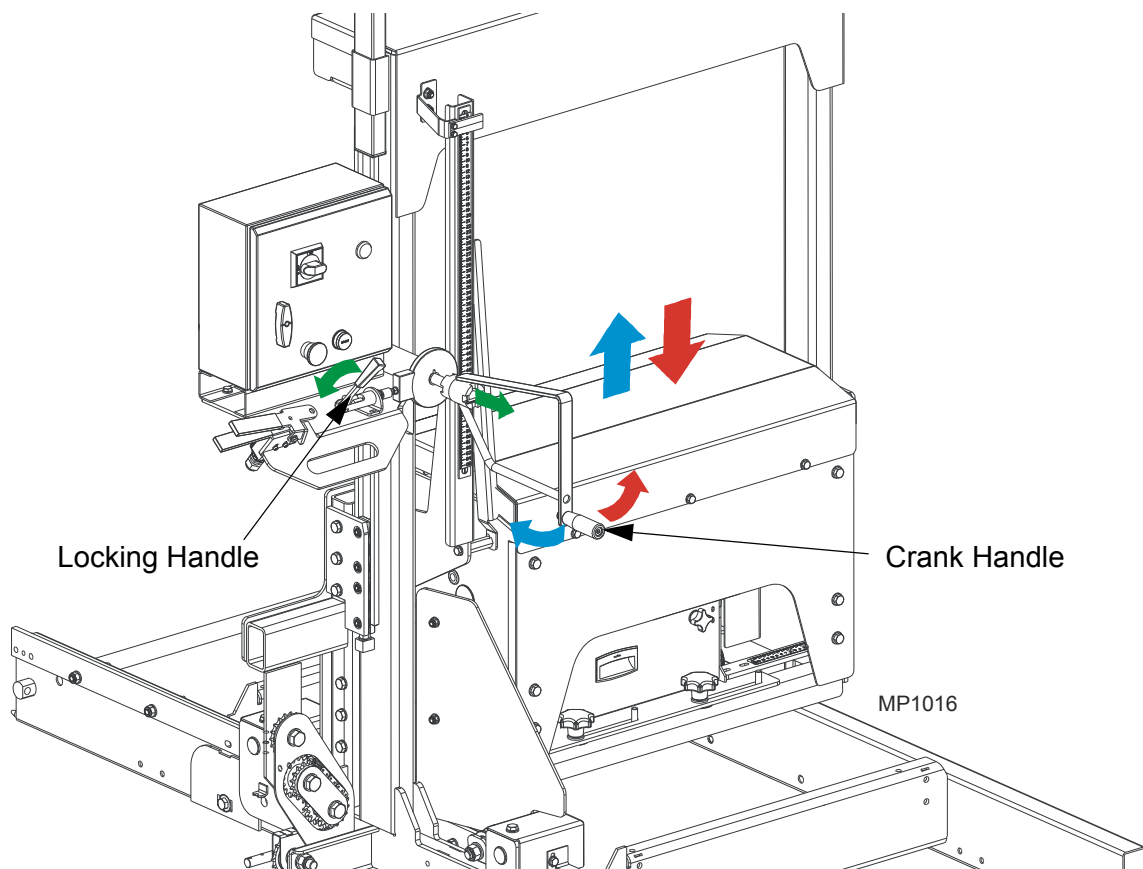
Allows forward/backward and up/down movement of the cutter head. **IMPORTANT!** Never push or pull the cutter head manually (without using the crank handle).

**Up/Down Operation**

Set the cutter head at the desired height. The height scale shows the height of the cutter with the knives above the bed rails. **IMPORTANT!** Remember that the maximum planing thickness can be 1/8" (4 mm).

1. Pull back the crank handle to engage the locking pins for up/down operation.
2. Loosen the locking handle.
3. Turn the crank handle clockwise to raise the head or counterclockwise to lower the head.
4. Secure the head in the desired position using the locking handle.

See Figure 4-18.



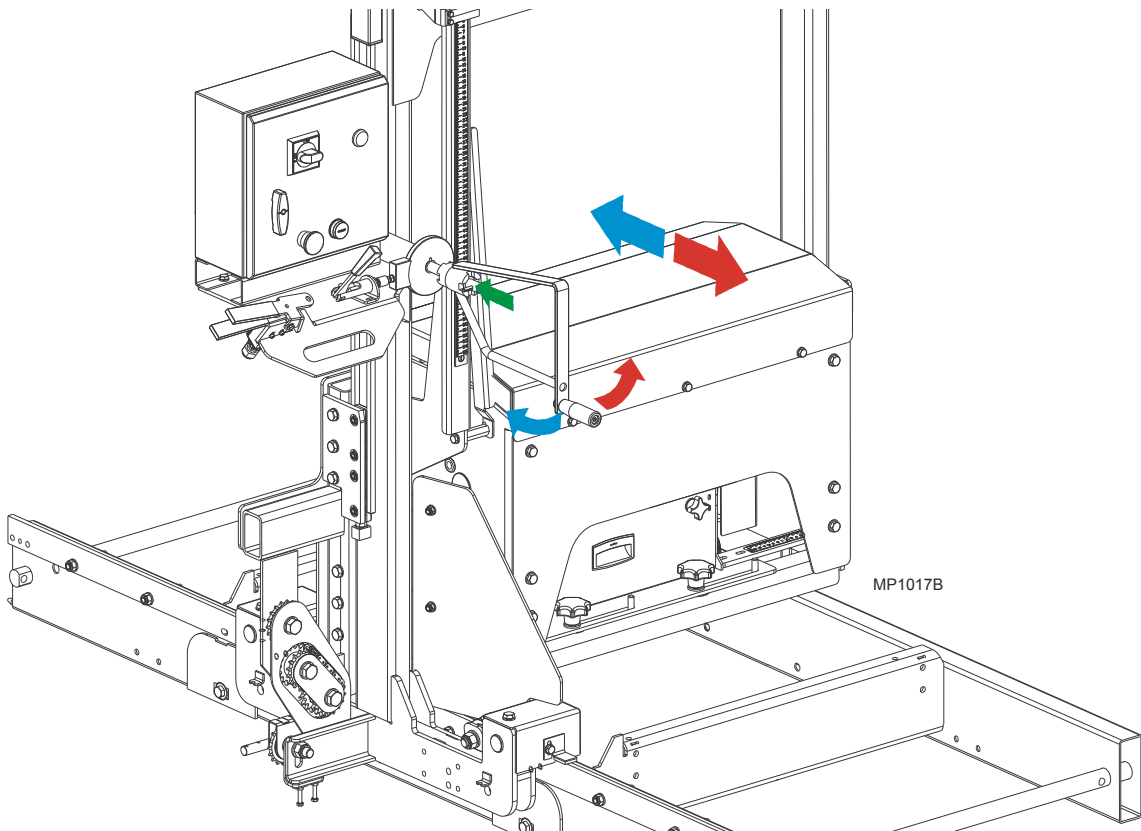
**FIG. 4-18**

**CAUTION! DO NOT** try to force the head above the 25 1/2" (645 mm) mark or below the 2 1/8" (55 mm) mark on the height scale. Damage to the up/down system may result.

**Feed Operation**

1. Push the crank handle to engage the locking pins for feed operation.
2. Turn the crank handle clockwise to move the head forward or counterclockwise to move the head backward.

See Figure 4-19.



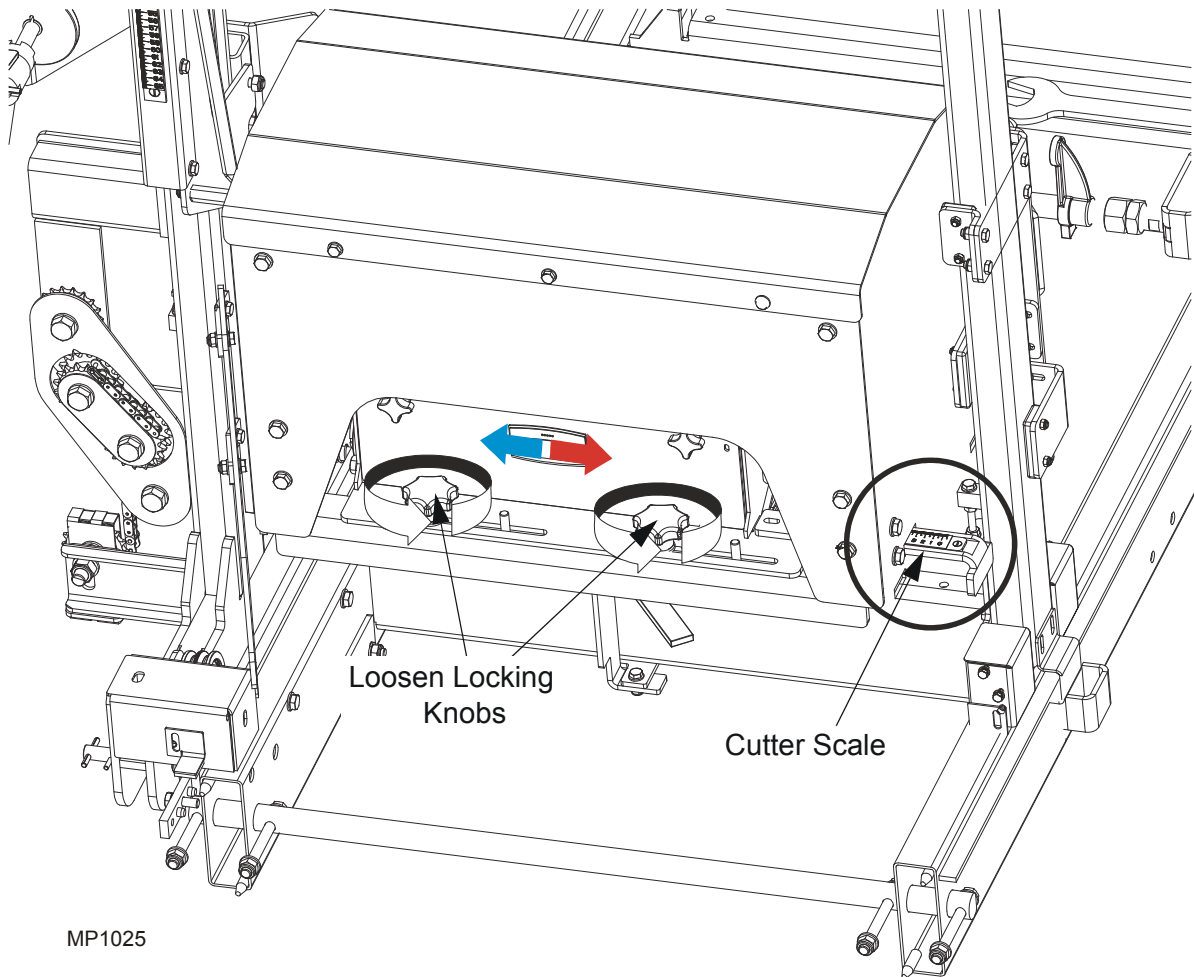
**FIG. 4-19**



**DANGER!** Always firmly hold the safety handle and the feed crank handle. Be aware that the moulding head can move towards you when you are working with hard wood or if the material is not secured properly. The planing head can be moved by using the crank handle only. Never push or pull the planing head manually.

3. It is possible to adjust the cutter right or left. The maximum adjustment available is 110mm. To slide the cutter, first loosen the locking knobs (4). Use the cutter scale to measure the distance from the initial position. (When the cutter is in the extreme left position, the cutter scale shows 0.) **IMPORTANT!** Always make sure that all locking knobs are firmly tightened before using the moulder.

See Figure 4-20.



MP1025

FIG. 4-20

**Factors that will determine what feed rate you can use include:**

- Cant dimensions
- Hardness of material to be planed/moulded. Some woods that are seasoned or naturally very hard will require slower feed rates.
- Sharpness of the knives. Dull or improperly sharpened knives will require slower feed rates than sharp and properly maintained knives.
- If you determine the pressure marks (small spots caused by wood debris around the edge of the knife) on the planed/moulded surface, it means that the feed rate is too high, the knives became dull or the dust extraction system is not sufficient.

## 4.5 Machine Start



**DANGER!** Before starting the machine, perform the following steps to avoid injury and/or damage to the equipment:

- Close or mount any covers removed for service.
- Check that the wood to be planed/moulded is properly secured.
- Make sure that all persons are at a safe distance from the machine.
- Turn on the dust extraction system.
- Check if the emergency stop button is released.

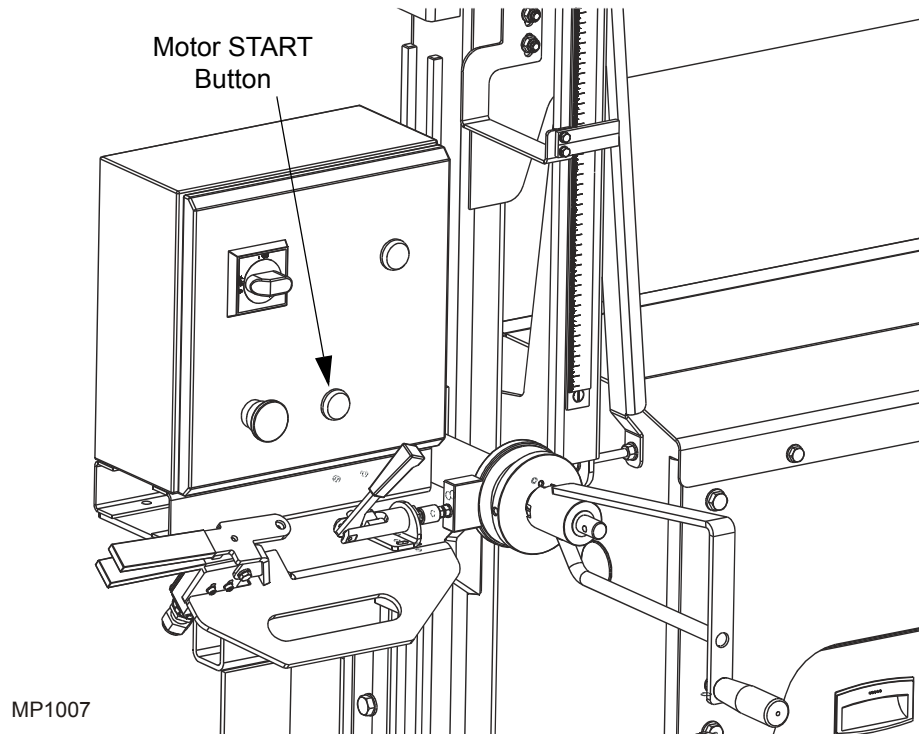
**NOTE:** The machine will not start if the emergency stop is on.

### **To start moulding/planing:**

1. Make sure that the head is secured at the desired height with the locking handle.
1. Turn the main switch on the electrical box to the ON position.
2. Press AND HOLD the safety handle. **NOTE:** If the safety handle is released, the cutter disengages and stops.

3. Press the green START button on the electric box to start the motor.

See Figure 4-21.



**FIG. 4-21**

## 4 Operation

### Track Roller Distance Adjustment

#### 4.6 Track Roller Distance Adjustment

Using the screw (1), adjust the distance between the track roller (2) and the track rail (3) so that the vertical mast can move freely (see the figure below). The distance should be about 1/4" (0.5 mm).

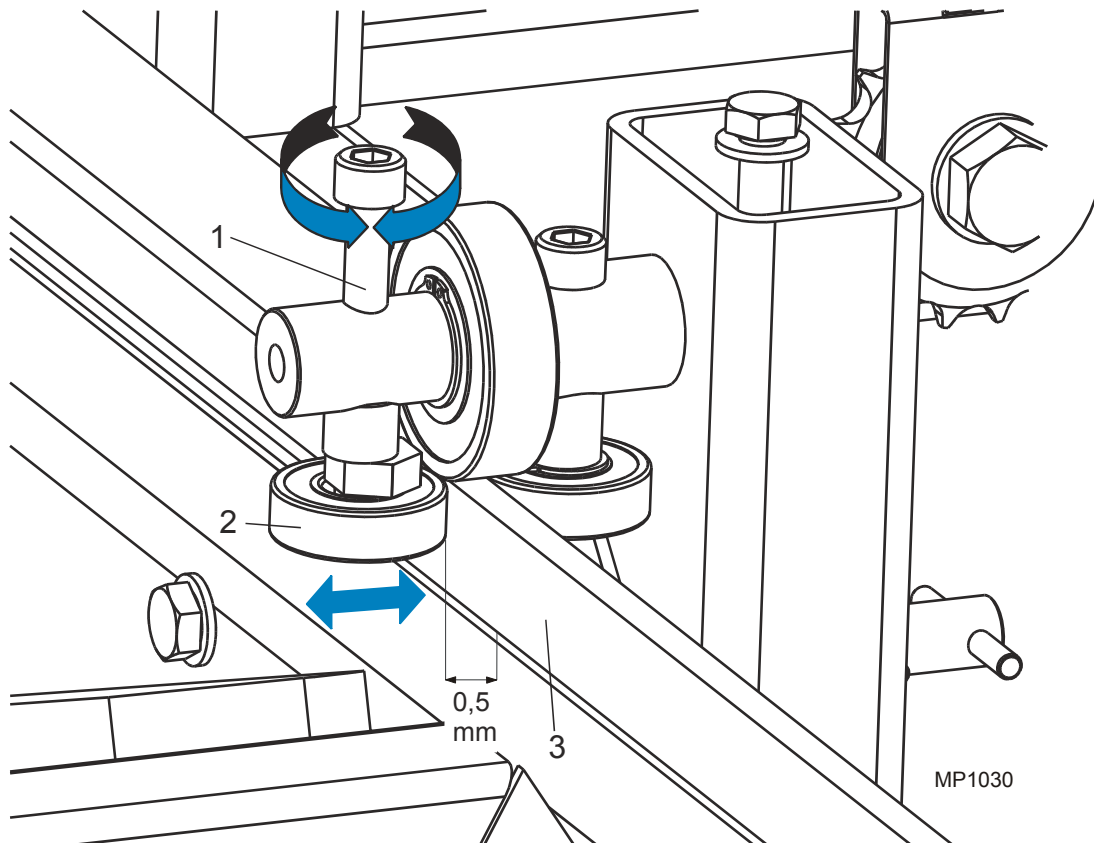


FIG. 4-22



## SECTION 5 MAINTENANCE

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



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

### 5.1 Wear Life

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

Part Description	Estimated Life
Drive Belt	1250 hours

*TABLE 5-1*

### 5.2 Sawdust Removal



Remove the excess sawdust and chips from the cutter housing using compressed air, and from the bed frame using a brush every eight hours of operation.

### 5.3 Head Track & Rollers

**See Figure 5-1.**



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

## 5 Maintenance

### Vertical Mast

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

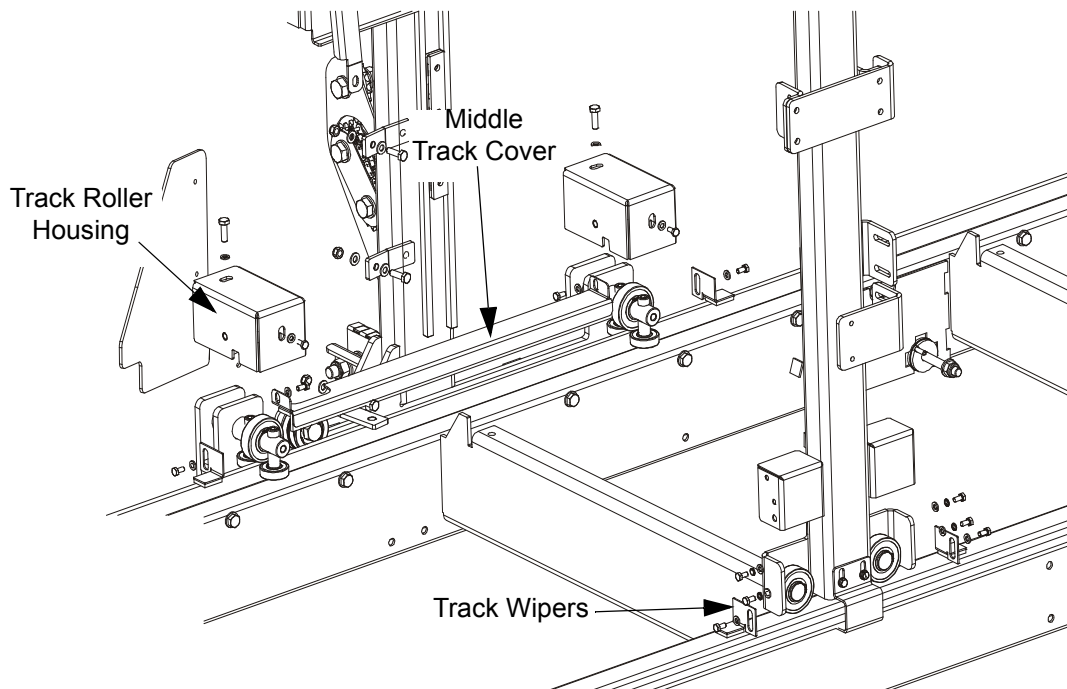


FIG. 5-1

### 5.4 Vertical Mast

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



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

### 5.5 Miscellaneous Lubrication

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



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

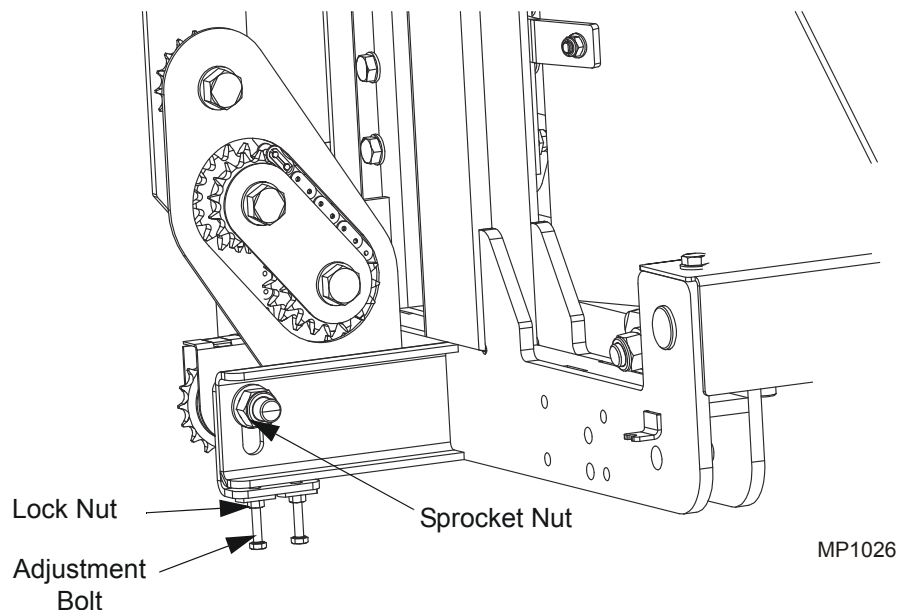
## 5.6 Manual Up/Down System

1. Adjust the up/down chain tension as needed. Measure the chain tension with the head all the way to the top of the vertical mast. Secure the head with a chain at the top, or shim it underneath. Find the chain adjusting bolts at the bottom of the mast. Loosen the sprocket nut on the bolt and lock nuts and using the adjustment bolts move the sprocket down until there is about 1" (2.5 cm) deflection in the center of the chain with a 5 lbs. (2,3 Kg) deflection force. The adjustment bolts must be adjusted evenly.



**WARNING!** Always secure the head with a chain or a brace before adjusting the up/down chain. The head may fall, causing severe injury or death.

See Figure 5-2.



**FIG. 5-2**

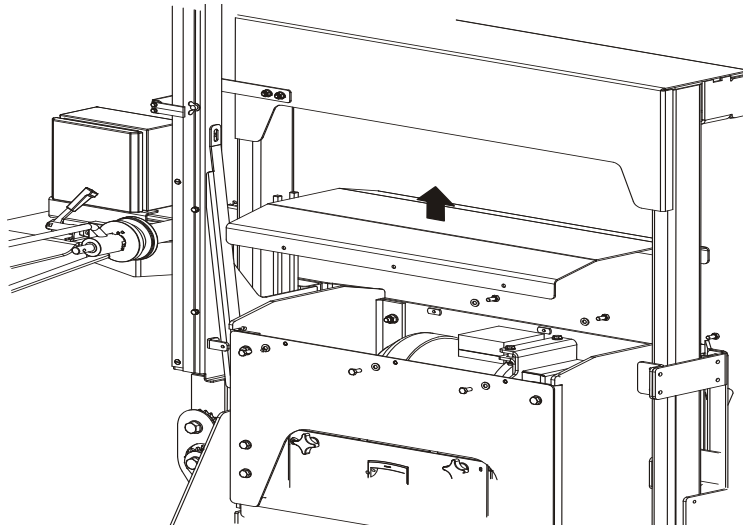
## 5.7 Drive Belt Tension Adjustment

Check the cutter drive belt tension after the first 20 hours, and every 50 hours thereafter.

50

1. Remove the cutter upper cover.

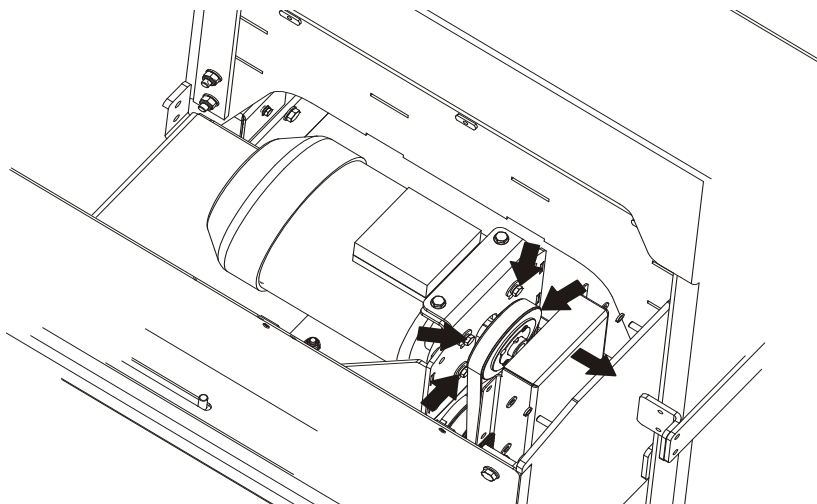
See Figure 5-3.



**FIG. 5-3**

2. Remove the belt cover and loosen four motor mounting bolts.

See Figure 5-4.



**FIG. 5-4**

3. Keep the pulleys aligned to avoid the premature belt and pulley wear.

See Figure 5-5.

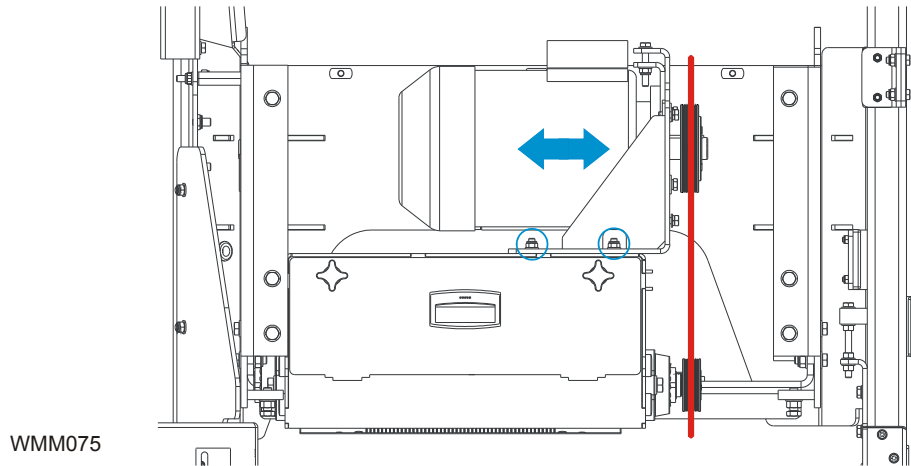


FIG. 5-5

4. Using the adjustment bolts, move the motor mounting plate up to tension the drive belt or move it down to loosen the belt. Next, tighten the mounting bolts. The belt is properly tensioned when 22 lbs. (10kg) of force deflects the belt by 3/8" (10mm).

See Figure 5-6.

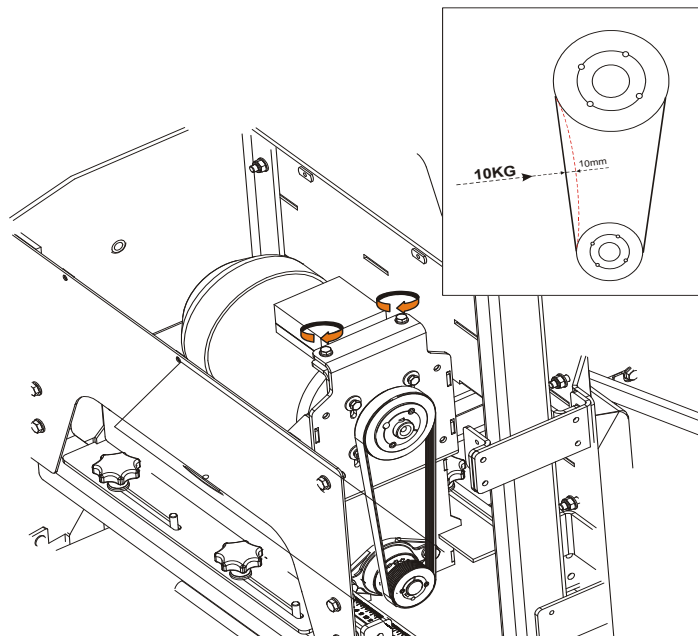


FIG. 5-6



**CAUTION!** After replacement of the motor drive belt, always adjust the belt tension as described above. Then turn on the motor for 5 minutes and check the belt tension again. If the belt deflection is greater than 3/8" (10 mm), adjust the belt tension again.

## 5.8 Cutter Bearings

When you discover cutter vibrations not caused by improper knife mounting, check the cutter bearings for wear. Replace if needed. The bearings do not require lubrication.

## 5.9 Long-Term Storage

If the machine is not used for a long period of time, do as follows:

- Disconnect the power cord.
- Perform all routine actions described above.
- Remove the knives with mounting strips or clamping wedges and store them well lubricated in above zero temperature.
- Loosen the motor belt tension.
- Spray a thin layer of anti-rust coating (such as P.D.R.P) onto the places not protected against rusting.
- Store the machine in a well ventilated room.

## 5.10 Safety Devices Inspection

### MP100E5S Moulder – Safety Devices Inspection

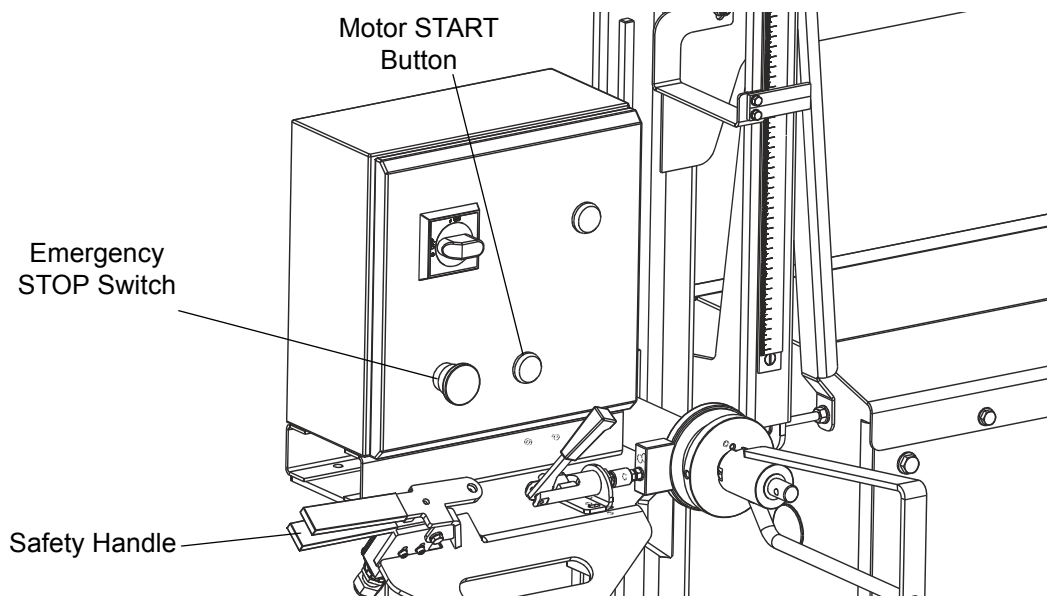
Safety devices on the machine which must be checked before every shift:

- E-STOP button and its circuit inspection (CE version only)
- Safety handle and its circuit inspection (CE version only)
- Cutter cover safety switch and its circuit inspection.

#### 1. E-STOP button and its circuit inspection (CE version only)

- Press and hold the safety handle;
- The START button should illuminate green;
- Press the START button to start the motor. The motor should start.
- Press the E-STOP button located on the control box. The motor should be stopped. Pressing the START button should not start the motor until the E-STOP button is released and the START button is pressed.

See Figure 5-7.



**FIG. 5-7**

**2. Safety handle and its circuit inspection (CE version only)**

- Be sure the E-STOP button is released;
- Press and hold the safety handle;
- The START button should illuminate green;
- Press the START button to start the motor. The motor should start.
- Release the safety handle. The motor should be stopped.
- Press the START button. The motor should remain stopped.
- Press and hold the safety handle. The START button should illuminate green, but the motor should remain stopped.

**3. Cutter cover safety switch and its circuit inspection**

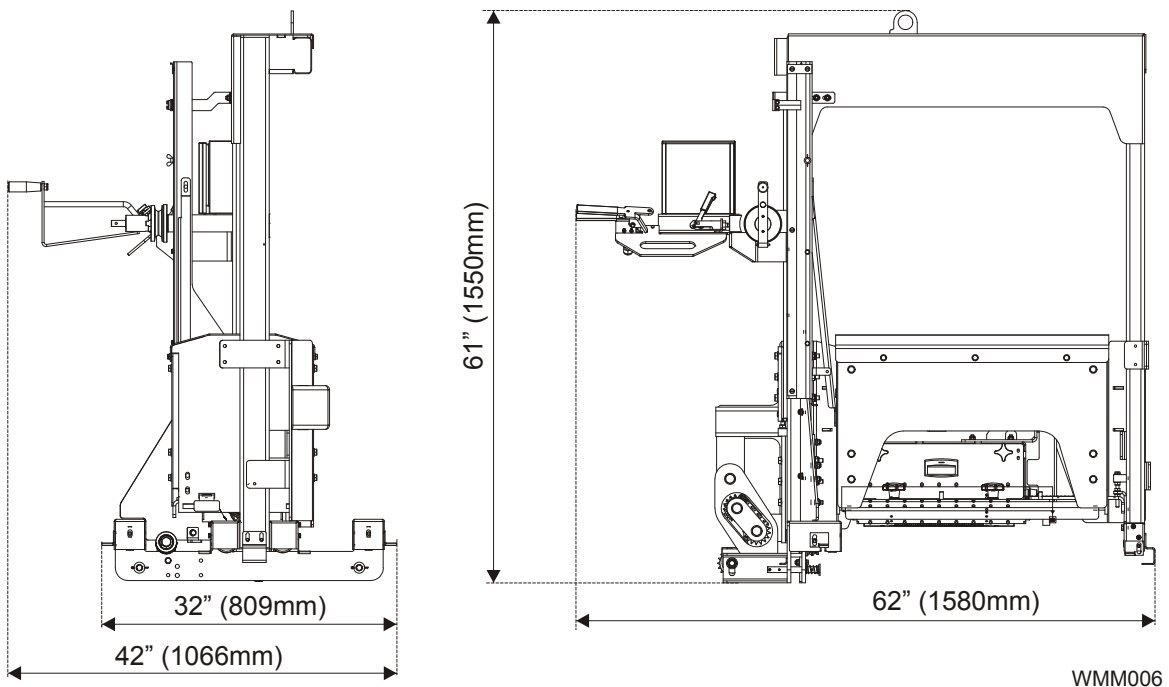
- Be sure the E-STOP button is released;
- Press and hold the safety handle (CE version only);
- Turn on the motor;
- Open the cutter housing cover;
- The motor should be stopped;
- Try to start the motor. The motor should remain stopped;
- Close the cutter housing cover;
- The motor should remain stopped until it is restarted with the START button.



## SECTION 6 SPECIFICATIONS

### 6.1 Overall Dimensions

See Figure 6-1. The major dimensions of the moulder are shown below.



**FIG. 6-1**

See Table 6-1. The moulder mast with head dimensions and weight are listed below.

Moulder Type	MP100
Weight	772 lbs. (350 kg)
Height	61" (1550 mm)
Width	62" (1580 mm)
Length	42" (1066 mm)

**TABLE 6-1**

## 6.2 Moulder Specifications

See Table 6-2. See the table below for the Wood-Mizer moulder motor specifications.

	MP100EC5-1 3-Phase Motor Specifications	MP100EH5-1 3-Phase Motor Specifications	MP100EA5-1 1-Phase Motor Specifications
<b>Motor Type</b>	E5 Electric Motor	E5 Electric Motor	E7.5 Electric Motor
<b>Manufacturer</b>	Siemens	Siemens	Leeson
<b>Voltage</b>	480V 60Hz	400V 60Hz	230V 60Hz
<b>Maximum Current</b>	7.9 A	---	36 A
<b>Motor RPM</b>	3480 RPM	---	3600 RPM
<b>Rated Output</b>	6 HP (4.4 kW)	---	7.5 HP (5.6 kW)
<b>Manufacturer Part #</b>	1LA9106-2LA92-Z L2T+D31	---	C213K34FK1B
<b>WM Part #</b>	500627-UL	---	053790

TABLE 6-2

See Table 6-3. The noise level of the moulder is given below.<sup>1 2</sup>

Moulder Motor Type	Noise Level
E5 Electric Motor	98 dB (A)

TABLE 6-3

**IMPORTANT!** The MP100EC5-1 is wired for use with a 480 volt power supply and the MP100EH5-1 is wired for use with a 400 volt power supply. To operate the MP100 with other power supplies an additional transformer is required. See the table below for transformers available from Wood-Mizer.

See Table 6-4.

Model	Conversion from 240 to 400 or 480 volts	Conversion from 400 to 480 volts	Conversion from 480 to 400 volts	Conversion from 600 to 400 or 480 volts
MP100EC5-1	078208	078209	X	078210
MP100EH5-1	X	X	X	X

TABLE 6-4

<sup>1</sup> 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.

<sup>2</sup> The measured values refer to emission levels, not necessarily to noise levels in the workplace. Although there is a relation between emission levels 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 machines and machining operations nearby. Also, the permissible exposure level value may vary depending on country. This information enables the machine's user to better identify hazards and a risk.

**See Table 6-5.** See the table below for planing/moulding material specifications.

<b>Minimum Cant Height</b>	2 1/2" (60 mm)
<b>Maximum Cant Height</b>	23 1/2" (600 mm)
<b>Maximum Cant Width <sup>1</sup></b>	20 1/2" (520 mm)

**TABLE 6-5**

<sup>1</sup> Using horizontal adjustment

**See Table 6-6.** Other specifications of the moulder are listed below.

<b>Cutter Specifications</b>	
<b>Number of Knife Sockets</b>	4
<b>Cutter Diameter</b>	122 mm
<b>Cutter Width</b>	410 mm
<b>Cutter Horizontal Adjustment</b>	110 mm
<b>Cutter Rotations</b>	4890 RPM
<b>Knife Specifications</b>	
<b>Straight Knife Height "A"</b>	27-35 mm
<b>Straight Knife Thickness "B"</b>	2-3 mm
<b>Straight Knife Protrusion "C"</b>	1.1 mm
<b>Pattern Knife Thickness "B"</b>	3-5 mm
<b>Pattern Knife Max Protrusion "C"</b>	Depends on the knife thickness (See Table 6-6)

**TABLE 6-6**

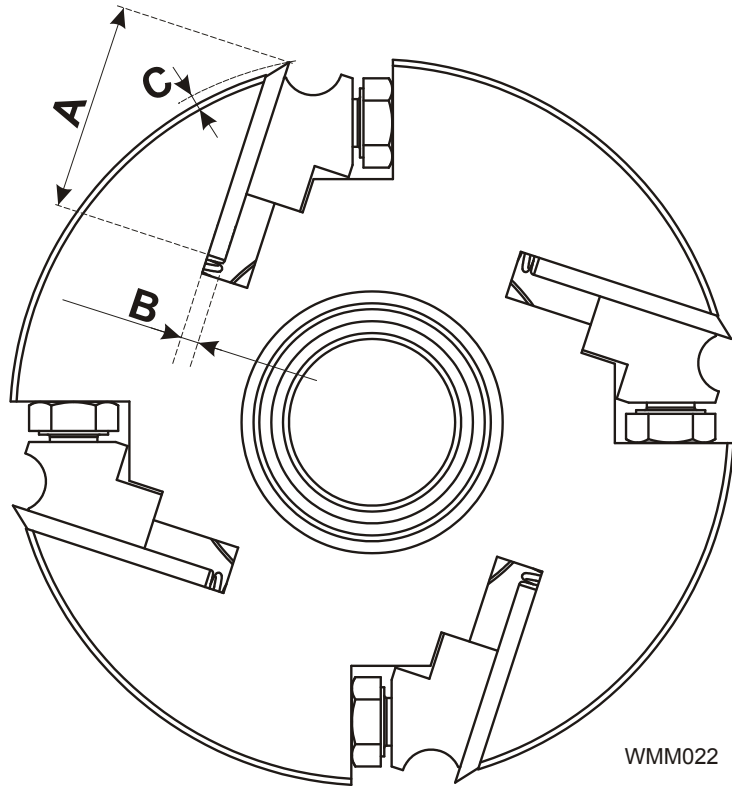
**See Table 6-7.** A relation between the pattern knife protrusion and the thickness is shown below.

<b>Pattern Knife Thickness</b>	<b>Pattern Knife Max. Protrusion <sup>1</sup></b>
<b>3 mm</b>	13 mm
<b>4 mm</b>	21 mm
<b>5 mm</b>	29 mm

**TABLE 6-7**

<sup>1</sup> According to EN 847-1:2005 European Standard

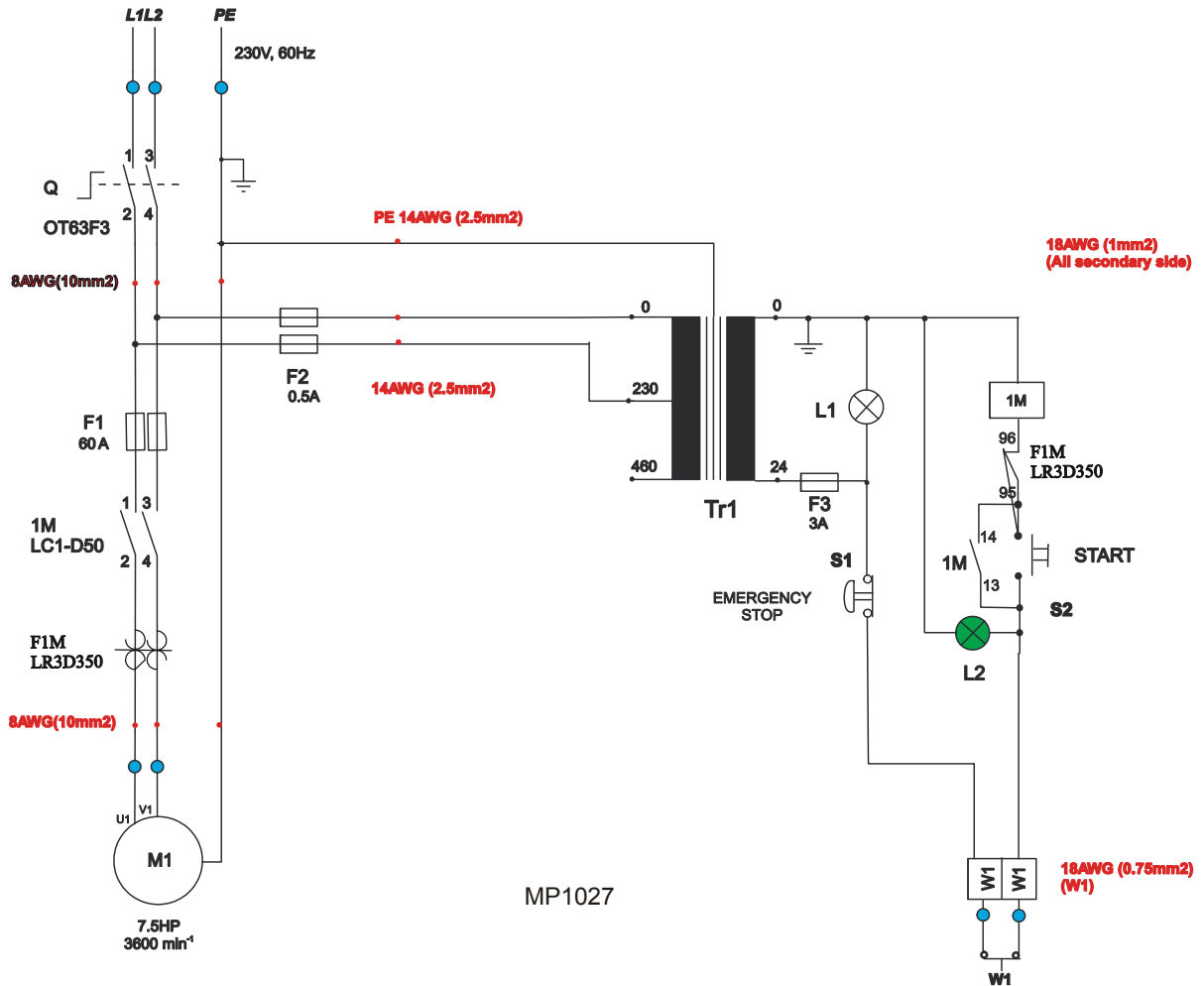
See Figure 6-2.



**FIG. 6-2**

### 6.3 Electrical Diagram

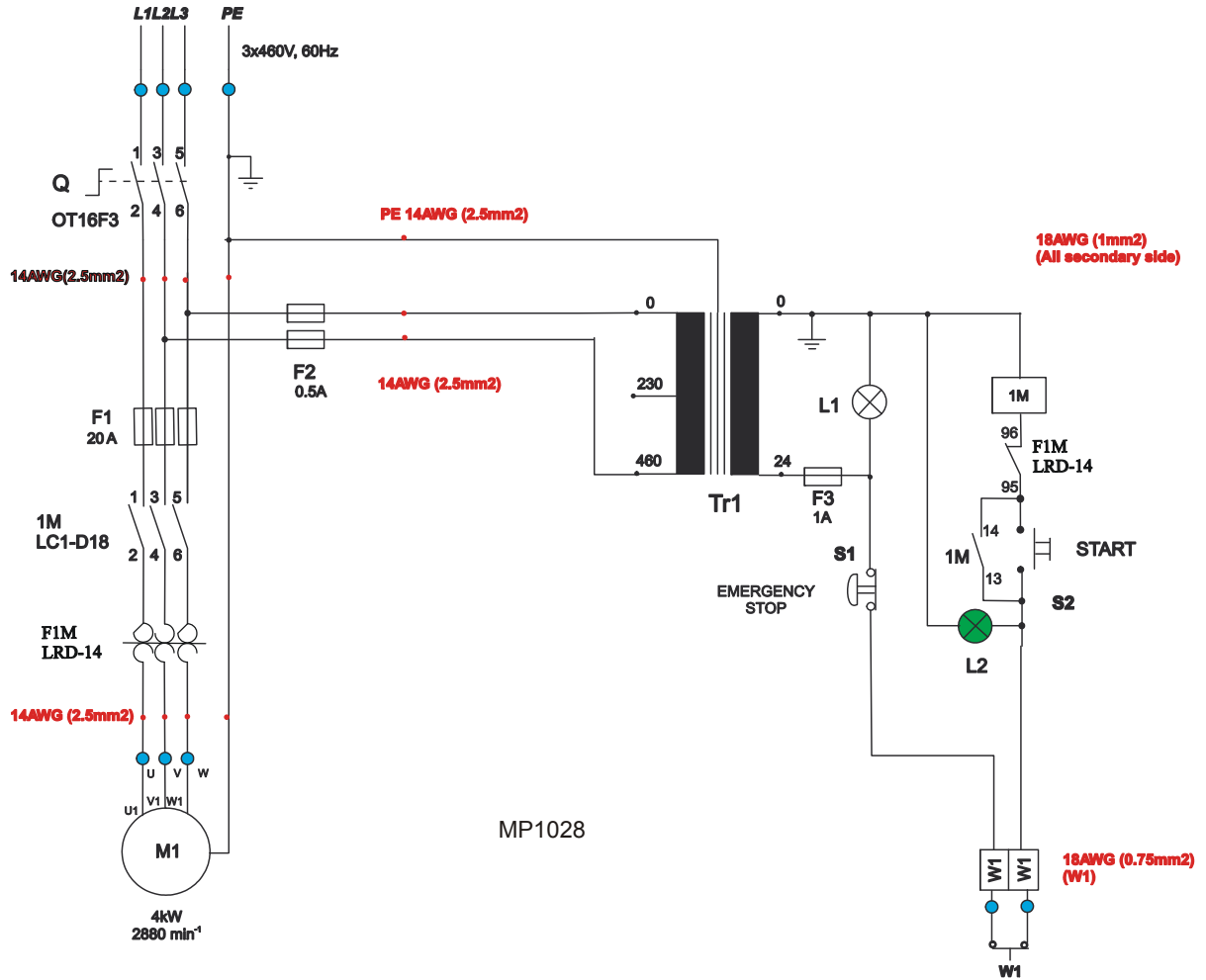
MP100EA5-1, 230V



# 6 Specifications

## Electrical Diagram

### MP100EC5-1, 460V



## 6.4 Electrical Component List

### *MP100EA5-1, 230V*

Component	Manufacturer Part No.	Manufacturer	Wood-Mizer Part No.	Description
<b>1M</b>	LC1-D50AB7	Schneider Electric	502686	Contactora
<b>F1</b>	TCF60RN	Bussmann	052711	Fuse, 60A
	TCFH60N	Bussmann	053717	Fuse Holder
<b>F2</b>	KLDR.500	---	E31338	Fuse, 0.5A
	LPSC002ID	---	052512	Fuse Holder
<b>F3</b>	---	Schneider Electric	504386	Fuse, 3A
<b>F1M</b>	LR3D350	Schneider Electric	502687	Relay, Thermal
<b>L1</b>	---	Moeller	090448	Light, LED White Control
<b>M1</b>	C213K34FK1B	Leeson	053790	Motor, 7.5 HP Leeson
<b>Q</b>	ABB OT63E3	ABB	503466	Switch, Main
<b>S1</b>	XB7 ES542	Schneider Electric	502315	Stop, Emergency
<b>S2, L2</b>	---	Moeller	094315	Button, Start + Green Control Light
<b>TR1</b>	SU78A-230400460/ 24	Noratel	094487	Transformer
<b>W1</b>	AZ17-11ZRK	Schmersal	094232	Switch, Safety

### *MP100EC5-1, 460V*

Component	Manufacturer Part No.	Manufacturer	Wood-Mizer Part No.	Description
<b>1M</b>	LC1-D18	Schneider Electric	084306	Contactora
<b>F1</b>	CCMR020	---	052691	Fuse, 20A
	LPSC003ID	---	052380	Fuse Holder
<b>F2</b>	KLDR.500	---	E31338	Fuse, 0.5A
	LPSC002ID	---	052512	Fuse Holder
<b>F3</b>	---	Schneider Electric	084454	Fuse, 1A
<b>F1M</b>	LRD-14	Schneider Electric	092480	Relay, Thermal
<b>L1</b>	---	Moeller	090448	Light, White Control
<b>M1</b>	1LA910602LA12-Z	Siemens	500627-UL	Motor, 6HP Siemens (No Brake)
<b>Q</b>	ABB OT16F3	ABB	503541	Switch, Main
<b>S1</b>	XB7 ES542	Schneider Electric	502315	Stop, Emergency
<b>S2, L2</b>	---	Moeller	094315	Button, Start + Green Control Light
<b>TR1</b>	SU78A-230400460/ 24	Noratel	094487-UL	Transformer
<b>W1</b>	AZ17-11ZRK	Schmersal	094232	Switch, Safety

## 6.5 Sawdust Extractor Specifications

See Table 6-8. See the table below for specifications of a dust extractor for the moulder.

<b>Airflow</b>	88 gal./second (1200 m <sup>3</sup> /h)
<b>Inlet Diameter</b>	4" (100 mm)
<b>Motor Power</b>	1.5 kW
<b>Number of Sacks</b>	2
<b>Sack Capacity</b>	66 gal. (0.25 m <sup>3</sup> )
<b>Weight</b>	240 lbs. (110 kg)
<b>Recommended conveying air velocity in the duct</b>	66 ft./second (20 m/s)

**TABLE 6-8**



## SECTION 7 PARTS

### 7.1 How To Use The Parts List

- Use the table of contents or index to locate the assembly that contains the part you need.
- Go to the appropriate section and locate the part in the illustration.
- Use the number pointing to the part to locate the correct part number and description in the table.
- Parts shown indented under another part are included with that part.
- Parts marked with a diamond (◆) are only available in the assembly listed above the part.

See the sample table below. Sample Part #A01111 includes part F02222-2 and subassembly A03333. Subassembly A03333 includes part S04444-4 and subassembly K05555. The diamond (◆) indicates that S04444-4 is not available except in subassembly A03333. Subassembly K05555 includes parts M06666 and F07777-77. The diamond (◆) indicates M06666 is not available except in subassembly K05555.

<b>7.2 Sample Assembly</b>				
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	SAMPLE ASSEMBLY, COMPLETE (INCLUDES ALL INDENTED PARTS BELOW)	A01111	1	
1	Sample Part	F02222-22	1	
	Sample Subassembly (Includes All Indented Parts Below)	A03333	1	
2	Sample Part (◆ Indicates Part Is Only Available With A03333)	S04444-4	1	◆
	Sample Subassembly (Includes All Indented Parts Below)	K05555	1	
3	Sample Part (◆ Indicates Part Is Only Available With K05555)	M06666	2	◆
4	Sample Part	F07777-77	1	

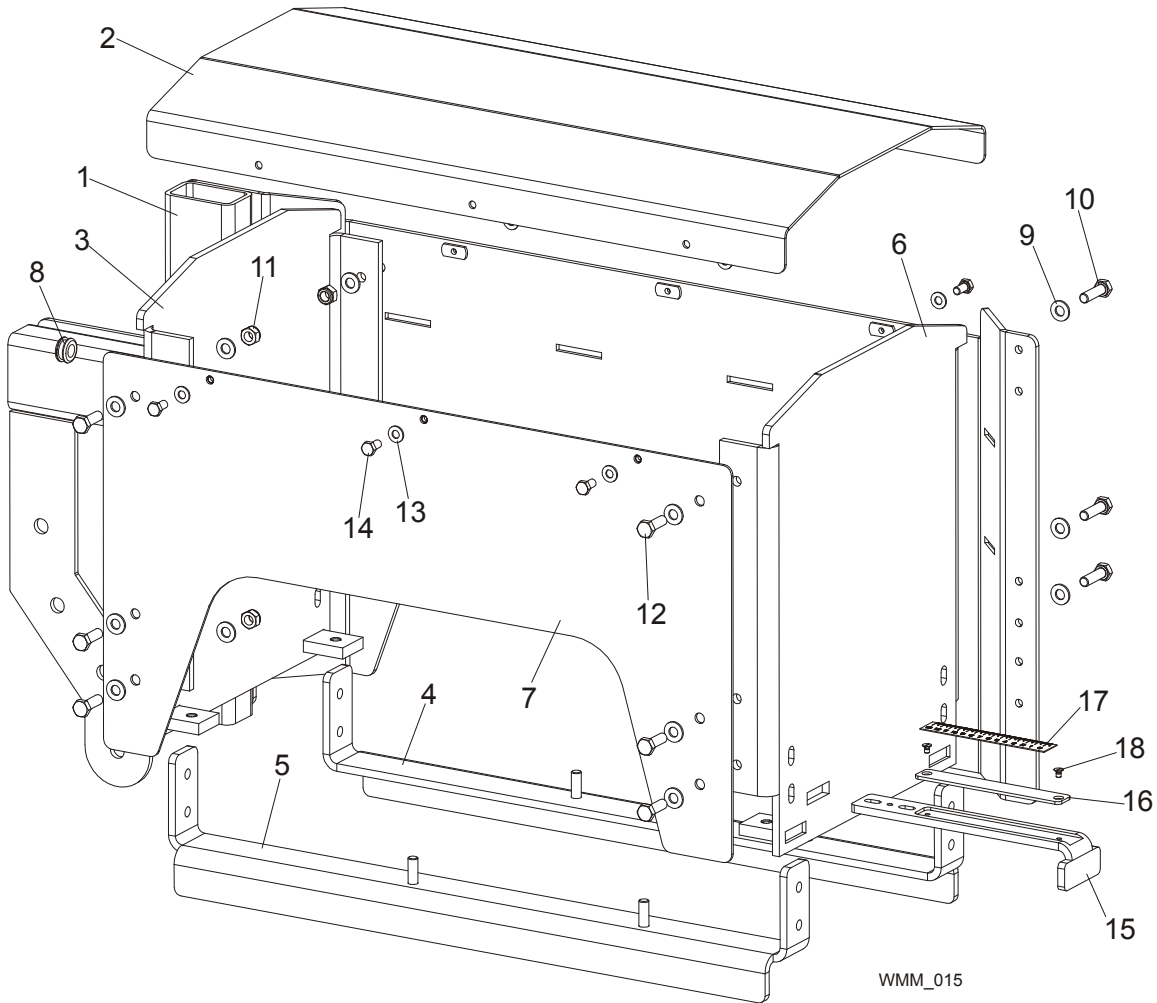
#### To Order Parts:

- From the continental U.S., call **1-800-525-8100** to order parts. Have your customer number, vehicle identification number, and part numbers ready when you call.
- From other international locations, contact the Wood-Mizer distributor in your area for parts.

# 7 Parts

## Moulder Head Housing

### 7.3 Moulder Head Housing



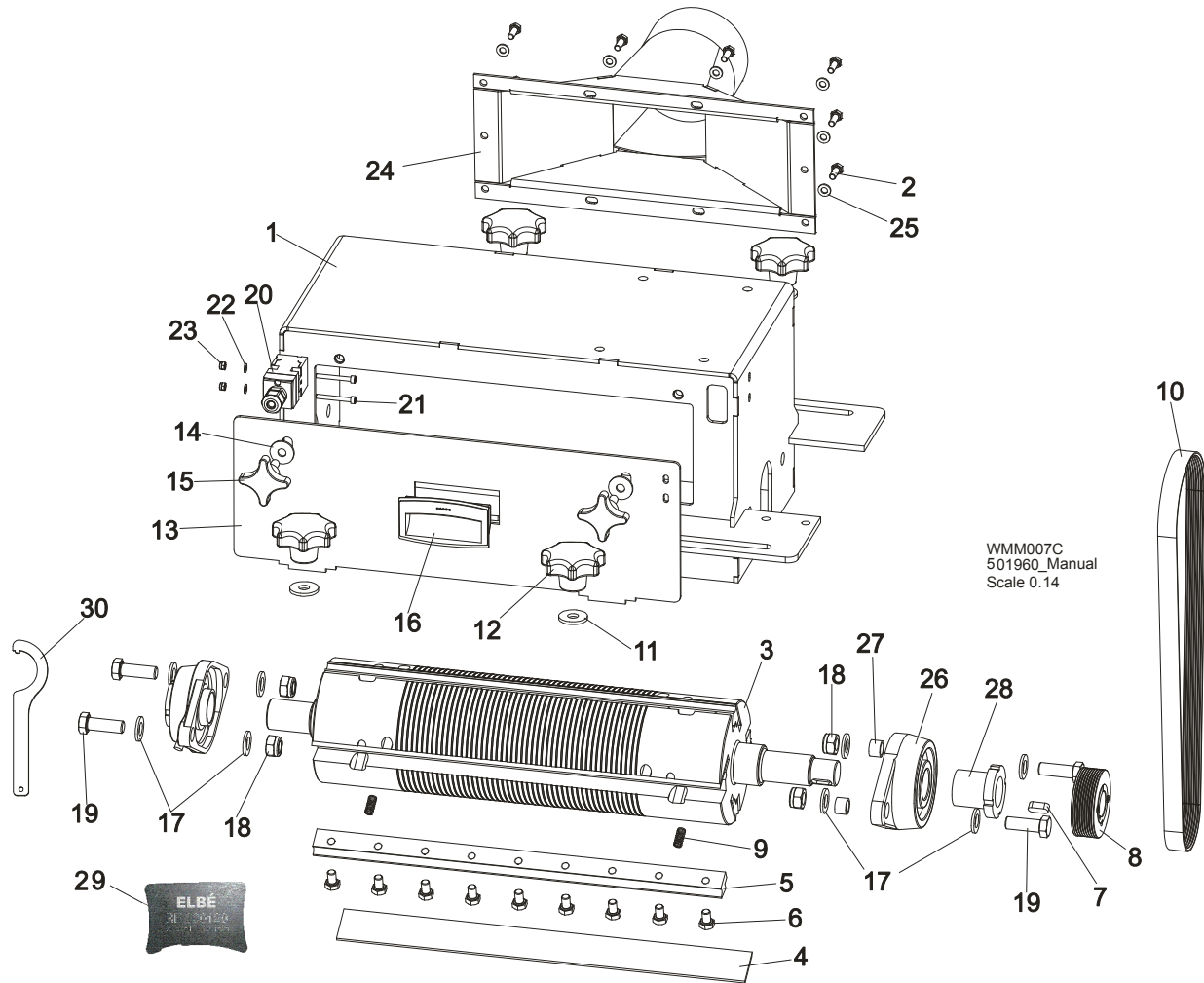
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>HOUSING, MOULDER HEAD COMPLETE</b>	501880	1
1	Cutter Height Assembly	501897-1	1
2	Cover, Moulder Housing Upper	501882-1	1
3	Cover, Moulder Housing Left	501895-1	1
4	Bracket, Moulder Angle Right	501951-1	1
5	Bracket, Moulder Angle Left	501952-1	1
6	Cover, Moulder Housing Right	501896-1	1
7	Cover, Moulder Housing Rear	501905-1	1
8	Grommet, 20/13 Rubber	086188	1
9	Washer, 10.5 Flat Zinc	F81055-1	24
10	Bolt, M10x35-8.8 Hex Head Full Thread Zinc	F81003-17	6
11	Nut, M10-8-b Hex Nylon Zinc Lock	F81033-1	12
12	Bolt, M10x30-5.8 Hex Head Full Thread Zinc	F81003-2	6

<b>13</b>	Washer, 8.4 Flat Zinc	F81054-1	6	
<b>14</b>	Bolt, M8x16 -8.8-b-fe/zn5 Pn-85/m-82105	F81002-20	6	
	Scale, Cutter Shaft Complete	502352	1	
<b>15</b>	Strand, Cutter	501949-1	1	
	Scale, Metric Horizontal Complete	501203	1	
<b>16</b>	Bar, Scale Complete	501205	1	
<b>17</b>	Decal, 0-20 Metric Scale Complete	501206	1	
<b>18</b>	Decal, Inch Scale Complete	505886	1	
<b>19</b>	Screw, M5x8-5.8-b Zinc	F81001-00	2	

# 7 Parts

## Moulder Cutter

### 7.4 Moulder Cutter



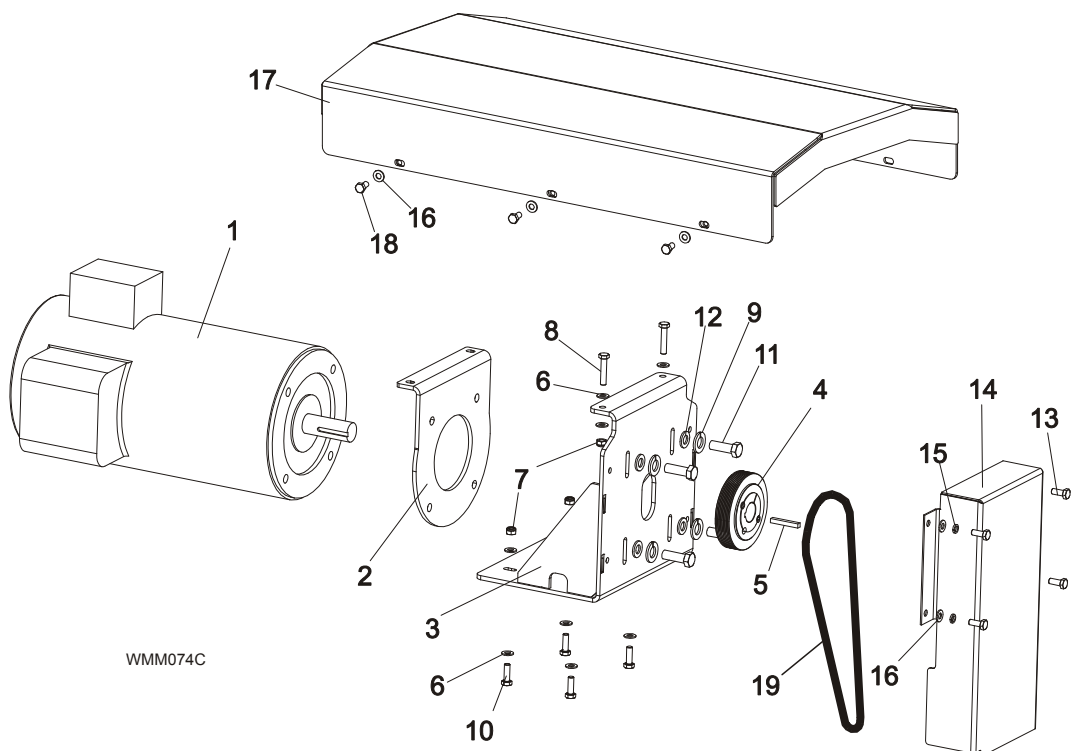
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CUTTER, MOULDER COMPLETE</b>	501960	1
1	Housing, Moulder Cutter	501890-1	1
2	Bolt, M6 X 16 8.8 FE/ZN5 PN-M/82105	F81001-15	10
	Shaft, Cutter Complete	500949	1
3	Shaft, Cutter Zinc	500950-1	1
4	Knife, Hss 410x35x3 Straight	501199	4
	Clamp, Cutter Complete	500951	4
5	Clamp, Cutter Zinc	500952-1	1
6	Bolt, M8x10mm Hex Head Full Thread	F81002-47 <sup>1</sup>	9
7	Key, A8x7x20 Parallel	099059	1
8	Pulley, PYB 67X8J Taper Split	500922	1
9	Spring, 18x6x1	501200	8
10	Belt, 8PJ955 (CE and U.S. 3-Phase Motor Only)	501185	1
11	Washer, 10.5 Zinc Flat Special	F81055-6	4
12	Knob, SR1580-63-M10-3 (462081-MOSS)	501189	4

13	Plate, Cutter	501904-1	1	
14	Washer, 8.5 Zinc Flat Special	F81054-11	2	
15	Knob, SR50/M8X25 (466406 Moss)	500973	2	
16	Handle, EPR.90-PF-C1(261051-C1)	100012	1	
17	Washer, 13 Flat Zinc	F81056-1	8	
18	Nut, M12-8 Hex Nylon Zinc Lock	F81034-2	4	
19	Bolt, M12 X 35-8.8-FE/ZN5 Hex Head Full	F81004-24	4	
20	Switch, AZ17-11ZRK Safety	094232	1	
21	Screw, M4x35-8.8 Hex Socket Head Cap Zinc	F81011-34	2	
22	Washer 4,3 FE/ZN5 PN-M/82005	F81051-2	2	
23	Nut M4-B FE/ZN5 PN-M/82175	F81029-1	2	
24	Plate, Moulder Housing	501994-1	1	
25	Washer, 6.4 Flat Zinc	F81053-1	10	
	Housing, Bearing+ Bushings FYTJ 507 (SKF)	513046	2	
26	Housing, Bearing FYTJ 35K SKF	513045	1	
27	Bushing R14 11.9x16.8x11 Ecomid 6" SKF	513047	2	
28	Sleeve Adapter H 2307 SKF	513386	1	
29	<b>ALIGNMENT TOOL SET, ELBE RF100120</b>	502848	1	
30	<b>WRENCH, BEARING NUT, DIAMETER 53MM</b>	502443	1	

<sup>1</sup> Replaced F81002-6 M8x12mm Hex Head Full Thread Gr8.8 Bolts to improve knives replacement (Rev. A1.01; 8/10).

**7** **Parts**  
*Motor Assembly, US Version Components (1-Phase 230V)*

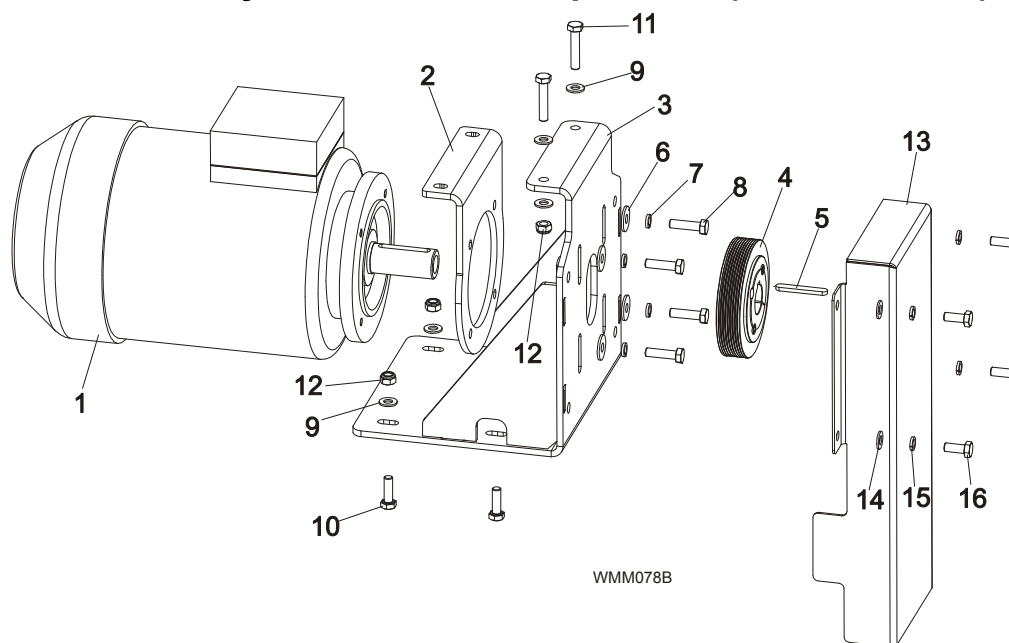
**7.5 Motor Assembly, US Version Components (1-Phase 230V)**



WMM074C

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOTOR, 1-PHASE W/HOLDER COMPLETE</b>	500954-UL	1
1	Motor, 7.5HP 1Ph 230V 60Hz 3600RPM	053790	1
2	Bracket, Motor Mount Ver. UL	503755-1	1
3	Bracket, Motor Mount Ver. ULL	503753-1	1
4	Pulley, PYB112X8J 1 1/8" Taper Split	503752	1
5	Key 6.35 X 6.36 X 40	092601	1
6	Washer, 8.4 Flat Zinc	F81054-1	12
7	Nut, M8-8-b Hex Nylon Zinc Lock	F81032-2	4
8	Bolt, M8x40-8.8-b Hex Head Full Thread Zinc	F81002-15	2
9	Washer, 16.3 Split Lock Zinc	F81058-2	4
10	Bolt, M8x25-8.8-b Hex Head Full Thread Zinc	F81002-5	4
11	Bolt, 1/2-13 x 1 1/2" Hex Head Grade 5	F05008-33	4
12	Washer, M12 Flat Zinc	F81056-1	4
13	<b>BOLT, M8X20MM, HEX HEAD GR 5.8 ZINC</b>	F81002-4	4
14	<b>COVER, BELT DRIVE - UL</b>	503756-1	1
15	<b>WASHER 8,2 ZINC</b>	F81054-4	4
16	<b>WASHER, 8.4 FLAT ZINC</b>	F81054-1	5
17	<b>COVER, MOULDER HOUSING UPPER</b>	505603-1	1
18	<b>BOLT, M8x16 -8.8-B-Fe/Zn5 PN-85/M-82105</b>	F81002-20	6
19	<b>BELT, PJ920/360J</b>	505615	1

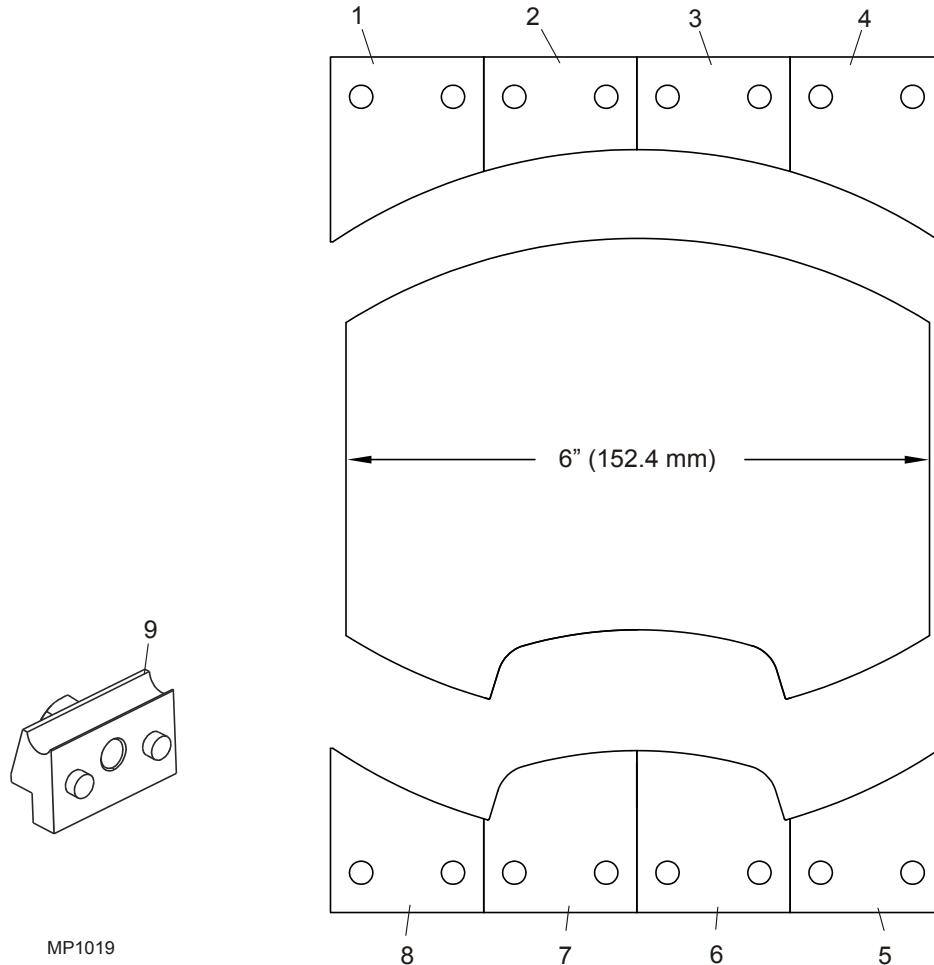
### 7.6 Motor Assembly, US Version Components (3-Phase 460V)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MOTOR MOUNT, COMPLETE</b>	500954-4	1
1	Motor, 5HP 1LA9106-2LA92-Z L2T+D31 3-Phase	500627-UL	1
2	Bracker, Motor Ptd	500955-1	1
3	Bracker, Motor Ptd	500956-1	1
4	Pulley PYB112 X 8J Taper Split	500923	1
5	Key 6.35 X 6.36 X 40	092601	1
6	Washer, 8.5 Zinc Flat Special	F81054-11	4
7	Washer, 8.2 Flat	F81054-4	4
8	Bolt M8x30-8.8	F81002-7	4
9	Washer, 8.4 Flat	F81054-1	12
10	Bolt, M8x25-8.8-B Hex Head Full Thre	F81002-5	4
11	Bolt, 8mm x 1.25 x 40mm HH Zinc	F81002-15	2
12	Nut, M8-8-b, Hex Nylon Lock Zinc	F81032-2	6
13	<b>COVER, BELT DRIVE - UL</b>	503756-1	1
14	<b>WASHER, 8.4 FLAT, ZINC</b>	F81054-1	4
15	<b>WASHER 8.2 ZINC</b>	F81054-4	4
16	<b>BOLT, M8 X 20MM, HEX HEAD GR 5.8 ZINC</b>	F81002-4	4

## 7.7 Moulding Profiles & Knife Sets

### Swedish Cope Profile



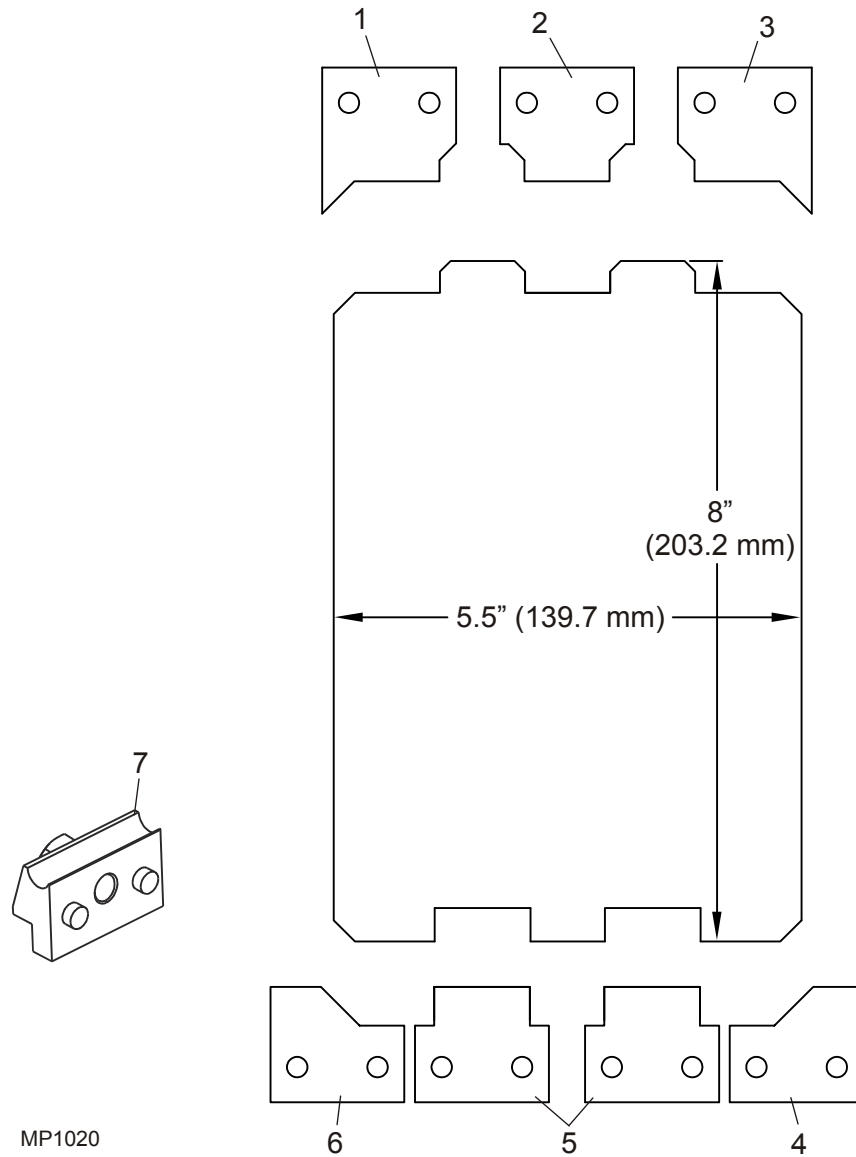
MP1019

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MP100 PROFILE SWEDISH COPE SET</b>	061050	1
1	Moulding Knife, MP100 (Pair)	061042	1
2	Moulding Knife, MP100 (Pair)	061043	1
3	Moulding Knife, MP100 (Pair)	061044	1
4	Moulding Knife, MP100 (Pair)	061045	1
5	Moulding Knife, MP100 (Pair)	061046	1
6	Moulding Knife, MP100 (Pair)	061047	1
7	Moulding Knife, MP100 (Pair)	061048	1
8	Moulding Knife, MP100 (Pair)	061049	1
9	<b>CLAMPING WEDGE, COMPLETE</b>	501175 <sup>1</sup>	8
	Bolt, M8x10mm Hex Head FT, Crowned Head	F81002-47	8

<sup>1</sup> Clamping wedges are reusable parts. It is recommended to order 16 clamping wedges for all profiles with the initial purchase.



**Profile #1 T&G**



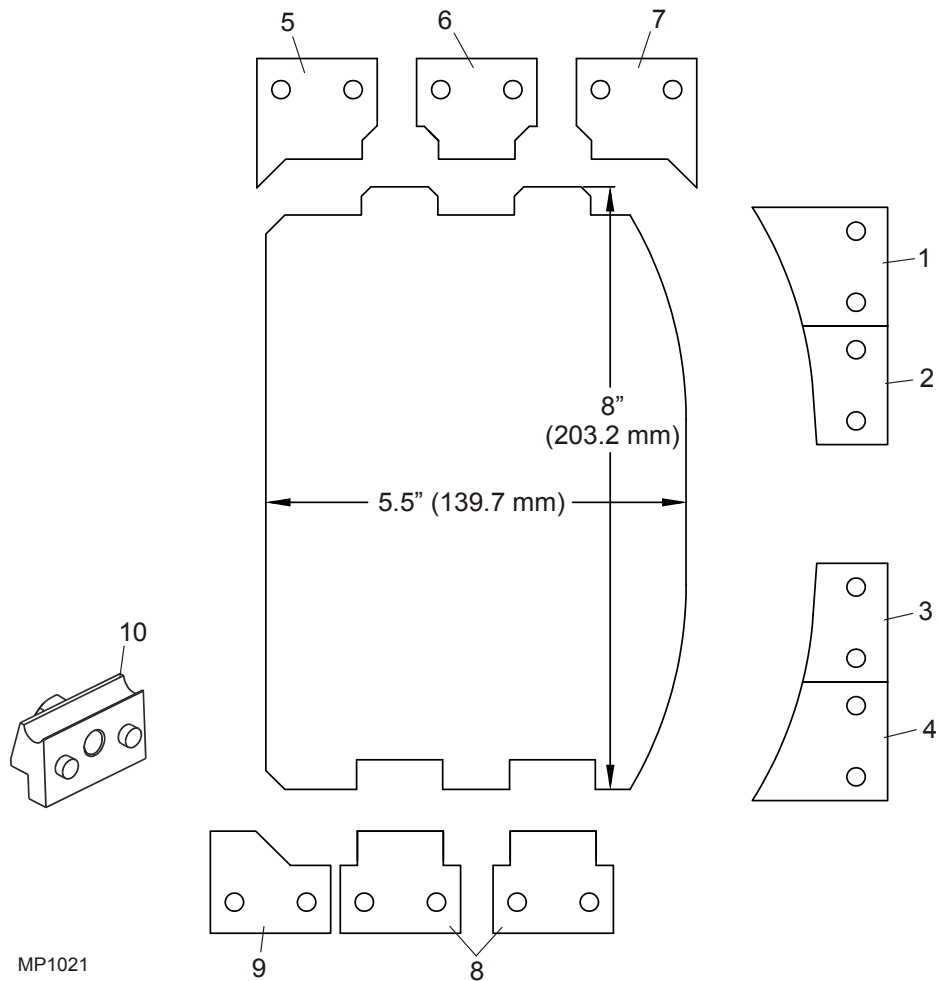
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MP100 KNIVES PROFILE #1 T&amp;G SET</b>	061035	1
1	Moulding Knife, MP100 (Pair)	061031	1
2	Moulding Knife, MP100 (Pair)	061030	1
3	Moulding Knife, MP100 (Pair)	061029	1
4	Moulding Knife, MP100 (Pair)	061032	1
5	Moulding Knife, MP100 (Pair)	061033	2
6	Moulding Knife, MP100 (Pair)	061034	1
7	<b>CLAMPING WEDGE, COMPLETE</b>	501175 <sup>1</sup>	14
	Bolt, M8x10mm Hex Head FT, Crowned Head	F81002-47	8

<sup>1</sup> Clamping wedges are reusable parts. It is recommended to order 16 clamping wedges for all profiles with the initial purchase.

# 7 Parts

## Moulding Profiles & Knife Sets

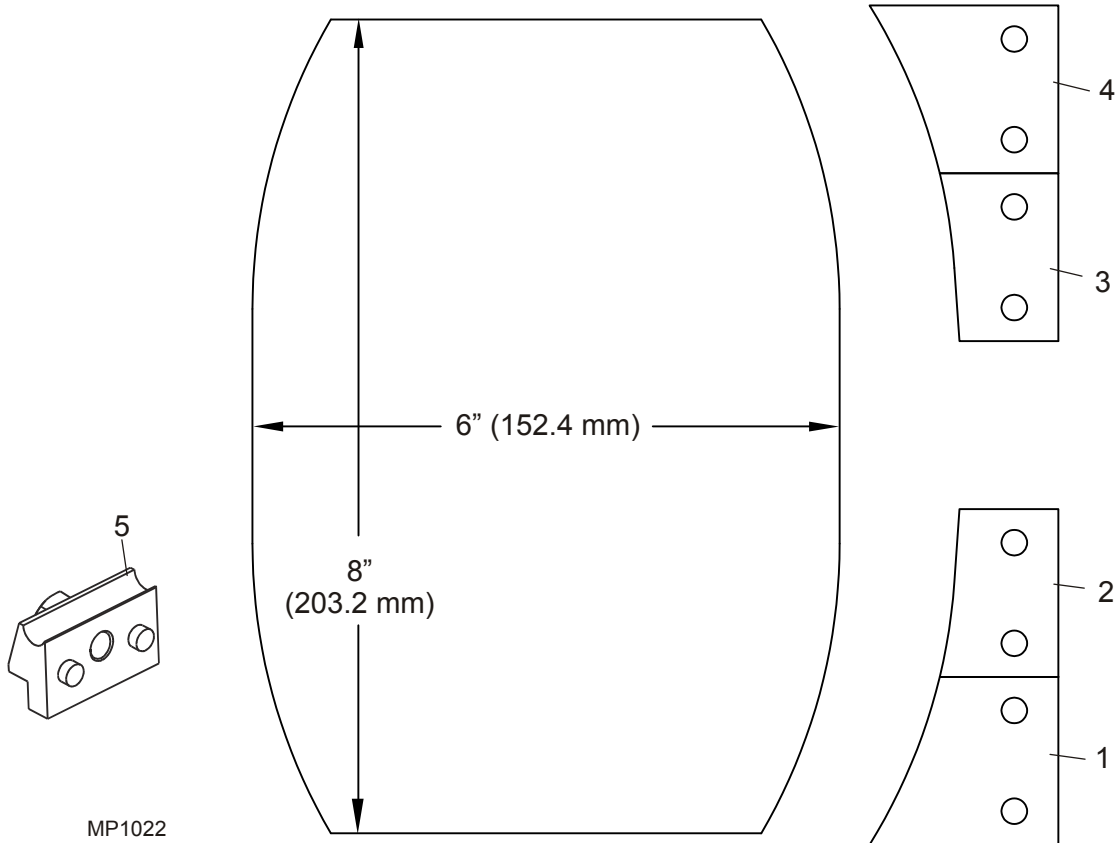
### Profile #2 D-Face (Requires Profile #1 T&G Knife Set)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MP100 PROFILE #2 D-FACE KNIFE SET</b>	061041	1
1	Moulding Knife, MP100 (Pair)	061040	1
2	Moulding Knife, MP100 (Pair)	061039	1
3	Moulding Knife, MP100 (Pair)	061038	1
4	Moulding Knife, MP100 (Pair)	061037	1
	<b>MP100 KNIVES PROFILE #1 T&amp;G SET</b>	061035	1
5	Moulding Knife, MP100 (Pair)	061031	1
6	Moulding Knife, MP100 (Pair)	061030	1
7	Moulding Knife, MP100 (Pair)	061029	1
	Moulding Knife, MP100 (Pair - Not Used for Profile #2)	061032	1
8	Moulding Knife, MP100 (Pair)	061033	2
9	Moulding Knife, MP100 (Pair)	061034	1
10	<b>CLAMPING WEDGE, COMPLETE</b>	501175 <sup>1</sup>	14
	Bolt, M8x10mm Hex Head FT, Crowned Head	F81002-47	8

<sup>1</sup> Clamping wedges are reusable parts. It is recommended to order 16 clamping wedges for all profiles with the initial purchase.

**Double Round Profile**



MP1022

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>MP100 PROFILE #2 D-FACE KNIFE SET</b>	061041	1
1	Moulding Knife, MP100 (Pair)	061040	1
2	Moulding Knife, MP100 (Pair)	061039	1
3	Moulding Knife, MP100 (Pair)	061038	1
4	Moulding Knife, MP100 (Pair)	061037	1
5	<b>CLAMPING WEDGE, COMPLETE</b>	501175 <sup>1</sup>	8
	Bolt, M8x10mm Hex Head FT, Crowned Head	F81002-47	8

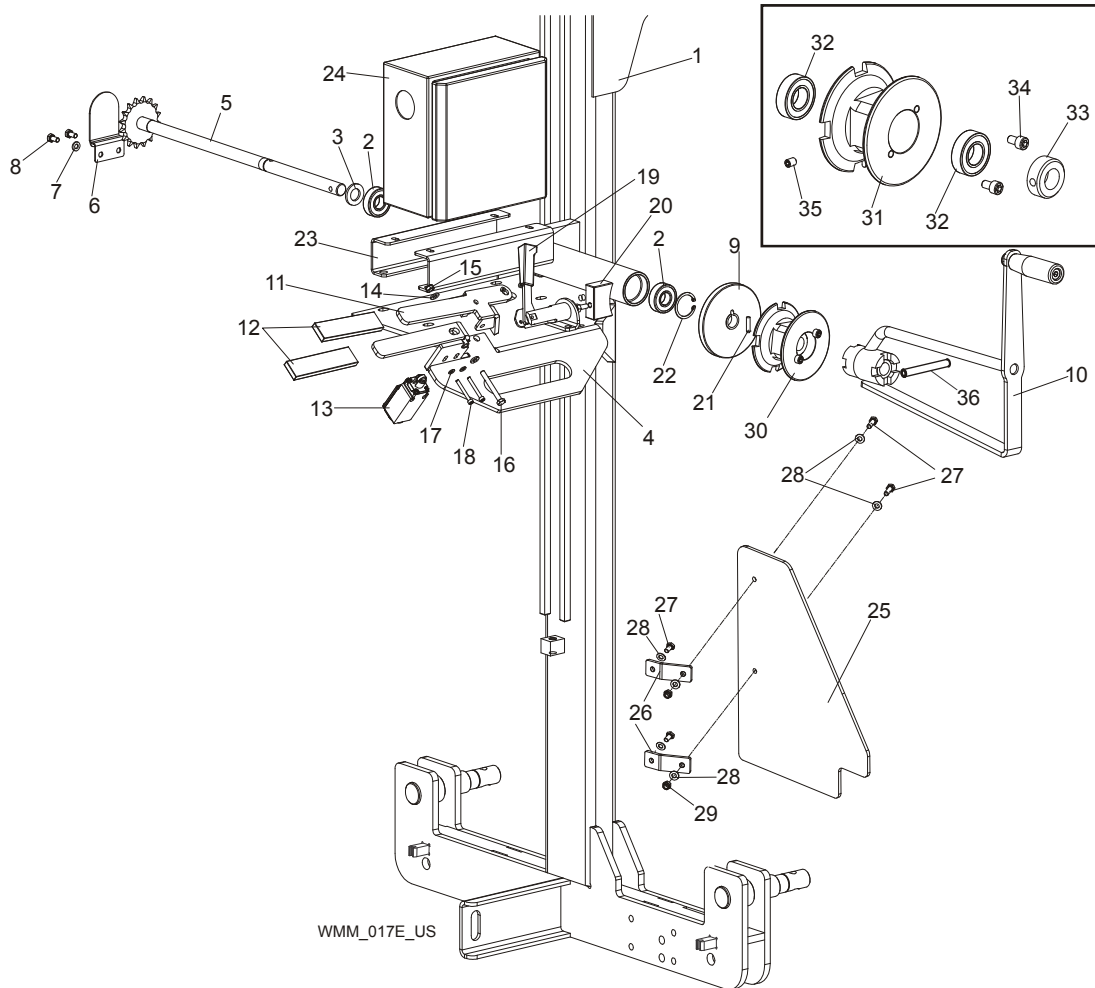
<sup>1</sup> Clamping wedges are reusable parts. It is recommended to order 16 clamping wedges for all profiles with the initial purchase.

# 7

## Parts

### Up/Down Crank Assembly, Electrical Box

## 7.8 Up/Down Crank Assembly, Electrical Box



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>MAST, MOULDER</b>	501947-1	1	
1	Mast, Moulder Metric	501946	1	◆
2	Bearing, 6203-2rs	086114	2	
3	Washer, 17 Flat Zinc	F81058-1	1	
4	Bracket, Electrical Box	501961	1	
5	Shaft W/sprocket Lt10	501996	1	
6	<b>GUARD, UPPER LT10 SAW HEAD SPROCKET</b>	092567-1	1	
7	<b>WASHER, 6.4 FLAT ZINC</b>	F81053-1	2	
8	<b>BOLT, M6X12-8.8 HEX HEAD FULL THREAD ZINC</b>	F81001-7	2	
9	<b>WHEEL, MOLUDER DRIVE BLOCK</b>	501957-1	1	
10	<b>FEED CRANK ASSEMBLY</b>	508239 <sup>1</sup>	1	
	Crank, Weldment LT15, Ptd	508238-1	1	
	Knob, Plastic Crank Handle	086338	1	

	Bushing, GFM 1719-25	094142	2	
	Nut, M10-8-B Hex Nylon Zinc Lock	F81033-1	1	
<b>11</b>	<b>HANDLE, BLADE ENGAGEMENT WLDMT/PTD</b>	097221-1 <sup>2</sup>	1	
<b>12</b>	<b>COVER, RRWA-91626-110 GRIP</b>	086875	2	
<b>13</b>	<b>SWITCH, GLCB01C LIMIT</b>	100910	1	
<b>14</b>	<b>WASHER, 6.4 FLAT ZINC</b>	F81053-1	2	
<b>15</b>	<b>NUT, M6-8-B HEX NYLON ZINC LOCK</b>	F81031-2	1	
<b>16</b>	<b>BOLT, M6x50-8.8 ZINC</b>	F81001-62	1	
<b>17</b>	<b>WASHER 4.3 FE/ZN5 PN-M/82005</b>	F81051-2	2	
<b>18</b>	<b>SCREW, M4x35-8.8 HEX SOCKET HEAD CAP ZINC</b>	F81011-34	2	
<b>19</b>	<b>HANDLE, LOCKING</b>	501962	1	
<b>20</b>	<b>BLOCK, UP/DOWN MOULDER</b>	501964	1	
<b>21</b>	<b>PIN, 4M6x22 DIN6325 HRC60 ROLL ZINC</b>	F81048-82	1	
<b>22</b>	<b>RING, 32W RETAINING</b>	F81090-37	1	
<b>23</b>	<b>BRACKET, MOULDER BOX</b>	501995-1	2	
<b>24</b>	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 460V (U.S. Only)</b>	500629-4	1	
	<b>BOX, MOULDER ELECTRICAL CONTROL MP100 230V (U.S. Only)</b>	500629-5	1	
	<b>GUARD, MOULDER COMPLETE</b>	501958	1	
<b>25</b>	Plate, Moulder Guard	502536	1	
<b>26</b>	Bracket, Moulder Guard	502517-1	2	
<b>27</b>	Bolt, M8x25-8.8-B Hex Head Full Thread zinc	F81002-5	4	
<b>28</b>	Washer, 8.4 FLAT,ZINC	F81054-1	6	
<b>29</b>	Nut, M8-8-B, Hex, Nylon Lock zinc	F81032-2	2	
<b>30</b>	<b>PULLEY, MP100 MANUAL FEED COMPLETE</b>	502527	1	
<b>31</b>	Pulley, LT15 Feed Rope	086117	1	
<b>32</b>	Bearing, 6003 DDUCM NSK	086116	2	
<b>33</b>	Ring, 17 FE/ZN5 Adjusting	F81039-1	1	
<b>34</b>	Screw, M6x10 8.8 Hex Socket Head Cap Zinc	F81001-12	2	
<b>35</b>	Screw, M6x8	F81013-1	1	
<b>36</b>	PIN, 6X50 ROLL ZINC	F81045-1	1	

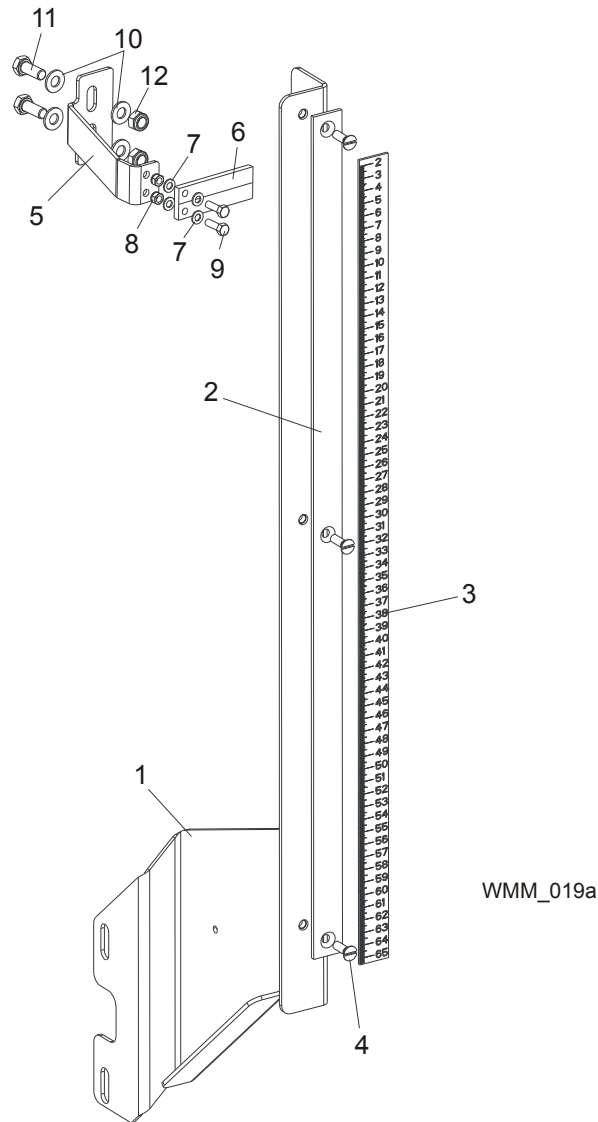
<sup>1</sup> Replaced 502967 Feed Crank Assembly (Rev. A1.02; 2/12).

<sup>2</sup> CE Version Only.

# 7 Parts

## Scale & Height Indicator

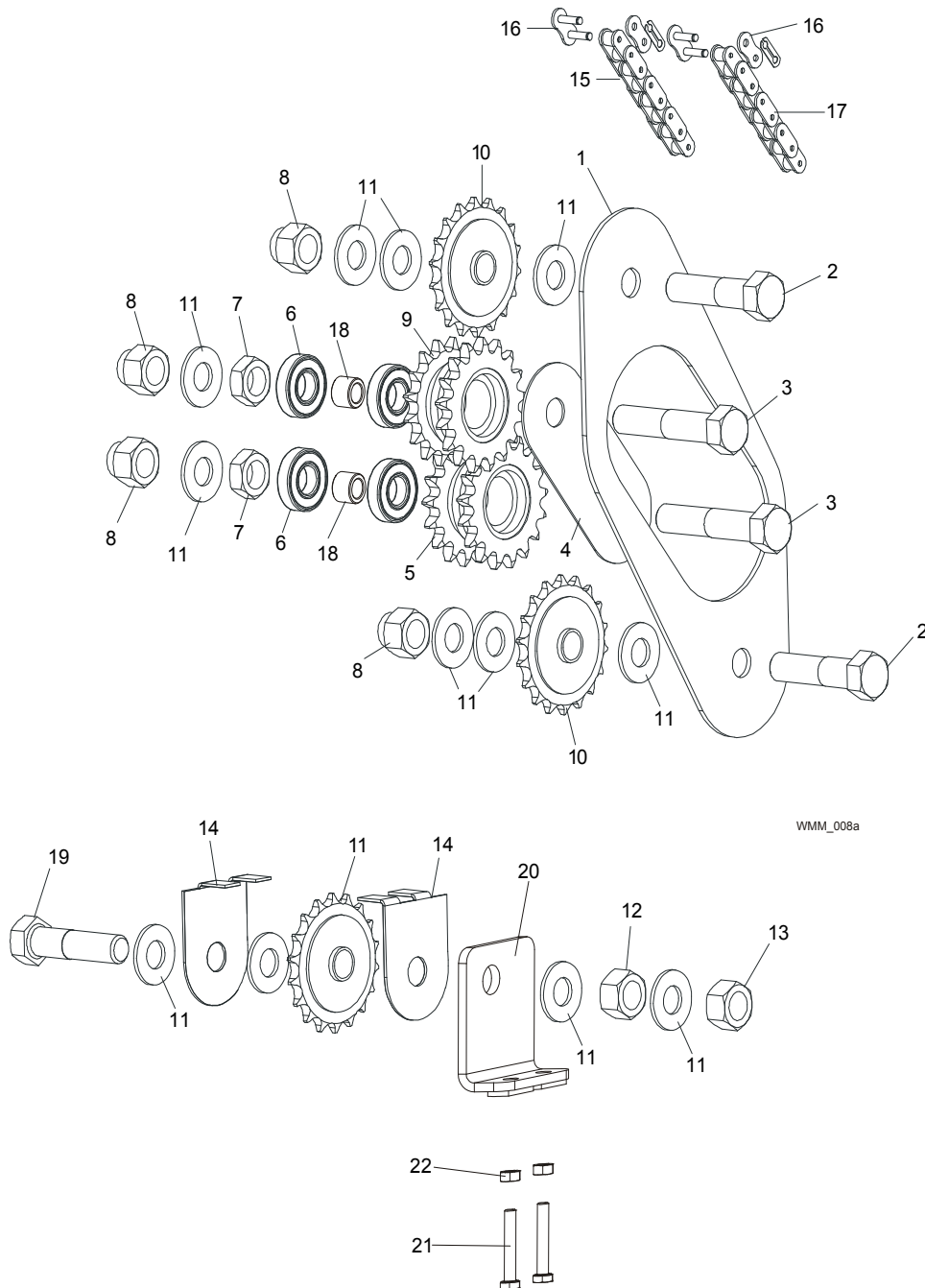
### 7.9 Scale & Height Indicator



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>SCALE, UP/DOWN MOULDER COMPLETE</b>	502509	1
1	Bracket, Moulder Scale	502508-1	1
2	Bar, Scale Flat	502506	1
3	Scale, Moulder Height	502505	1
4	Screw, M6x20- 4.8-B Zinc	F81001-31	3
	<b>INDICATOR, MOULDER COMPLETE</b>	501999	1
5	Bracket, Moulder Indicator	501998-1	1
6	Indicator, Blade Height Scale	094821	1
7	Washer, 5.3 Flat Zinc	F81052-1	4
8	Nut, M5-8 Din 985 Zinc-plated	F81030-2	2

<b>9</b>	Bolt, M5x16-8.8 Hex Head Full Thread Zinc5	F81000-20	2	
<b>10</b>	Washer, 8.4 Flat Zinc	F81054-1	4	
<b>11</b>	Bolt, M8x20-8.8-B Hex Head Full Thread	F81002-4	2	
<b>12</b>	Nut, M8-8-B Hex Nylon Zinc Lock	F81032-2	2	

### 7.10 Up/Down Drive Sprocket Assembly

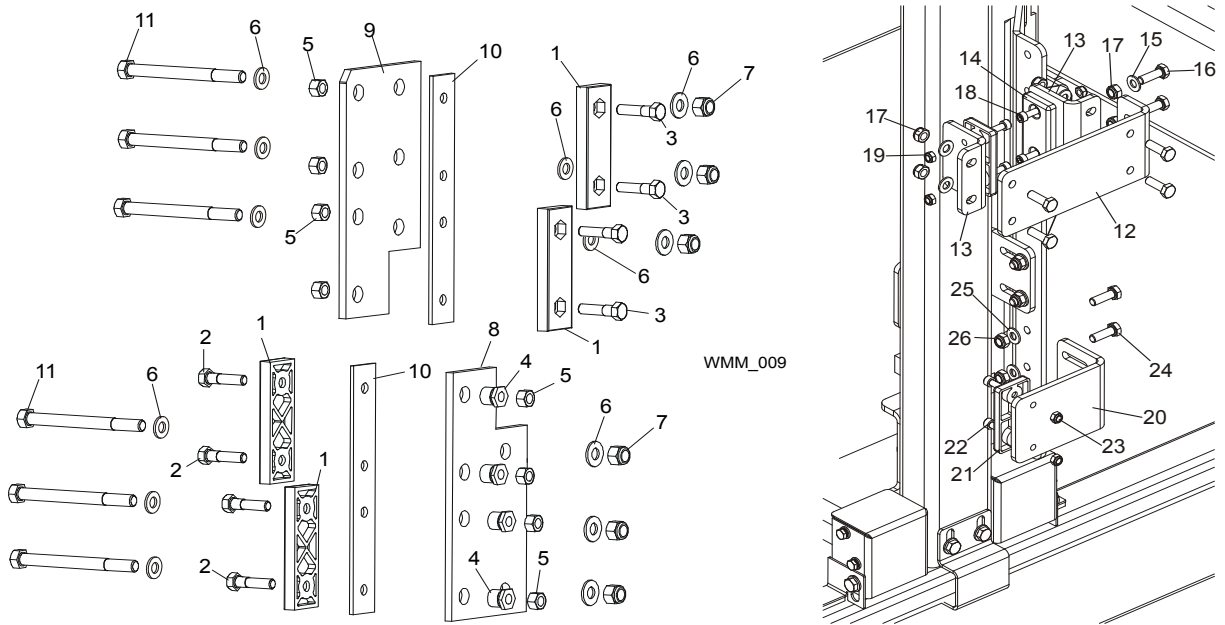


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	GUARD, UP/DOWN CHAIN INTERNAL	014907-1	1
2	BOLT, M16X65-8.8-B HEX HEAD FULL THREAD ZINC	F81006-1	2
3	BOLT, M16X80 8.8-B HEX HEAD FULL THREAD ZINC	F81006-11	2
4	PLATE, UP/DOWN DRIVE SPROCKET MOUNT PTD	087104-1	1



5	SPROCKET DUAL 17/17 PTD	086812-1	1	
6	BEARING, R-10	P04156	4	
7	NUT, M16 HEX THIN ZINC	F81036-4	2	
8	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	4	
9	SPROCKET DUAL 16/17 PTD	086813-1	1	
10	SPROCKET, 17T G1#40-41 5/8" ID	P04333	3	
11	WASHER 17 FLAT ZINC	F81058-1	12	
12	NUT M16-5.8 HEX ZINC	F81036-1	1	
13	NUT, M16-8 HEX NYLON ZINC LOCK	F81036-2	1	
14	GUARD,LT10 UP/DOWN CHAIN SPROCKET	092566-1	2	
15	CHAIN, #40 X 111 1/2"	014831	1	
16	LINK, #40 MASTER	P04200	2	
17	CHAIN, #40 X 15 1/2"	P12496	1	
18	BUSHING - ZINC	095938-1	2	
19	BOLT, M16x80 8.8-B- Fe/Zn5 HEX HEAD FULL	F81006-11	1	
20	BRACKET, TIGHTENING	502525-1	1	
21	BOLT, M6X40MM,HEX HEAD,FULL THRD,ZINC	F81001-5	2	
22	NUT, M6, HEXAGON,FREE, GRADE 5(8.8)ZINC	F81031-1	2	

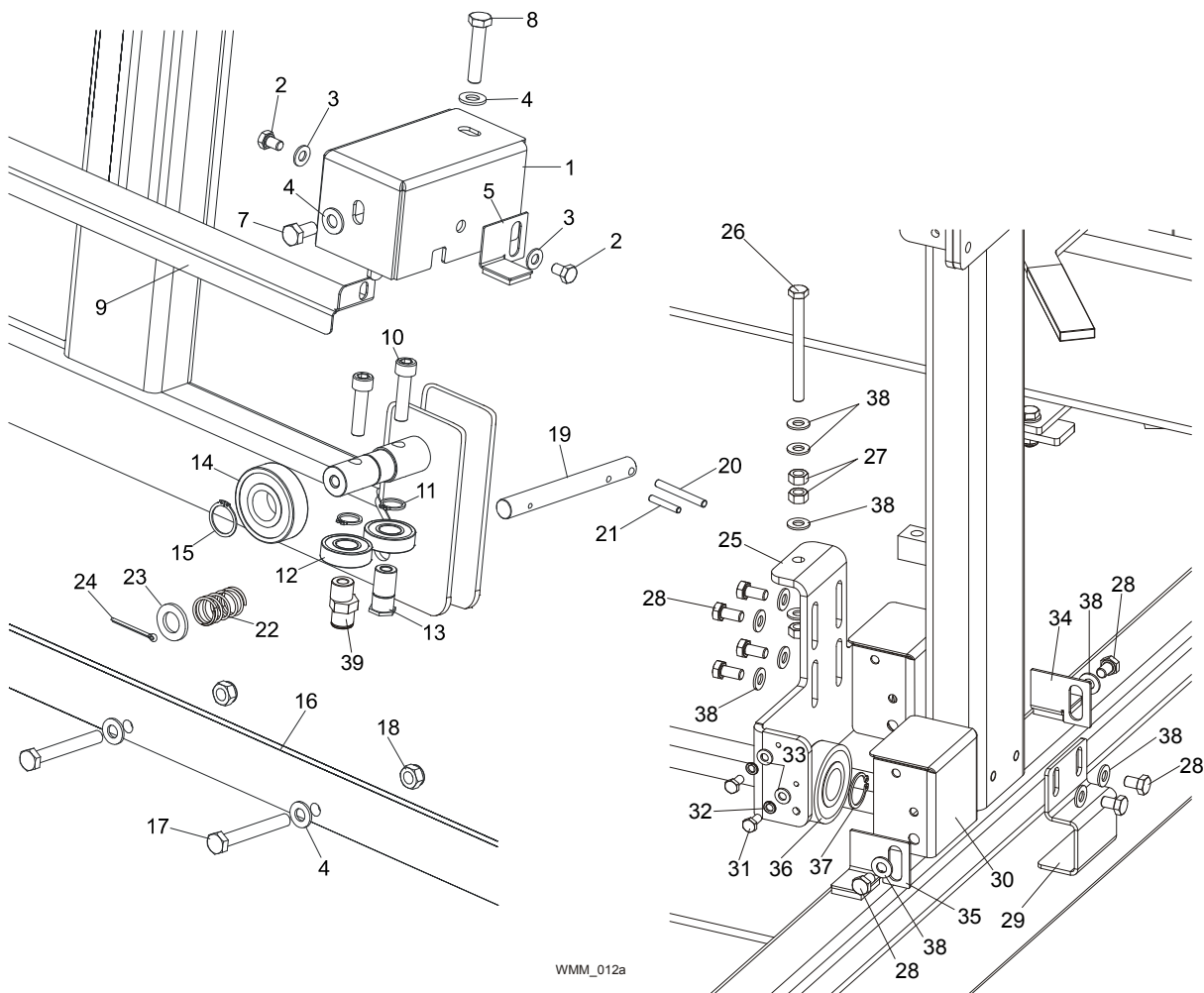
### 7.11 Slide Pads



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	PADS, UP/DOWN SLIDE	M04096	4
2	BOLT, M8X35 -8.8 HEX HEAD FULL THREAD ZINC	F81002-13	4
3	BOLT, M8X20MM, HEX HEAD,GR 5.8 ZINC	F81002-4	4
4	NUT, LT10 SLIDE PAD ADJUSTMENT ZINC-PLATED	086683-1	4
5	NUT, M8-8-B HEX NYLON ZINC LOCK	F81032-2	8
6	WASHER, 10.5 FLAT ZINC	F81055-1	12
7	NUT, M10-8-B HEX NYLON ZINC LOCK	F81033-1	8
8	PLATE, LT10 SLIDE PAD MOUNT	086682-1	1
9	PLATE, SAW HEAD UPPER GUIDE PAINTED	094139-1	1
10	PLATE, SLIDE PAD SPACER PAINTED	094140-1	2
11	BOLT, M10X115-8.8 HEX HEAD ZINC	F81003-19	6
	<b>PAD, SLIDE UPPER</b>	502503	1
12	Bracket, Slide Pad Upper	501902-1	1
13	Bracket, Slide Pad	501903-1	2
14	Pad, Idle Side Slide	P13576	2
15	Washer, 8,4 Flat Zinc	F81054-1	10
16	Bolt, M8x25-8.8-b Hex Head Full Thread Zinc	F81002-5	6
17	Nut, M8-8-b Hex Nylon Zinc Lock	F81032-2	6
18	Screw, M6x16, Hex Socket Head Cap	F81001-21	4
19	Nut, M6-8-b Hex Nylon Zinc Lock	F81031-2	4
	<b>PAD, SLIDE LOWER</b>	502504	2
20	Bracket, Slide Pad Lower	501991-1	1
21	Pad, Idle Side Slide	P13576	1

22	Screw, M6x16, Hex Socket Head Cap	F81001-21	2	
23	Nut, M6-8-b Hex Nylon Zinc Lock	F81031-2	2	
24	<b>BOLT, M8x25-8.8-B HEX HEAD FULL THREAD ZINC</b>	F81002-5	4	
25	<b>WASHER, 8,4 FLAT ZINC</b>	F81054-1	4	
26	<b>NUT, M8-8-B HEX NYLON ZINC LOCK</b>	F81032-2	4	

### 7.12 Track Rail, Rollers & Travel Pins



WMM\_012a

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	HOUSING, TRACK ROLLER PAINTED	086739-1	2
2	BOLT, M8X12-8.8 HEX HEAD FULL THREAD ZINC	F81002-6	4
3	WASHER, 8.4 FLAT ZINC	F81054-1	4
4	WASHER, 10.5 FLAT ZINC	F81055-1	4
5	PLATE, RIGHT TRACK WIPER	086322	2
6	PLATE, LEFT TRACK WIPER	086323	2
7	BOLT, M10 X 20 5.8 HEX HEAD FULL THREAD ZINC	F81003-1	2
8	BOLT, M10X50-8.8 HEX HEAD FULL THREAD ZINC	F81003-4	2
9	COVER, MIDDLE TRACK	086745	1
10	SCREW, M10X40 HEX SOCKET HEAD CAP ZINC	F81003-22	4
11	RING, Z 17 OUTSIDE RETAINING	F81090-21	4
12	BEARING, 6203-2RS ROLLING	086114	4
13	SHAFT, SIDE BEARING MOUNT ZINC-PLATED	086645-1	4

14	<b>BEARING, 6305-2RS CX</b>	085706	2	
15	<b>RING, 25Z OUTSIDE RETAINING</b>	F81090-22	2	
16	<b>RAIL, LT15 1950 (LT15S3) TRACK ZINC-PLATED</b>	094427-1	3	
	<b>RAIL, LT15 2700 (LT15M2) TRACK ZINC-PLATED</b>	094696-1	2	
17	<b>BOLT, M10X75-8.8 HEX HEAD ZINC</b>	F81003-15	9/13 <sup>1</sup>	
18	<b>NUT, M10-8-B HEX NYLON ZINC LOCK</b>	F81033-1	9/13 <sup>2</sup>	
19	<b>SHAFT, LOWER UPRIGHT GUIDE</b>	014899 <sup>3</sup>	2	
20	<b>PIN, 1/4" X 2" ROLL</b>	F05012-46 <sup>3</sup>	2	
21	<b>PIN, 3/16" X 1 1/4" X 30 ROLL</b>	F05012-16 <sup>3</sup>	2	
22	<b>SPRING, 7/8" OD X 1 1/2"</b>	P07997 <sup>3</sup>	2	
23	<b>TUBE, 41/64" X 1" X 3/16"</b>	S12480 <sup>3</sup>	2	
24	<b>PIN, 1/8" X 1" COTTER</b>	F05012-1 <sup>3</sup>	2	
	<b>ROLLER, IDLE SIDE COMPLETE</b>	503081-S	1	
25	Bracket Weldment, Idle Side Roller Painted	501782-1	1	
26	Bolt, M8x90-8.8 Hex Head Full Thread Zinc	F81002-16	1	
27	Nut, M8-8-b Hex Zinc	F81032-1	3	
28	Bolt, M8x16-8.8-b Hex Head Full Thread Zinc	F81002-20	8	
29	Guide, Lt15 Mast Idle Side Painted	503768-1	1	
30	Cover, Roller	501783-1	2	
31	Bolt, M6x12-8.8 Hex Head Full Thread Zinc	F81001-7	4	
32	Washer, Z6.1 Split Lock Zinc	F81053-3	4	
33	Washer, 6.4 Flat Zinc	F81053-1	4	
34	Plate, Right Track Wiper	086322	1	
35	Plate, Left Track Wiper	086323	1	
36	Bearing, 6305-2rs Cx	085706	2	
37	Ring, 25z Outside Retaining	F81090-22	2	
38	Washer, 8.4 Flat Zinc	F81054-1	12	
39	<b>SHAFT, OUTER ECCENTRIC E=3,3-ZINC</b>	098898-1	2	

<sup>1</sup> Number of bolts for one bed section.

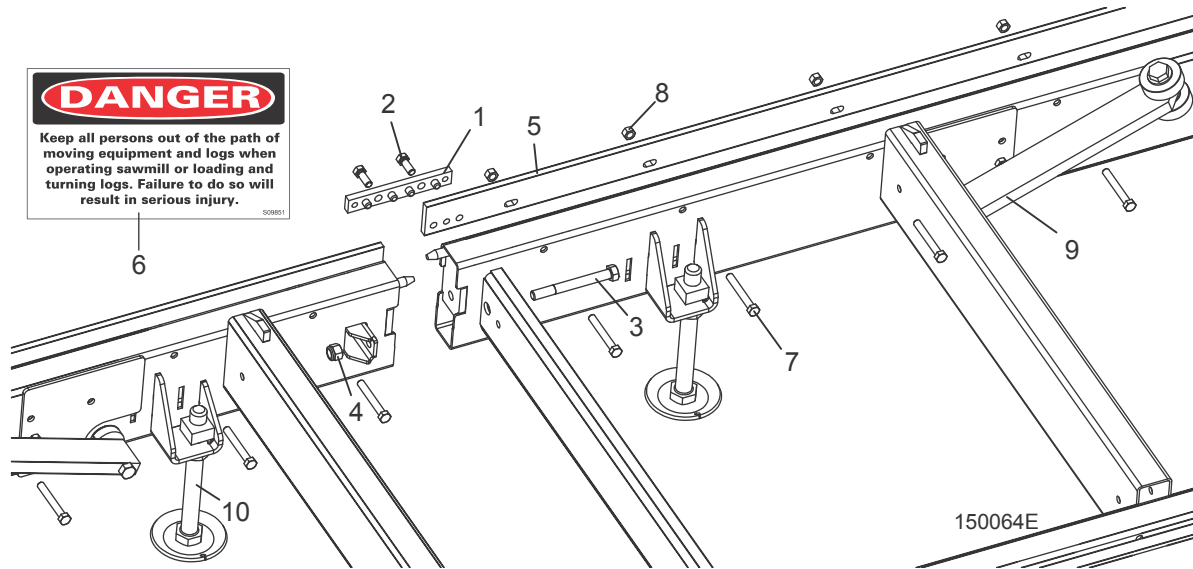
<sup>2</sup> Number of nuts for one bed section.

<sup>3</sup> 014899 replaced metric Travel Lock Zinc-Plated Pin (086743-1), F05012-46 replaced 6x50 Roll Pin (F81045-1), F05012-16 replaced 5x30 Roll Pin (F81044-21), P07997 replaced 18x37x1.8 Compression Spring (087301), S12480 replaced 17 Flat Washer (F81058-1), F05012-1 replaced 4 X 25 Cotter Pin (F81043-2) (8/11).

# 7 Parts

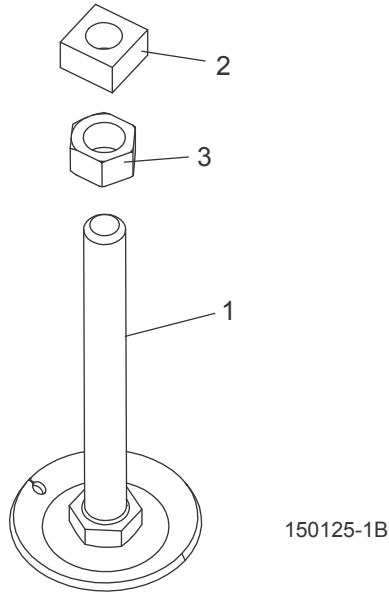
## Bed Frame Section (Optional)

### 7.13 Bed Frame Section (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>BED SECTION ASSEMBLY, LT15</b>	LT15BS	1
1	Splice Assembly, Pinned Bed Rail	016170	1
2	Bolt, 3/8-16 X 1" Grade 5 Hex Head	F05007-87	2
3	Bolt, 1/2-13 X 5" Grade 5 Hex Head	F05008-66	4
4	Nut, 1/2-13 Hex Nylon Lock	F05010-8	4
5	Rail, Pinned 80.5" Long Bed	016489	1
6	Decal, Keep Away Danger	S09851	1
7	Bolt, 3/8-16 x 2 3/4" Hex Head Full Thread	F05007-230	8
8	Nut, 3/8-16 Swaged Lock	F05010-25	8
9	Side Support Parts ( <a href="#">See Section 7.15</a> )		
10	Leg Parts ( <a href="#">See Section 7.14</a> )		

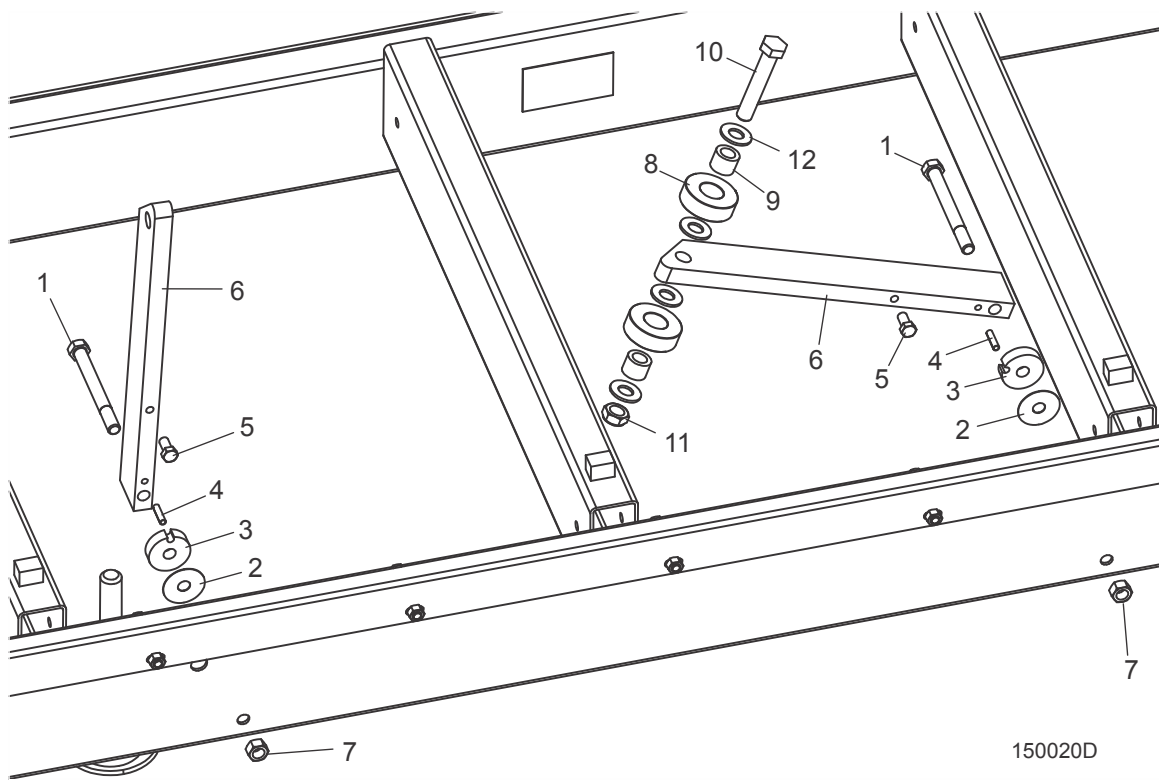
### 7.14 Leg Assembly (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	LEG WELDMENT, LT15 2004	046615	4	
2	NUT, 7/8-9 SQUARE	F05010-186	4	
3	NUT, 7/8-9 HEX	F05010-136	4	

**7** Parts  
*Log Side Support Assembly (Optional)*

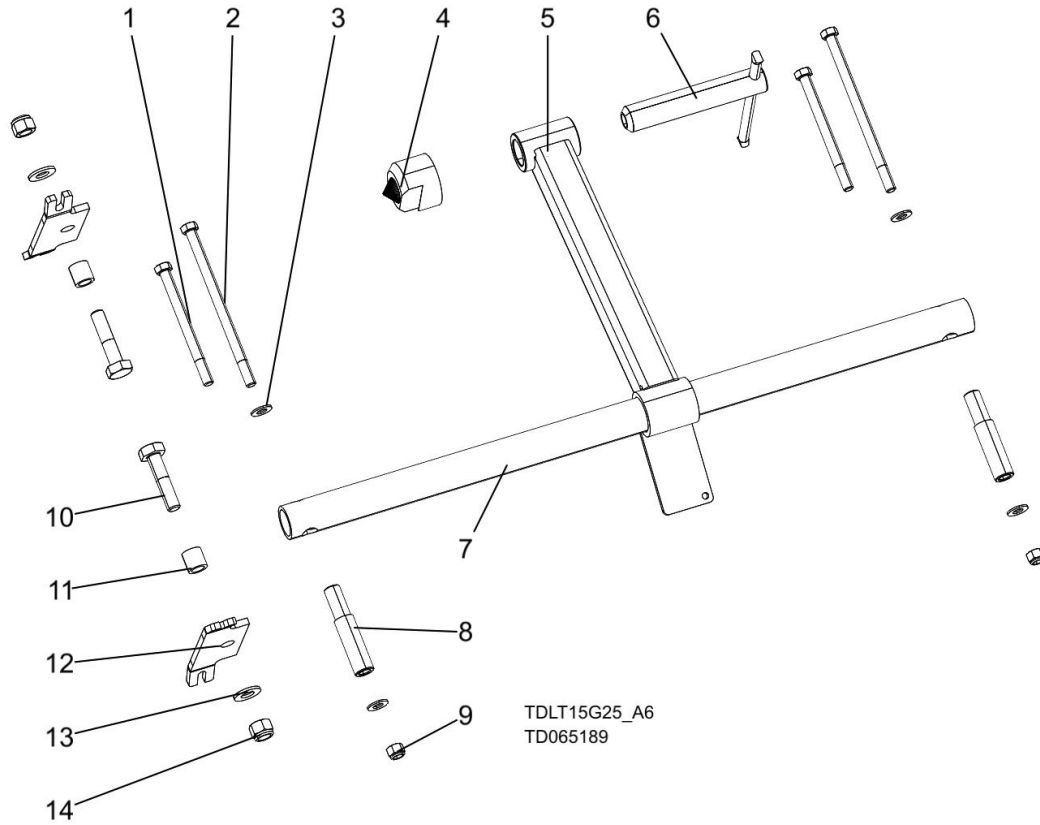
**7.15 Log Side Support Assembly (Optional)**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	<b>BOLT, 1/2-13 X 5 1/2" HEX HEAD CAP GRADE 5</b>	F05008-28	2
2	<b>WASHER, 33/64 X 1 3/4 X 1/32" NYLON</b>	014972	2
3	<b>WASHER, 1/2" LOG SIDE SUPPORT</b>	025767	2
4	<b>PIN, 1/4 X 1" ROLL</b>	F05012-7	2
5	<b>BOLT, 3/8-16 X 3/4" HEX HEAD GRADE 5 W/NYLON PATCH</b>	F05007-168	2
6	<b>SUPPORT, LOG SIDE</b>	014855	2
7	<b>NUT, 1/2-13 HEX LOCK</b>	F05010-3	2
	<b>ROLLER ASSEMBLY, LT15 SIDE SUPPORT</b>	074276	1
8	Roller, Side Support	016561	2
9	Bushing, Bronze 5/8" x 1" x 3/4"	016560	2
10	Bolt, 5/8-11 x 3 1/2" Hex Head Grade 5	F05009-93	1
11	Nut, 5/8-11 Jam Nylon Lock	F05010-96	1
12	Washer, 5/8" SAE Flat	F05011-5	4



7.16 Feed Rope/Log Clamp Kit (Optional)



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	F05007-109	Bolt, 3/8-16x4 3/4 HH Gr5		2
2	F05007-205	BOLT, 3/8-16 X 6 1/2 HH Zinc Gr5		2
3	F05011-3	Washer, 3/8 Flat SAE		4
4	075295	Block, Clamp Point		1
5	071343	Tube Weldment, Clamp Post		1
6	071348	Screw, 1-5 Acme Clamp		1
7	071026	Tube, 2012 Clamp Main		1
8	071034	Spacer, 2012 Clamp Mount		2
9	F05010-10	Nut, 3/8-16 Hex Nyl Lock		2
10	F05008-10	Bolt, 1/2-13x2 1/4 Hex Head GR5		2
11	033911	Spacer, Pivot Lock Board Return		2
12	074463	Bracket, Rope/Stop LT15		2
13	F05011-2	Washer, 1/2 SAE Flat		2
14	F05010-8	Nut, 1/2-13 Nyl Hex Lock		2

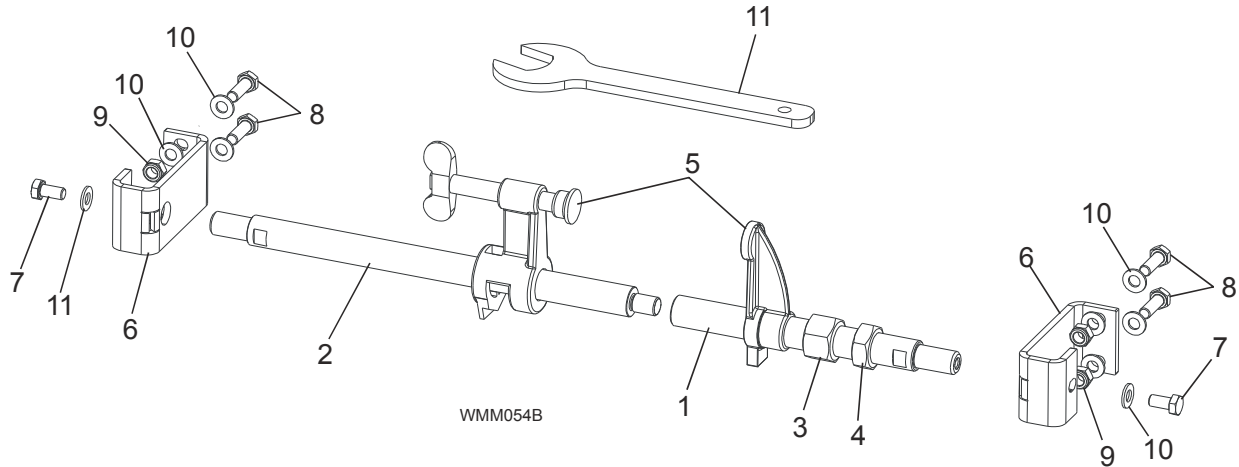


## **Parts**

*Feed Rope/Log Clamp Kit (Optional)*

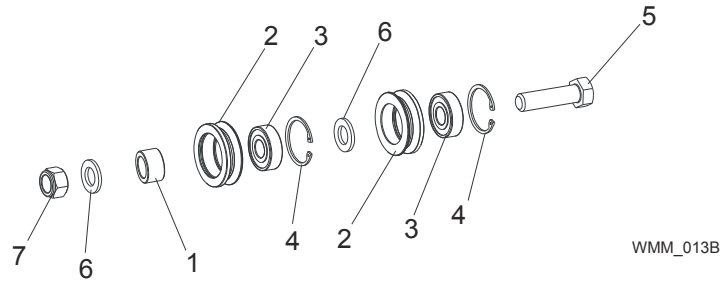
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## 7.17 Cant Clamp, MP100 Option



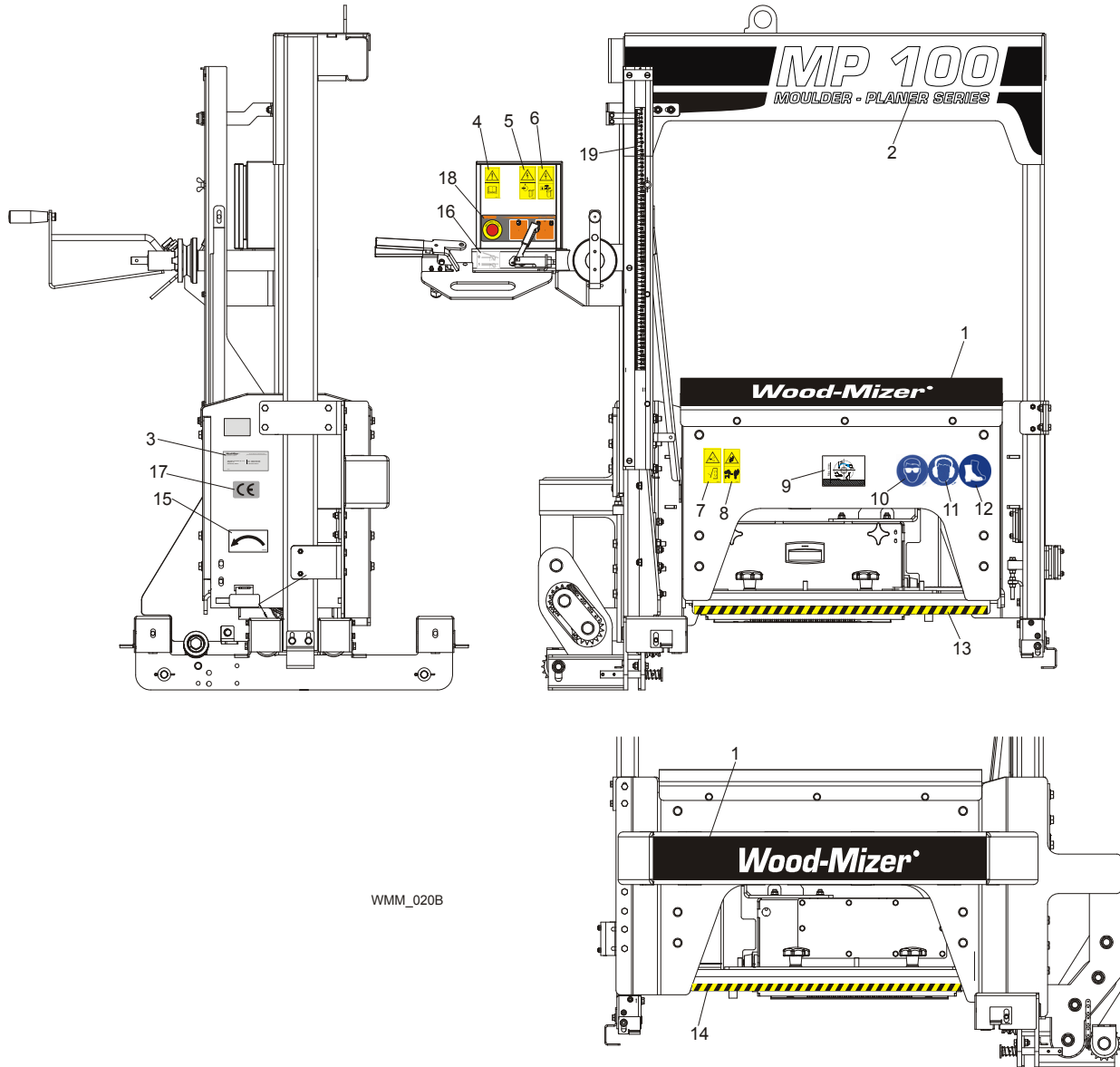
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CANT CLAMP ASSEMBLY, MP100 OPTION</b>	504192-S	1
1	Rod, SCR Zinc-plated	502988-1	1
2	Rod, Smooth	502989-1	1
3	Nut, G 3/4	502991-1	1
4	Nut, G 3/4 Thin	502992-1	1
5	Jaws, Log Clamp Complete	502993	1
6	Bracket, Log Clamp Mount Zinc	502994-1	2
7	Bolt, M10x20mm Hex Head, Gr 5.8 Zinc	F81003-1	2
8	Bolt, M10x30-5.8 Hex Head Full Thread Zinc	F81003-2	4
9	Nut, M10-8-b Hex Nylon Zinc Lock	F81033-1	4
10	Washer, 10.5 Flat Zinc	F81055-1	10
11	Wrench, 36 Flat Zinc-plated	502995-1	1

### 7.18 Feed Rope Guide Rollers



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	<b>ROPE ROLLER GUIDE SYSTEM COMPLETE</b>	501415-1	1
	Support, Rope Roller Guide System	093855	2
2	Spacer, N25xn16.5x60 Bearing	093856-1	1
3	Bearing, 6203 2rs 5/8 Cx	095087	1
4	Ring, W40 Inside Retaining	F81090-3	1
5	Bolt, M16x70 8.8 Hex Head Full Thread Zinc	F81006-16	1
6	Washer, 17 Flat Zinc	F81058-1	2
7	Nut, M16-8 Hex Nylon Zinc Lock	F81036-2	1

### 7.19 Moulder Decals



WMM\_020B

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>KIT, MOULDER DECAL</b>	502583	1
1	Decal, Wood-Mizer Moulder	502581	2
2	Decal, Moulder Type	502582	1
3	Decal, European Headquarters Address	015841	1
	Decal, WMP Headquarters Address	505761 <sup>1</sup>	1
4	Decal, Read Operator's Manual (Pictogram)	096317	1
5	Decal, High Voltage Inside The Electric Box (Pictogram)	096316	1
6	Decal, Remove The Plug Before Opening The Box (Pictogram)	096319	1
7	Decal, Sawmill Covers Caution	099220	1

# 7 Parts

## Moulder Decals

8	Decal, Keep Away Danger, Pictogram	099221	1	
9	Decal, Maximum Moulding Depth	502423	1	
10	Decal, Eye Protection Warning (Pictogram)	S12004G	1	
11	Decal, Ear Protection Warning (Pictogram)	S12005G	1	
12	Decal, Use Safety Boots (Pictogram)	501465	1	
13	Decal, Warning Stripe (Black&yellow)	087649	1	
14	Decal, Warning Stripe (Black&yellow)	502481	1	
15	Decal, Motor Rotation Direction	089296	1	
16	Decal, Safety Handle (CE Version Only)	501477	1	
17	Decal, CE Certified Sawmill, Small	P85070 <sup>2</sup>	1	
18	<b>DECAL, MOULDER CONTROL BOX (CE VERSION ONLY)</b>	502320	1	
	<b>DECAL, MOULDER CONTROL BOX (U.S. VERSION ONLY)</b>	502320-UL	1	
19	<b>DECAL, MOULDER HEIGHT</b>	502505	1	

<sup>1</sup> U.S. Version Only.

<sup>2</sup> CE Version Only.

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