

SECTION 6.5 ACCUMULATOR OPTION

6.5.1 Overview

The Wood-Mizer Accumulator is compatible with Multihead Resaws which have four or less saw heads and a Merry-Go-Round handling system. The Accumulator holds, or accumulates, cants until the Merry-Go-Round has room for them.

See Figure 6-21. As a cant is fed into the Accumulator, it travels down the far side until it engages the Accumulator table switch. This switch causes the transfer table to rise.

The transfer chains on the table, which run continuously, make contact with the cant and move it from the far side of the Accumulator against the feed chain on the near side. The table then lowers until the next cant activates the switch, and so on.

This cycle causes the cants to stack up against the feed chain on the near side of the Accumulator.

When the Merry-Go-Round has room for another cant, it sends a signal to the Accumulator. This signal momentarily stops the transfer chains and starts the feed chain. As the feed chain turns, it sends a cant from the Accumulator to the transfer table of the Merry-Go-Round. The feed chain then stops and the transfer chains start again.

Table 6-1 shows the specifications of the Accumulator. Overall dimensions include the Accumulator and the MULTIHEAD with standard Merry-Go-Round. For Merry-Go-Rounds with transfer tables which are 8' (2.44 m) long, add 4' (1.22 m) to the overall length.

Width of Accumulator	5' 6 5/8" (1.69 m)
Length of Accumulator	6' 2" (1.88 m)
Overall Width	8' 10" (2.69 m)
Overall Length (1-2 heads)	34' 6 1/4" (10.52 m)
Overall Length (3-4 heads)	39' 2 1/4" (11.94 m)
Overall Height	6' 8" - 6' 3/4" (1.85 m)
Fuse Size (electrical box)	.4 AMP

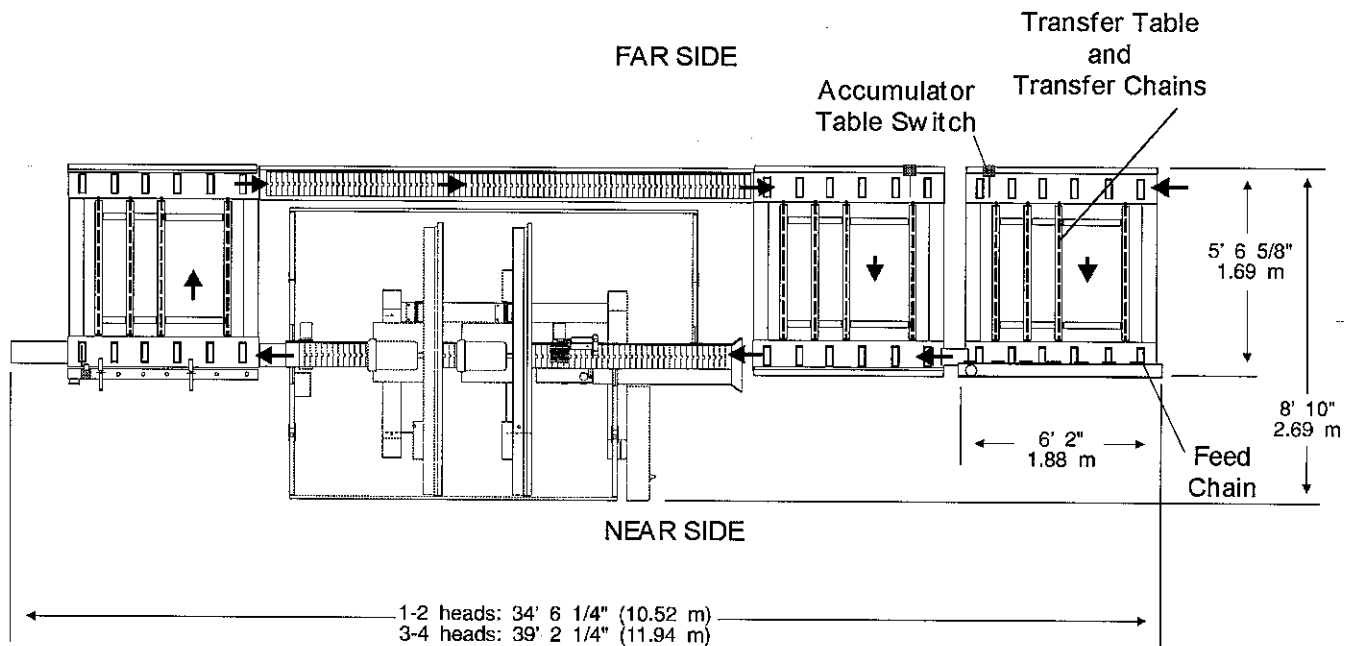


FIGURE 6-21. ACCUMULATOR.

6.5.2 Accumulator Setup

1. See Figure 6-22. Each Accumulator leg is adjustable to help align the table with the Merry-Go-Round (MGR) table. Loosen the locking bolt and turn the adjusting bolt to raise or lower the leg. Sight down the table edge to determine if the table is aligned with the MGR table. Retighten the locking bolt to maintain the adjustment.

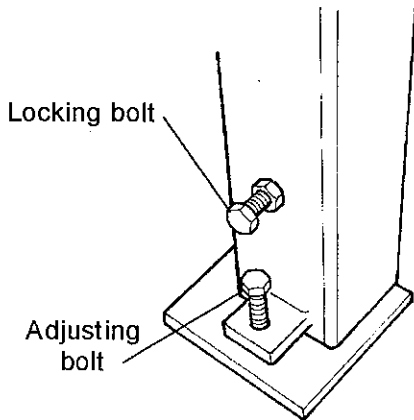


FIGURE 6-22. TABLE LEG ADJUSTMENT.

Avoid adjusting the legs so the table buckles, causing cants to contact the transfer chain before they are completely on the transfer table.

2. See Figure 6-23. Adjust the Accumulator air switch so that the end of the cant contacts the switch once it has completely moved onto the Accumulator table.

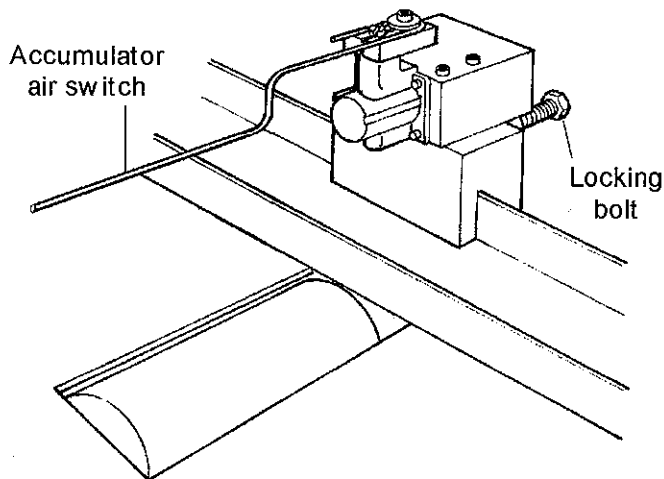


FIGURE 6-23. AIR SWITCH ADJUSTMENT.

6.5.3 Accumulator Air System

1. The Accumulator air system consists of a shutoff valve and an air regulator/filter. The Accumulator air system should be connected to the MGR transfer air system as follows.

1. At the MGR transfer air system, remove the line connecting the top of the MGR shutoff valve to the left side of the MGR regulator/filter.
2. See Figure 6-24. Locate the two lines coming off of the 'T' fitting on the Accumulator shutoff valve.

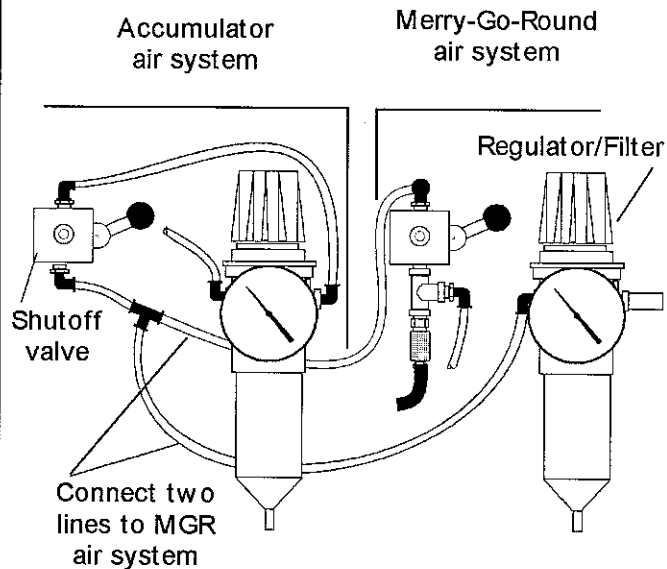


FIGURE 6-24. ACCUMULATOR AIR SYSTEM.

3. Connect one of the 'T' lines to the MGR shutoff switch fitting. Connect the other line to the MGR regulator/filter fitting.
4. Raise all shutoff valve handles up to open.
5. Turn the regulator valve until the gauge indicates 60 p.s.i. Turning the valve clockwise raises the air pressure; counterclockwise lowers the air pressure.

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6.5.4 Accumulator Parts Lists

TRANSFER DRIVE ASSEMBLY			
Item	Part #	Description	Qty
1	P20206	Motor, Hydraulic	1
2	F05007-7	Bolt, 3/8-16 x 1" Hex Head	6
3	F05011-4	Washer, 3/8" Split Lock	6
4	F05011-16	Washer, 5/16" Standard Flat	4
5	S20185	Coupling, 1" Shaft	2
6	P21507	Gear Box	1
7	F05007-78	Bolt, 3/8-16 x 1.5" Hex Head, G5	10
8	F05011-16	Washer, 5/16" Standard Flat	20
9	P21491	Bearing, 1" Pillow Block	5
10	F05010-26	Nut, 5/16-18 Hex, Unplated	10
11	S21133	Shaft, Transfer Chain Drive	1
12	P21509	Chain, Transfer C2050	A/R
	P21558	Master Link, Transfer Chain C2050	5
13	F05010-82	Nut, 5/8-11 Jam	4
14	F05011-40	Washer, 5/8" Standard Flat	16
15	F05011-27	Washer, 5/8" Split Lock	4
16	F05009-20	Bolt, 5/8-11 x 2.5" Hex Head	4
17	F05006-53	Bolt, 5/16-18 x 5/8" Hex Hd, G2	2
18	F05011-13	Washer, 5/16" Split Lock	2
19	F05011-17	Washer, 5/16" SAE Flat	2
20	P21490	Bearing, 1" Flanged	1
21	P21505	Sprocket, 50BS14X1	1
22	P21504	Sprocket, 50BB17H	4
23	P20208	Master Link, #50 Chain	1
24	P20207	Chain, #50	A/R
25	P21503	Sprocket, 50B28X1	5
26	S21134	Shaft, Roller Drive	1
27	P21414	Sprocket, 50BS10X1	1
28	F05007-64	Bolt, 3/8-16 x 1" Flat Head	4
29	S20173	Plate, Motor Mount	1
30	S21330-1	Strip, Transfer Chain Guide	4

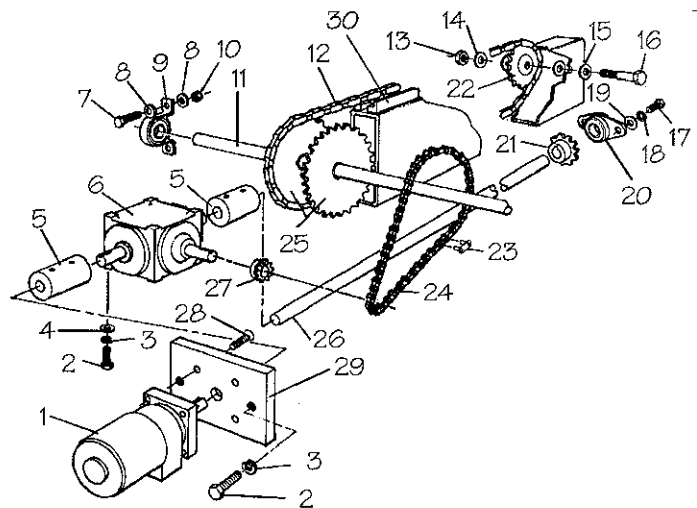


FIGURE 6-25. TRANSFER DRIVE ASSEMBLY.

ACCUMULATOR AIR BAG ASSEMBLY			
Item	Part #	Description	Qty
1	P21538	Air Bag, Accumulator	1
2	F05010-82	Nut, 5/8-11 Jam	1
3	R01869	Tube, Plastic Air 1/4" O.D.	A/R
4	P09736	Fitting, 1/8" NPT - 1/4" Tube Elbow	1
5	F05008-16	Bolt, 1/2-13 x 4.5" Hex Head, FT	2
6	F05010-3	Nut, 1/2-13 Lock	4

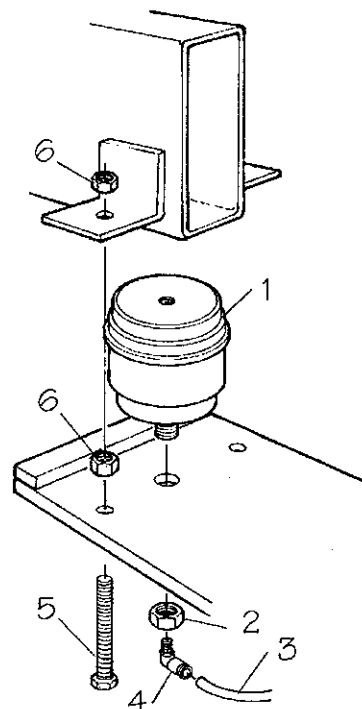


FIGURE 6-26. ACCUMULATOR AIR BAG ASSEMBLY.

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ACCUMULATOR AIR SYSTEM			
Item	Part #	Description	Qty
1	F05004-54	Bolt, #10-24 x 5/8" Socket Head	2
2	S21493	Washer, Air Switch Wand	1
3	S21497	Wand, Accumulator Air Switch	1
4	S21492	Block, Air Switch Wand	1
5	P21515	Air Switch, Accumulator	1
6	F09736	Fitting, 1/8" NPT - 1/4" Tube Elbow	1
7	S21128	Block, Air Switch Adjustment	1
8	P21544	Fitting, 1/4" Tube Tee	1
9	P21519	Fitting, 1/4" NPT - 1/4" Tube Elbow	4
10	P21510	Filter/Regulator, Accumulator Air	1
11	P21512	Gauge, Air p.s.i.	1
12	F05005-1	Bolt, 1/4-20 x 3/4" Hex Head	2
13	F05011-14	Washer, 1/4" Split Lock	2
14	F05011-11	Washer, 1/4" SAE Flat	2
15	P21511	Bracket, Air Filter/Regulator	1
16	F05004-26	Bolt, #10-24 x .5" Socket Head	4
17	P21513	Valve, Accumulator Air	1
18	P20904	Muffler, 1/4" NPT Air	1
19	R01869	Tube, Plastic Air 1/4" O.D.	A/R
20	F05007-16	Bolt, 3/8-16 x 2" Hex Hd, Full Thd.	1
21	F05010-1	Nut, 3/8-16 Hex	1
22	P21554	Fitting, 1/8" NPT - 1/4" Tube Straight	1
23	P20902	Muffler, 1/8" NPT Air	1
24	F05004-51	Bolt, #10-24 x 1.5" Socket Head	4

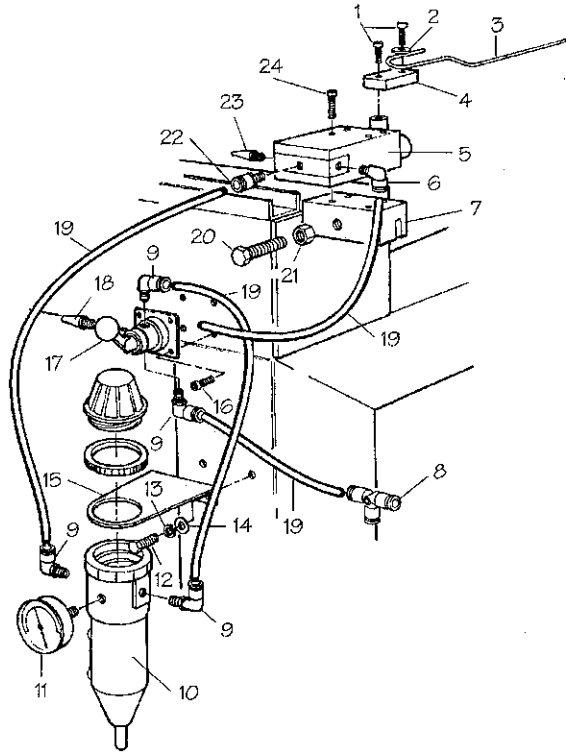


FIGURE 6-27. ACCUMULATOR AIR SYSTEM.

ACCUMULATOR ROLLER ASSEMBLY			
Item	Part #	Description	Qty
1	F05007-7	Bolt, 3/8-16 x 1" Hex Head	4
2	F05011-4	Washer, 3/8" Split Lock	4
3	F05011-16	Washer, 5/16 Standard Flat	4
4	S21088-N	Plate, Accumulator End	1
5	P21414	Sprocket, 50BS10X1	12
6	S21486	Key, 1/4" Shaft	12
7	W21082	Roller, Accumulator Feed	12
8	F05009-2	Bolt, 5/8-11 x 2" Hex Head	8
9	F05011-3	Washer, 5/8" SAE Flat	24
10	P20207	Chain, #50	A/R
	P20208	Master Link, #50 Chain	2
11	P21504	Sprocket, 50BB17H	8
12	F05011-27	Washer, 5/8" Split Lock	8
13	F05010-82	Nut, 5/8-11 Jam	8
14	P21490	Bearing, 1" Flanged	24
15	F05011-17	Washer, 5/16" SAE Washer	48
16	F05011-13	Washer, 5/16" Split Lock	48
17	F05006-53	Bolt, 5/16-18 x 5/8" Hex Head, G2	48

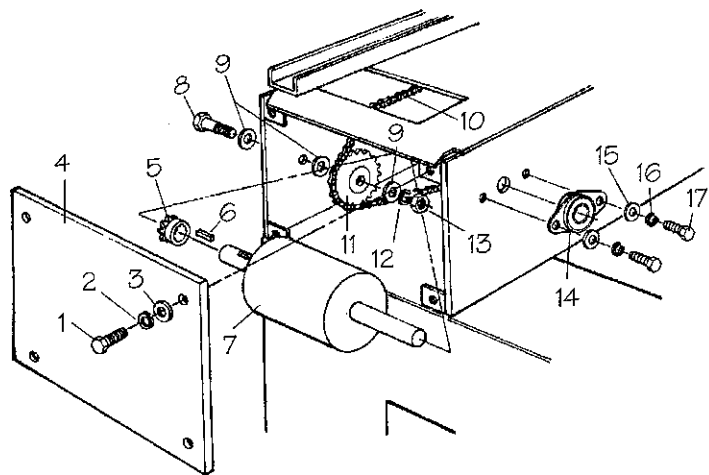


FIGURE 6-28. ACCUMULATOR ROLLER ASSEMBLY.

SECTION 6.5 ACCUMULATOR OPTION - cont'd

FEED CHAIN DRIVE ASSEMBLY			
Item	Part #	Description	Qty
1	P21506	Motor, Hydraulic	1
2	F05011-4	Washer, 3/8" Split Lock	4
3	F05007-27	Bolt, 3/8-16 x .75" Hex Head	4
4	W21713	Cover, Feed Chain Drive	1
5	P21503	Sprocket, 50BS28x1	1
6	P21509	Chain, Transfer C2050	A/R
	P21558	Master Link, Transfer Chain C2050	1
7	F05004-50	Bolt, #10-24 x 1" Socket Head	3
8	S21719	Block, Nylon Spacer	2
9	F05015-26	Bolt, 1/4-20 x 1" Flat Phillips Head	8
10	S21330	Strip, Feed Chain Guide, 48"	1.5

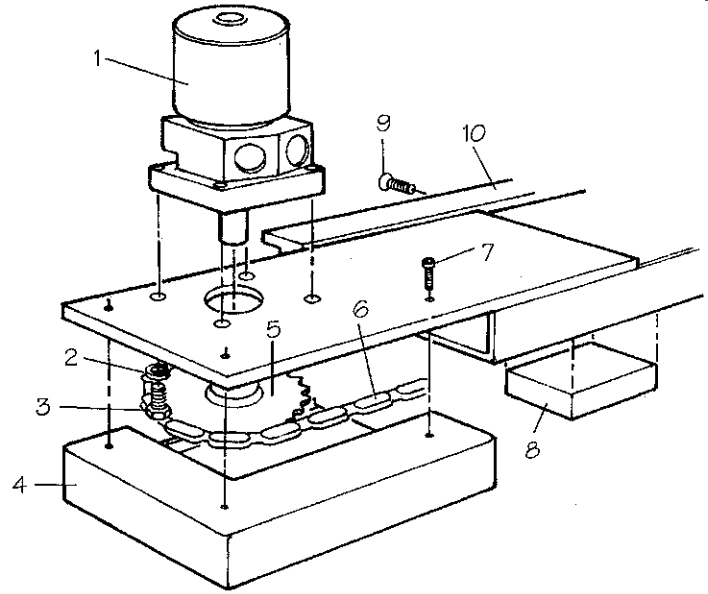


FIGURE 6-29. FEED CHAIN DRIVE ASSEMBLY.

FEED CHAIN IDLE ASSEMBLY			
Item	Part #	Description	Qty
1	S21718	Guard, Feed Chain Idle	1
2	F05004-26	Bolt, #10-24 x .5" Socket Head	4
3	F05010-82	Nut, 5/8-11 Jam	1
4	F05011-27	Washer, 5/8" Split Lock	1
5	F05011-40	Washer, 5/8" Standard Flat	10
6	P21504	Sprocket, 50BB17H	1
7	F05009-21	Bolt, 5/8-11 x 2.75" Hex Head	1

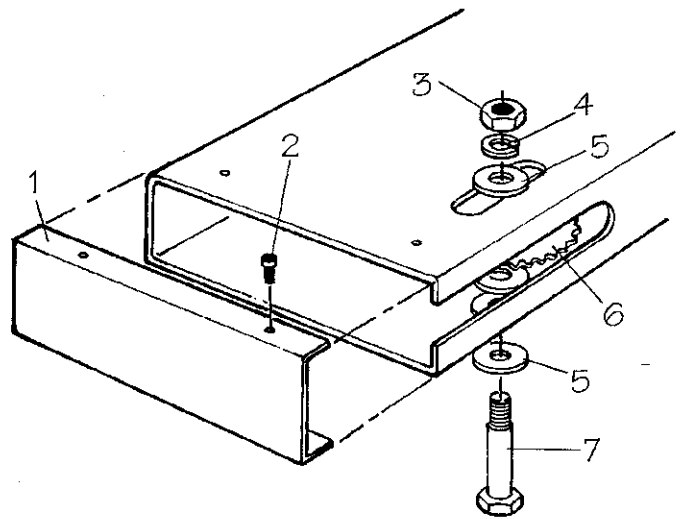


FIGURE 6-30. FEED CHAIN IDLE ASSEMBLY.

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FEED ROLLER DRIVE ASSEMBLY			
Item	Part #	Description	Qty
1	P21506	Motor, Hydraulic	1
2	P21129	Sprocket, 50BS20X1	1
3	P20207	Chain, #50 Drive	A/R
	P20208	Master Link, #50 Drive Chain	1
4	F05007-64	Bolt, 3/8-16 x 1" Flat Head	4

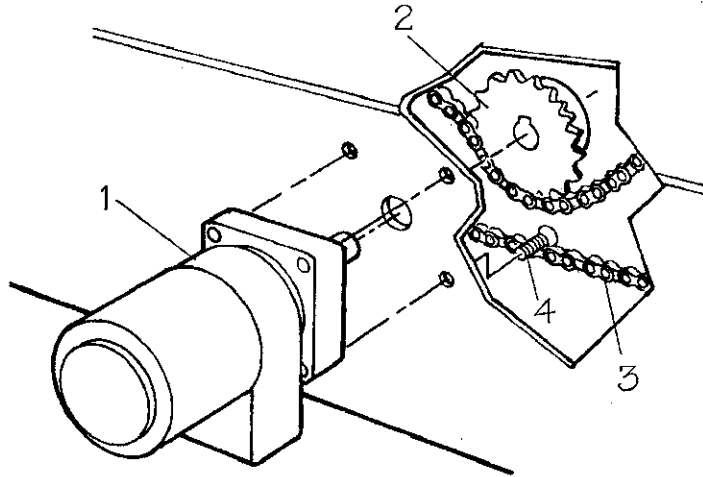


FIGURE 6-31. FEED ROLLER DRIVE ASSEMBLY.