

Wood-Mizer[®] Sawmill

Safety, Setup, Operation & Maintenance Manual

LT10

rev. A1.00 - B4.09



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

June 2005

Form #1231

California

Proposition 65 Warning



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

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

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



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

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

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

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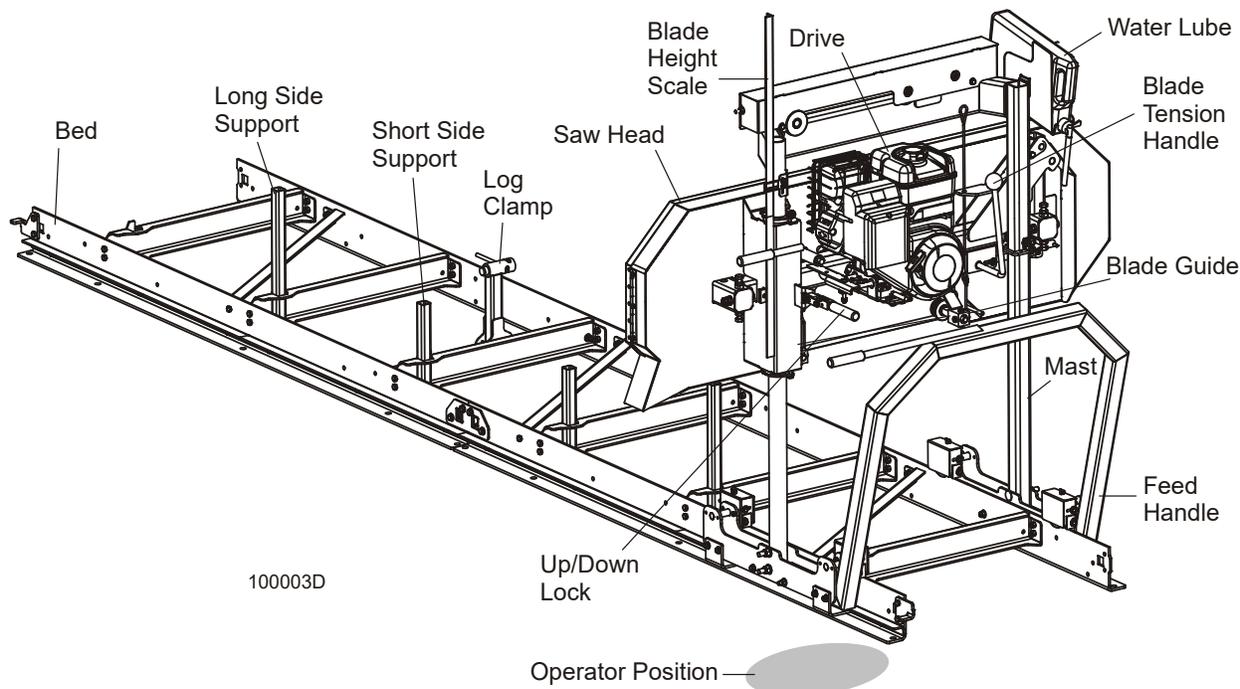
SECTION 1 INTRODUCTION

1.1 About This Manual

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

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

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



MILL COMPONENTS

*Wood-Mizer® is a registered trademark of Wood-Mizer Products, Inc.

1.2 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 more Wood-Mizer locations.

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

Office Hours: All times are Eastern Standard Time.

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

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

Wood-Mizer will accept these methods of payment:

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

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

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

1

Introduction

Wood-Mizer Locations

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

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

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

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

1.3 Specifications

Model: LT10 Rev. B3.02+

Dimensions:		Metric
	Length: 14'-4"	4.36m
	Width: 5'-5"	16.5m
	Height (Ground To Mast): 5'-5 1/2"	16.6m
	Height (Max Head Position): 6'-5"	1.95m
	Bed Height (Ground To Bed): 11'-1/4"	3.36m
	Blade Length: 144"	3.65m

Weights: Basic Unit(with heaviest power option):

Cutting Capacity:		
	Length: 11'-10"	3.6m
	Diameter: 24"	0.6m
	Maximum Log Weight: 3500 lbs	1587kg
	Max Clamp Width (from stop block): 20"	0.5m
	Max Throat Width (guide to guide): 20"	0.5m
	Max Cant Width (outer guide to stop block): 18 1/8"	0.46m
	Min. Cut Height: 1"	25.4mm
	Max. Cut Height: 22 5/8"	0.57m
	Maximum Throat Depth: 8 7/16"	0.21m

Power Unit:	G7	G10
	Manufacturer: Kohler	Briggs & Stratton
	Fuel: gas	gas
	Horsepower Rating*: 7	14.5
	Weight (lbs)*: 38.7	50.4
	Cooling System*: air	air
	Noise Level (dba)*:	102 (Full Load, @3600rpm) 97.5 (No Load, @3600rpm)
	Fuel Consumption(gallon/hour)*:	0.771 (Full Load, @3600rpm) 0.674 (75% Load, @3600rpm) 0.471 (50% Load, @3600rpm) 0.332 (25% Load, @3600rpm)

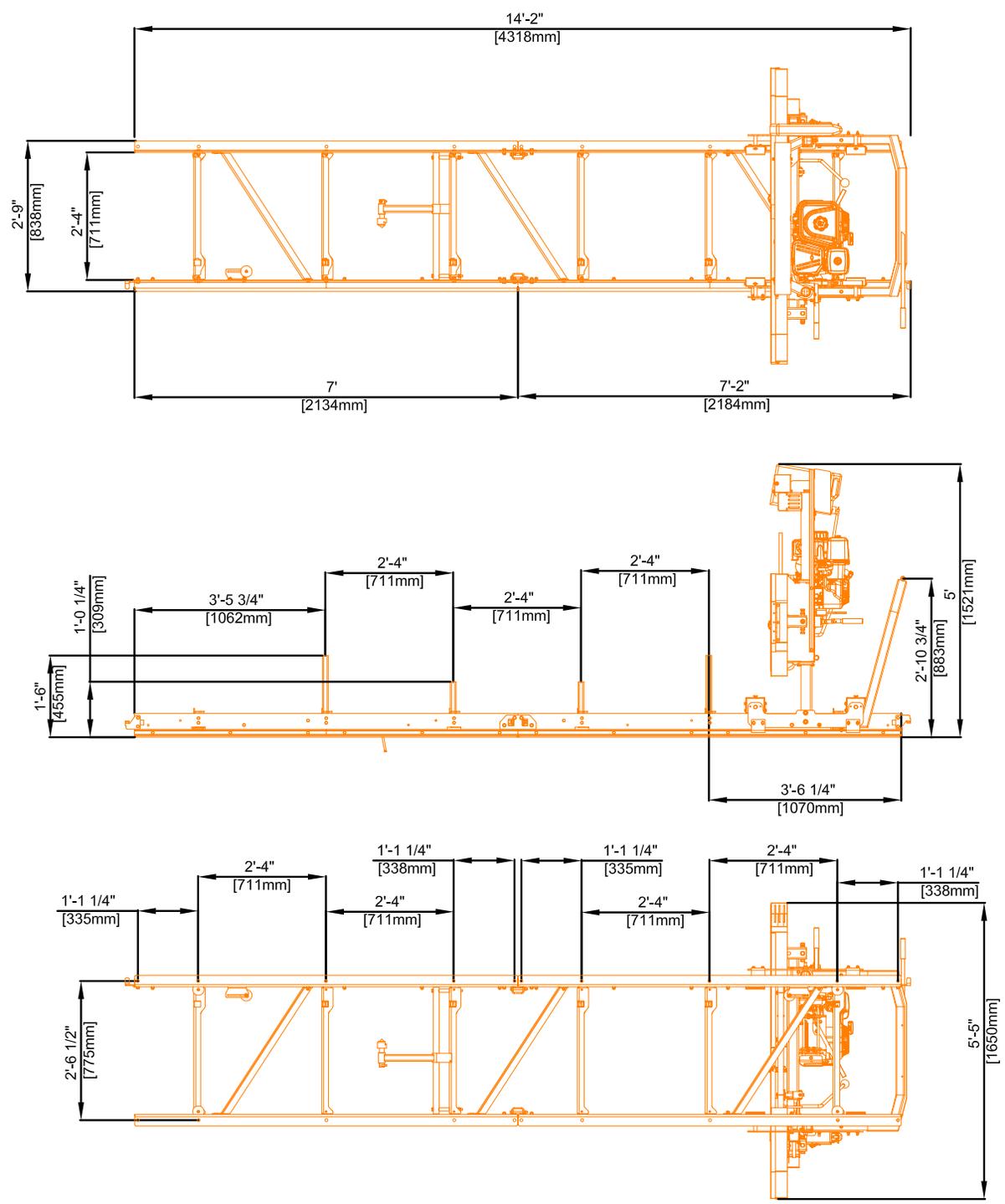
Rates:
Hourly Production (Average range w/experienced 160 bd ft/hr operators/average size logs):

*Manufacturer's Specification

1 Introduction

LT10 Dimensions

LT10 Dimensions



Model: LT10 Rev. B1.00 - B3.01

Dimensions:

Length: 14'-4"
 Width: 5'-4 3/4"
 Height (Ground To Mast): 5'-10 3/4"
 Height (Max Head Position): 75 1/2"
 Bed Height (Ground To Bed): 4 51/64" (Unblocked)
 Blade Length: 144"

Weights:

	G7	G10
Basic Unit (Wet):	544 lbs	563.1 lbs

Material Capacity:

Max. Length: 11'-0" (Can be extended with additional beds)
 Min. Length: 2'-6"
 Log Diameter: 24"
 Max Clamp Width (from stop block): 19"
 Max Throat Width (guide to guide): 19 1/2"
 Max Cant Width (outer guide to stop block): 17 3/4"

Engine:

	G7	G10
Manufacturer:	Briggs	Briggs
Fuel:	Gas	Gas
Horsepower Rating:	7.8	10.4
Weight:	33.7 lbs	52.8 lbs
Idle Speed:	1750 RPM	1750 RPM
High Throttle Speed (No Load):	3750 RPM	3750 RPM
Noise Level - @ operator position:		
Noise Level - 20 feet away:		
Blade Speed (No Load):		
Fuel Consumption (per hour):		
Cooling System:	Air	Air
Drive Shaft O.D.:	1"	1"
Drive Pulley O.D.:	3.95"	3.95"
Drive Belt:	B75.5	B75.5
Blade Braking:	4 Seconds	4 Seconds
Oil Capacity w/Filter:	.625 qts. (.6 liters)	.875 qts. (.8 liters)
Battery:	N/A	N/A

Rates:

Hourly Production (Average range w/experienced operators/average size logs): Up to 100 bdf.

Options:

Bed Section: 83 lbs.

1**Introduction***LT10 Dimensions*

Model: LT10 Rev. A1.00 - A2.00**Dimensions:**

Length: 14'-4"
Width: 5'-4 3/4"
Height (Ground To Mast): 5'-10 3/4"
Height (Max Head Position): 75 1/2"
Bed Height (Ground To Bed): 4 51/64" (Unblocked)
Blade Length: 144"

Weights:

G7.8
Basic Unit (Wet): 559 lbs.

Material Capacity:

Max. Length: 11'-0" (Can be extended with additional beds)
Min. Length: 2'-6"
Log Diameter: 24"
Max Clamp Width (from stop block): 19"
Max Throat Width (guide to guide): 19 1/2"
Max Cant Width (outer guide to stop block): 17 3/4"

Engine:

G7.8
Manufacturer: Generac
Fuel: Gas
Horsepower Rating: 7.8
Weight: 48 lbs.
Idle Speed: 850 RPM
High Throttle Speed (No Load): 3600 RPM

Noise Level - @ operator position: 98 dBA
Noise Level - 20 feet away: 72 dBA
Blade Speed (No Load): 3730 sfpm
Fuel Consumption (per hour): 1/2 Gal.
Cooling System: Air
Drive Shaft O.D.: 1"
Drive Pulley O.D.: 3.95"
Drive Belt: B74
Blade Braking: 4 Seconds
Oil Capacity w/Filter: .69 qts. (.65 liters)
Battery: N/A

Rates:

Hourly Production (Average range w/experienced operators/average size logs): 55-100 bdft.

Options:

Bed Section: 83 lbs.

1.4 Customer and Sawmill Identification

Each Wood-Mizer LT10 sawmill is identified with a model number, revision, and serial number (see the figure below).

MFG BY/ FABRIQUÉ PAR: WOOD-MIZER PRODUCTS, INC. 8180 W. 10th St. Indianapolis, IN 46214-2400 U.S.A. 317/ 271-1542 Or 800/ 553-0182	
Model No.:	LT10 G7.8
Serial No.:	06050001
Rev.:	A1.00
Sawmill U.S. Patent Nos. 3,935,780 and 4,559,858; Brevet au Canada 1986 No. 1,211,684 Brevete 1986; Dry Kiln U.S. Patent Nos. 4,620,373 et 4,490,926. Other patents pending.	

SERIAL NUMBER TAG.

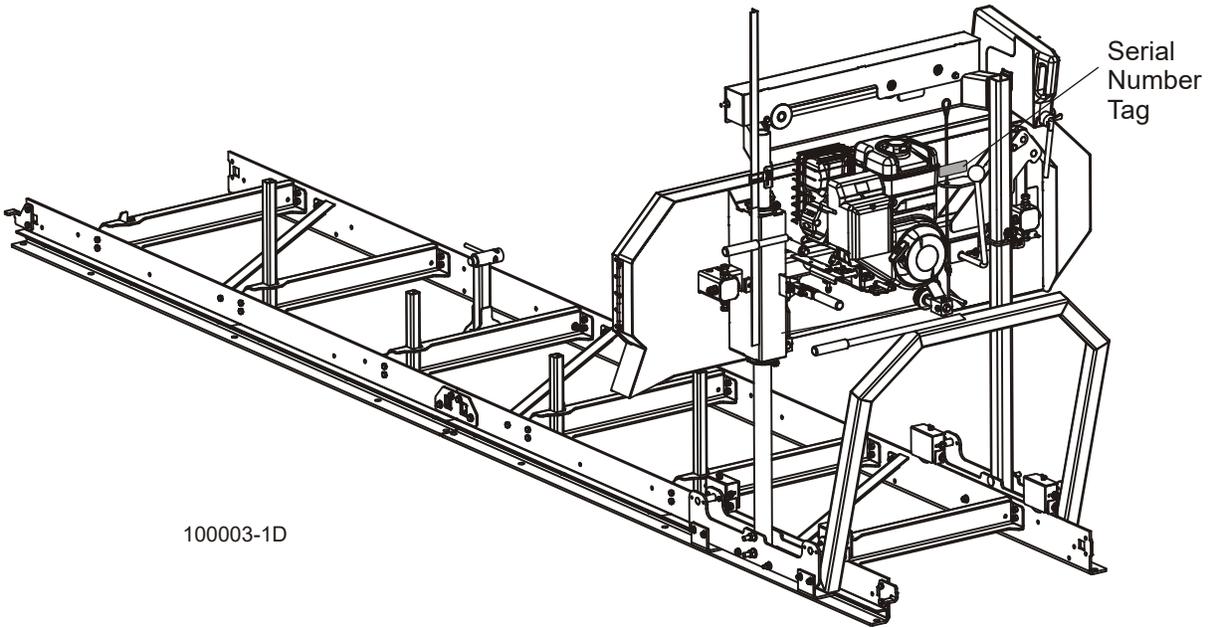
The model number includes the base model and the engine/motor configuration. The serial number contains the month and year of manufacture and a sequence number. The revision number helps identify the exact design of the equipment. See the figure for a description of the model, serial, and revision numbers.

Model Number	LT10 Basic Sawmill I.D.	G7.8 Engine/Motor Configuration
Serial Number	0605 Month/Year of Manufacture	0001 Manufacture Sequence
Revision Number	A1. Major Revision Code	00 Minor Revision Code

MODEL, SERIAL, AND REVISION NUMBER DESCRIPTION.

1 Introduction
Customer and Sawmill Identification

The serial number tag can be found at the following location.



100003-1D

SERIAL NUMBER TAG LOCATION.

1.5 Warranty

Wood-Mizer® LLC
Limited Product Warranty

Wood-Mizer®

Wood-Mizer LLC (“Warrantor”), an Indiana corporation with its principal place of business at 8180 West Tenth Street, Indianapolis, IN 46214-2400 USA, warrants to the purchaser (“Purchaser”) that for the time periods specifically stated herein and subject to the terms, conditions and limitations stated herein, the equipment manufactured by the Warrantor will be free from defects in material and workmanship attributable to Warrantor so long as, during the warranty periods stated herein, the equipment is installed, operated and maintained in accordance with the instructions provided by Warrantor.

PRODUCT	MODEL CLASS	LENGTH OF WARRANTY		EFFECTIVE DATE
		USA & CANADA	NON USA & CANADA	
Portable Sawmills, Resaws, Edgers	LT, LX, HR, EG	Two years	One year	Date of purchase
Portable Sawmills with Chassis	LT28, LT35, LT40, LT50, LT70, LX450	Two years, excluding the chassis, which chassis shall have a five year warranty	One year	
Industrial Sawmills, Resaws, Edgers	WM, HR, EG, TVS, SVS, FS	One year	One year	Date of purchase or date of installation / training (if applicable), whichever occurs first, not to exceed 6 months from date of purchase
TITAN Industrial	WB, TV, HR, EG, EA, MR	One year	One year	
Material Handling	TWC, IC, TD, LD, GC, CR, CB, CC	One year	One year	
Blade Maintenance Equipment	BMS, BMT, BMST	One year	One year	Date of purchase
Options and Accessories	Various	One year ¹	One year ¹	
Moulders, Kilns	MP, SD, KD	One year	One year	
Pallet Dismantler	PD	One year	One year	
Log Splitter	FS	One year	One year	
Replacement Parts	Various	90 days	90 days	

¹ Warranty on Options will match the warranty on the primary equipment when purchased on same invoice.

EXCLUSIONS FROM 90 DAY, LIMITED ONE YEAR AND TWO YEAR WARRANTY

Warrantor shall have **no** responsibility under this warranty for any wear components, including, but not limited to: belts, blade guides, blades, electric motor brushes, drum switches, filters, fuses, hoses, bearings (excluding cylindrical drive bearings), bushings, cable carriers, and spark plugs. All wear components are furnished **“as is”**, without any warranty from Warrantor. This limited warranty does not cover any defects caused by

misuse, negligence, alterations, damage due to overload, abnormal conditions, excessive operation, accident, or lack of performance of normal maintenance services.

Several components which are used in the manufacture of the equipment but not manufactured by Warrantor, such as cant hooks, power plants, laser sights, batteries, tires, and trailer axles have warranties provided by the original equipment manufacturer (written copies available upon request). Warrantor does not separately warrant such items. Components or equipment manufactured by third parties are not covered by this warranty. Warrantor, however, will provide reasonable assistance to the Purchaser to make claims against any warranties applicable to such component parts as provided by such original equipment manufacturers. Components or equipment manufactured by third parties are not covered by this Warranty.

FIVE YEAR LIMITED CHASSIS WARRANTY

The limited five year chassis warranty, described above, DOES NOT extend to (a) any damage stemming from accident, improper towing, overload, abuse, misuse, abnormal conditions, negligence, excessive operation, or lack of maintenance, (b) rust caused by exposure to corrosive atmospheric conditions, or (c) the sawmill head, carriage, axle, brakes, or any hydraulic or electrical components attached to the chassis.

WARRANTOR'S OBLIGATIONS AS TO DEFECTS

In the event that the equipment fails to perform due to defective materials or workmanship attributable to Warrantor under normal use and service within the established warranty period, Purchaser's sole and exclusive remedy and Warrantor's sole liability shall be to replace or repair, in Warrantor's sole and subjective discretion, any defective part at Warrantor's principal place of business without cost to the Purchaser if such defect exists. The determination of whether a product is defective shall be made by Warrantor in Warrantor's sole and subjective discretion. The Purchaser must notify Warrantor prior to shipping any defective part. Warrantor, at its sole discretion, may cover expenses incurred in shipping the defective part to Warrantor for evaluation; provided, however, that Warrantor will not be responsible for labor, travel time, mileage, removal, installation, and/or incidental or consequential damages. However, any part in excess of 140 pounds must be returned by the Purchaser to the Warrantor's nearest authorized facility at the Purchaser's expense, if return is requested by Warrantor. Warrantor shall have a reasonable time within which to repair or replace the defective part. If Warrantor determines that the product is not defective under the terms of this warranty in Warrantor's sole and subjective discretion, then Purchaser shall be responsible for any expenses incurred by Warrantor in returning the equipment to the Purchaser.

LIMITATIONS AND DISCLAIMERS OF OTHER WARRANTIES

EXCEPT FOR THE EXPRESS WARRANTY PROVISIONS STATED ABOVE, WARRANTOR DISCLAIMS ALL WARRANTIES, EXPRESS AND/OR IMPLIED, INCLUDING AND WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY, AND FITNESS FOR A PARTICULAR PURPOSE, NONINFRINGEMENT AND TITLE. No representation or other affirmation of fact by representatives of Warrantor, whether verbal or in writing, including photographs, brochures, samples, models, or other sales aids, shall constitute a warranty, or any other basis, for any legal action against Warrantor. There are no other representations, promises, agreements, covenants, warranties, guarantees, stipulations or conditions, expressed or implied, by Warrantor, except as expressly set forth herein. THE PURCHASER AND ANY INTENDED USER OR BENEFICIARY OF THIS EQUIPMENT, SHALL NOT BE ENTITLED TO RECOVER ANY INDIRECT, SPECIAL, PUNITIVE, EXEMPLARY, CONSEQUENTIAL, SPECIAL, OR INCIDENTAL DAMAGES OR LOSSES, INCLUDING BUT NOT LIMITED TO, DAMAGES OF LOST PRODUCTION, LOST REVENUE, LOST PRODUCT, LOST PROFITS, LOST BUSINESS, LOSS OF USE, LOSS OF GOODWILL, OR BUSINESS INTERRUPTION, FROM WARRANTOR FOR ANY REASON WHATSOEVER INCLUDING, WITHOUT LIMITATION, WARRANTY OR DEFECT IN THE PRODUCT REGARDLESS OF THE SOLE, JOINT, AND/OR CONCURRENT NEGLIGENCE, BREACH OF CONTRACT, BREACH OF WARRANTY, STRICT LIABILITY IN TORT OR STATUTORY CLAIMS, OR OTHER LEGAL FAULT, OR RESPONSIBILITY OF EITHER WARRANTOR OR PURCHASER OR ITS EMPLOYEES OR AGENTS. Warrantor does not warrant that its equipment meets or complies with the requirements of any particular safety code or governmental requirements.

Defective items, replaced under the terms of this warranty, become the property of Warrantor.

DESIGN CHANGES

Warrantor reserves the right to change the design of its products from time to time without notice and without obligation to make corresponding changes in or to its products previously manufactured.

RIGHTS OF PURCHASERS

The validity and effect of this limited warranty, as well as its interpretation, operation and effect, shall be determined exclusively by the principles of law and equity of the State of Indiana, USA. This limited warranty gives Purchaser specific legal rights. Purchaser may also have other rights, which may vary from state to state. Some states may not allow limitations as to the duration of implied warranties or to the exclusion or limitation of incidental or consequential damages, therefore some of the limitations and exclusions detailed set forth above may not apply. In the event that any one or more of the provisions of this warranty shall be or become invalid, illegal or unenforceable in any respect, the validity, legality and enforceability of the remaining provisions of this warranty shall not be affected thereby.

INTERPRETATIONS

This Warranty constitutes the entire warranty agreement between Warrantor and Purchaser and supersedes any prior understandings or agreements pertaining to the same subject matter. This warranty cannot be amended, except in writing, which refers to this warranty that is signed by both Warrantor and Purchaser.

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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.



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



OBSERVE SAFETY INSTRUCTIONS



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

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

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

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



WEAR SAFETY CLOTHING



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

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



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



KEEP SAWMILL AND AREA AROUND SAWMILL CLEAN



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

HANDLE FUEL/LUBRICANTS SAFELY



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

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



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

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



DISPOSE OF SAWING BY-PRODUCTS PROPERLY



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

CAUTIONS FOR SAWMILL SETUP



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

CHECK SAWMILL BEFORE OPERATION



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

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



WARNING! Do not operate the sawmill without the retaining bracket properly installed. The saw head may tip and fall from the sawmill resulting in possible injury or damage to the machine.

WARNING! Use both hands to operate the blade tensioner handle. Failure to do so may result in injury.

KEEP PERSONS AWAY



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

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

KEEP HANDS AWAY



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

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

of your engine are especially hot during and following operation. Contact with hot engine components can cause serious burns. Therefore, never touch or perform service functions on a hot engine. Allow the engine to cool sufficiently before beginning any service function.

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

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



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

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

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

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

CAUTIONS FOR GAS OR DIESEL ENGINE OPERATION



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

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

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

KEEP SAFETY LABELS IN GOOD CONDITION



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



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

USE CAUTION WHEN WORKING WITH HEAVY LOGS



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

UP/DOWN SYSTEM SAFETY



WARNING! Release pressure from the up/down assist prior to performing any service to the assembly. Failure to do so may result in injury or damage to the equipment.



WARNING! The gas spring cylinders are pressurized. Disassembly of cylinder may result in injury or damage to the cylinder.

SECTION 3 SETUP

3.1 Required Tools

The following materials and tools are required to assemble and setup the sawmill for operation:

- **Rev. A1.00 - B3.03:** 2 14' (4.2m) Wood Beams (for standard two-bed setup; add 7' (2.1m) for each additional bed section). [See Section 3.2](#) for beam dimensions.
- **Rev. A1.00 - B3.03:** 5/16" x 1 3/4" Lag Bolts and Washers (minimum 4 per bed section).
- Two each wrenches: 7/16", 3/8", 1/2", 9/16" & 3/4" (9/16" ratchet/socket required).
- Rubber Mallet.
- Phillips Head Screwdriver.
- Shim material (standard door shims work well).
- Large Square (20" minimum).
- 3/16" Hex Wrench.
- Blade Guide Alignment Tool.



IMPORTANT: The blade guide alignment tool is attached to the idle side blade wheel. Open the blade housing covers and remove the blade guide alignment tool before performing sawmill setup.

3.2 Site Preparation

Prepare the site where the sawmill is to be operated. The ground should be firm and relatively level. There should be enough room around the sawmill for operators, sawdust removal, log loading and board removal.

Rev. A1.00 - B3.03: The sawmill must be elevated off the ground at least 4 1/2" (11.4cm) to allow proper clearance under the bed frame for the log clamp. Two 14' (4.2m) long wood beams should be used for this purpose. Use beams that are relatively straight with a minimum amount of bow or twist. Be sure the width of the beam for the operator-side of the sawmill allows clearance between the side supports and mast retainer brackets. Space the beams 24" (61cm) apart (inside to inside).

See Figure 3-1.

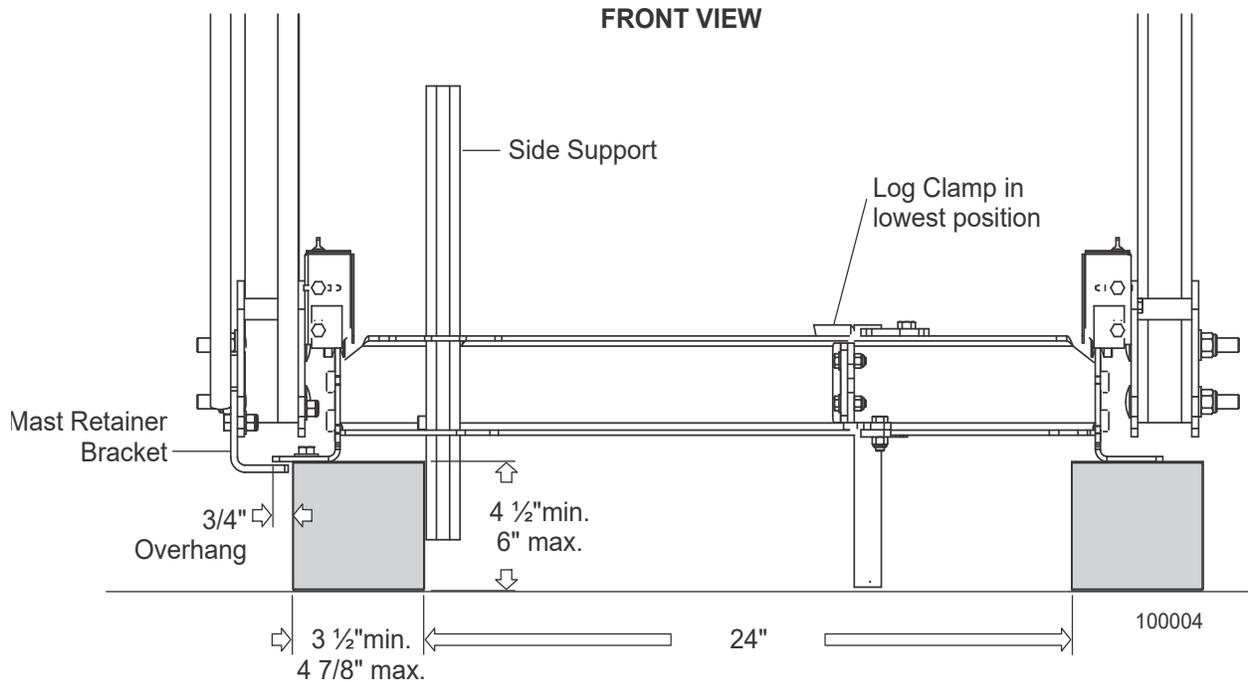


FIG. 3-1 REV. A1.00 - B3.03

3.3 Bed Assembly

B4.00+: Assembly includes two track rails, three bed rails and two catch rail plates per section.

NOTE: Be sure to orient the bed rails with the bed stops on the **operator side** as shown.

See Figure 3-2.

1. Secure the bed rails to the track rails with 3/8-16 x 1" hex head bolts and nylon lock nuts.
2. Install the warning decals to the track rail.

3 Setup

Bed Assembly

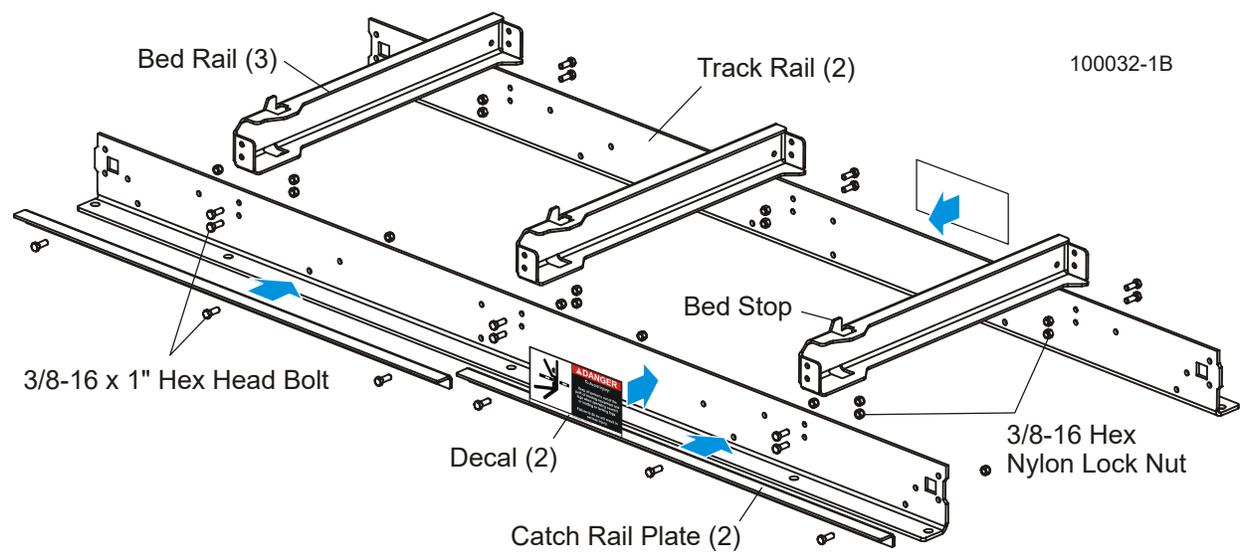


FIG. 3-2 REV. B4.00+

See Figure 3-3. Rev. A1.00 - B3.03: Assemble each bed section as shown using two track rails and three bed rails per section. Be sure to orient the bed rails with the bed stops on the operator side as shown. Insert the tabs on each end of the bed rails into the slots of the track rails. If necessary, use a rubber mallet to seat the rails together. After the bed rails are installed, assemble 3/8-16 x 1" hex head bolts and nylon lock nuts to secure bed rails to the track rails.

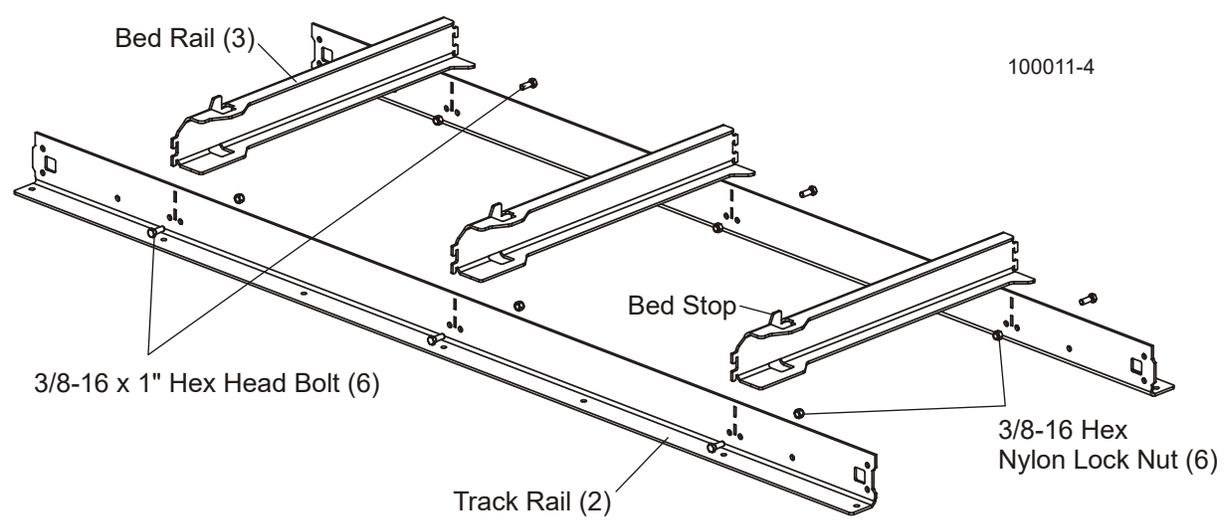


FIG. 3-3 REV. A1.02 - B3.03

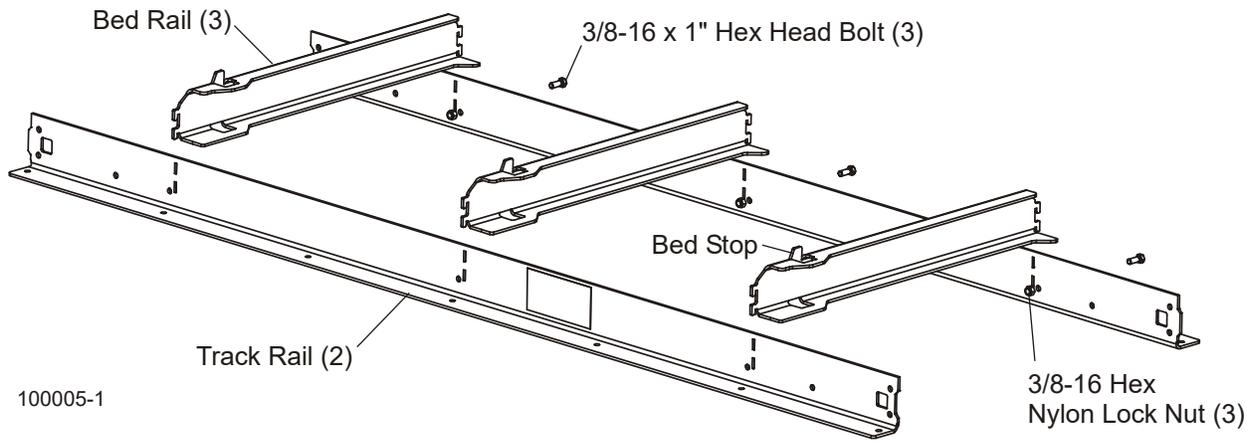


FIG. 3-3 REV. A1.00 - A1.01

3 Setup

Bed Assembly

- See Figure 3-4.**
3. Connect the bed sections using two connecting plates, two clamp plates and hardware as shown. 5.
 4. Be sure the track rails of each bed section are aligned before tightening the bolts.
 5. Install the three cross brace plates to the bed sections as shown. **Rev. B4.00+:**

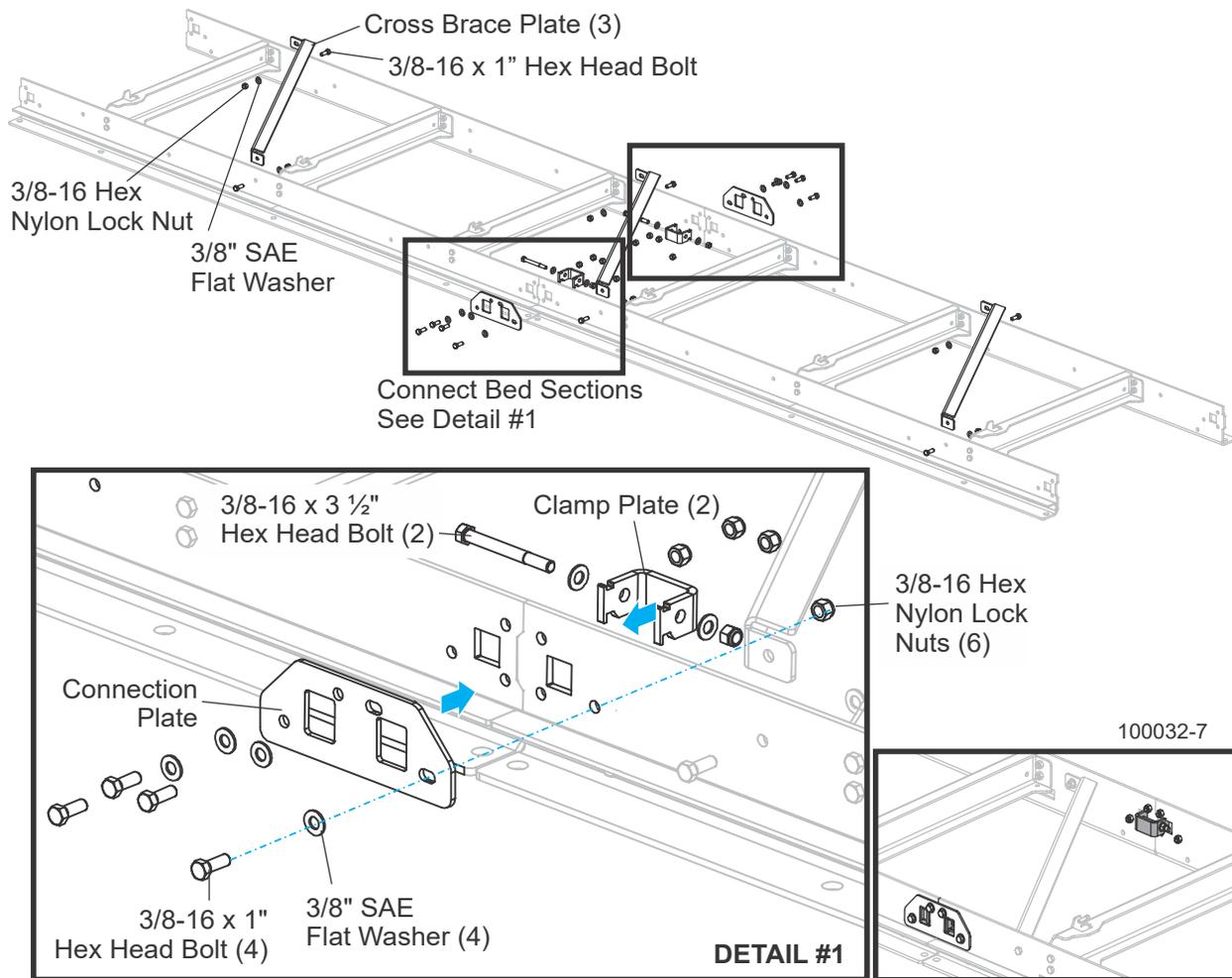


FIG. 3-4

See Figure 3-5.

6. Run a string along one side of the track rail.
7. Place equal size objects between the string and track rail at each end of the bed (wrench sockets work well for this).
8. Measure the distance between the string and the track rail at several points along the length of the bed.
9. Use shims underneath the track rail to lift the rail toward the string where necessary.

3 Setup

Bed Assembly

See **Figure 3-6**. Repeat with the string along the opposite track rail. **Rev. A1.00 - B3.03:** Connect the bed sections using two connecting plates, four clamp blocks and hardware as shown. Be sure the track rails of each bed section are aligned before tightening the bolts. **NOTE:** Make sure the clamp blocks are pushed towards the center of the bed sections before tightening to create required space between the clamp blocks and the moving mast assembly installed later.

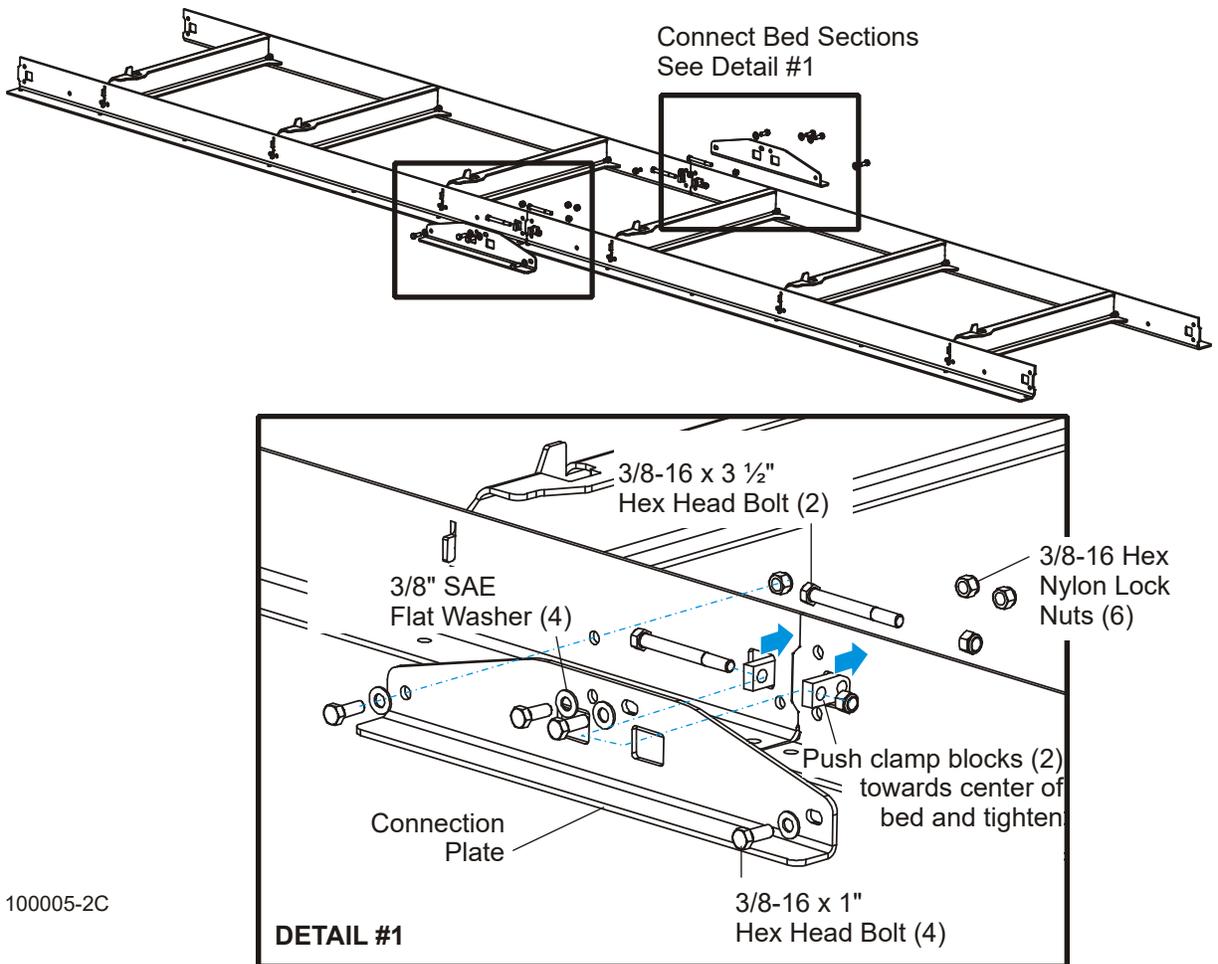


FIG. 3-6

See **Figure 3-7. Rev. A1.00 - B3.03:** Place the bed assembly on the support beams. Be sure the operator side of the bed overhangs the support beam by 3/4" to allow clearance for the mast retainer brackets. Secure the bed assembly to the beams with at least four

5/16" x 1 3/4" lag bolts and flat washers per bed section (do not tighten the lag bolts until the bed has been aligned and shimmed as explained in the next step).

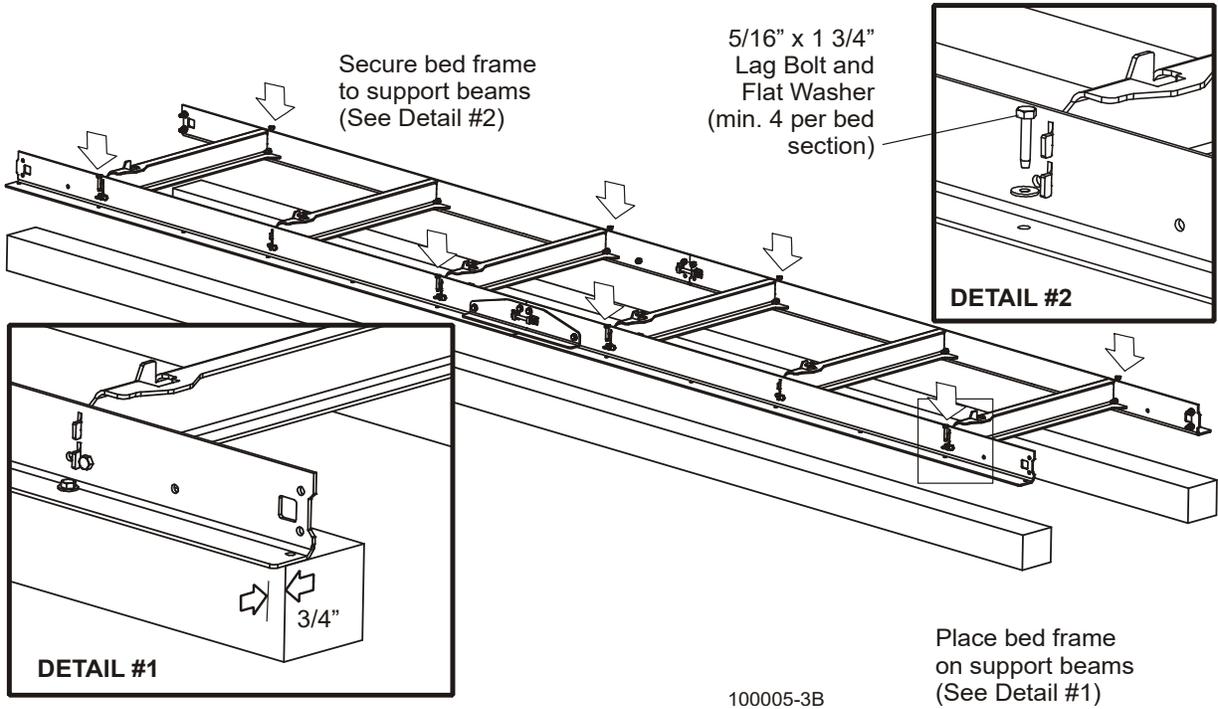


FIG. 3-7

3 Setup

Bed Assembly

10. Rev. B4.00+:

String track rail and
check along length of bed.
Shim if necessary (See Detail)

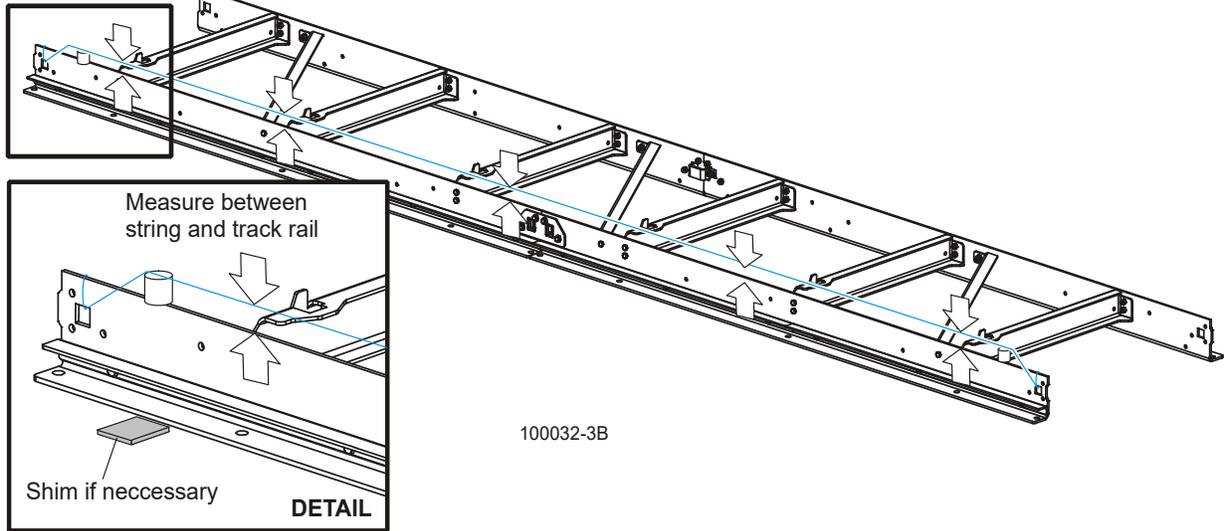


FIG. 3-7

See Figure 3-8. Rev. B4.00+:

11. Assemble the clamp to a bed rail near the center of the bed assembly with the provided hardware to secure the clamp to the bed rail.

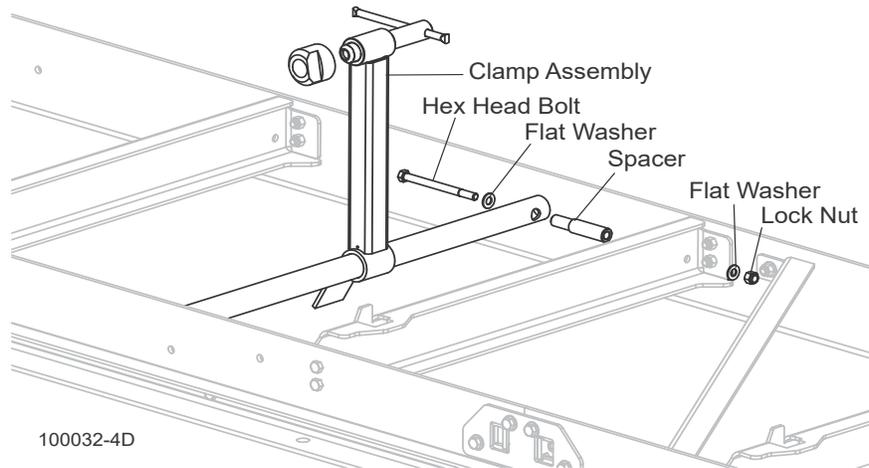


FIG. 3-8

3 Setup Bed Assembly

See Figure 3-9. Rev. A1.00 - B3.03: String one side of the bed assembly along the track rail. Place equal size objects between the string and track rail at each end of the bed (wrench sockets work well for this). Measure the distance between the string and the track rail at several points along the length of the bed. Use shims underneath the track rail to lift the rail toward the string where necessary. Repeat with the string along the opposite track rail. Tighten the lag bolts after the bed is shimmed level.

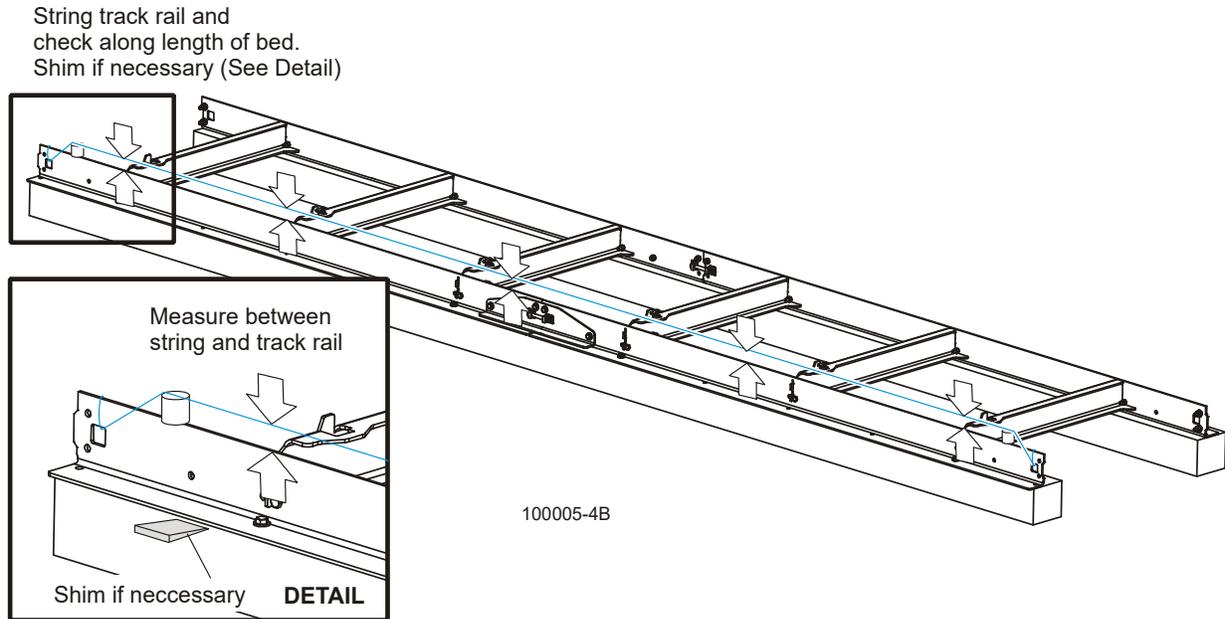


FIG. 3-9

See Figure 3-10. Rev. A1.00 - B3.03: Disassemble the side and bottom mount plates from the clamp assembly. Assemble the clamp to a bed rail near the center of the bed assembly. Reinstall the mount plates to secure the clamp to the bed rail.

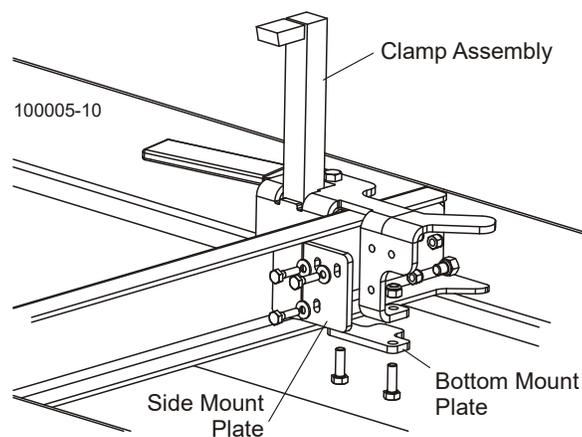


FIG. 3-10

3.4 Mast Assembly

Assemble the mast assembly to the bed frame.

1. Position the track rollers on top of the track rails.
2. Assemble the mast latch plates to the operator-side roller assembly using hex head bolts, flat washers and nylon lock nuts.
3. Adjust the mast latch plates vertically so they are close to, but not touching, the catch rail plates.

Sawmill without pre-assembled saw head prior to 4/08 only:

See Figure 3-11. Assemble the two track roller assemblies to the bottom of the mast assembly with four 1/2-13 x 4" carriage head bolts, flat washers and nylon lock nuts provided. Orient the roller assemblies so the track rollers face inward toward each other.

3 Setup

Mast Assembly

Leave the bolts loose until the mast is squared to the bed frame as described in the next step.

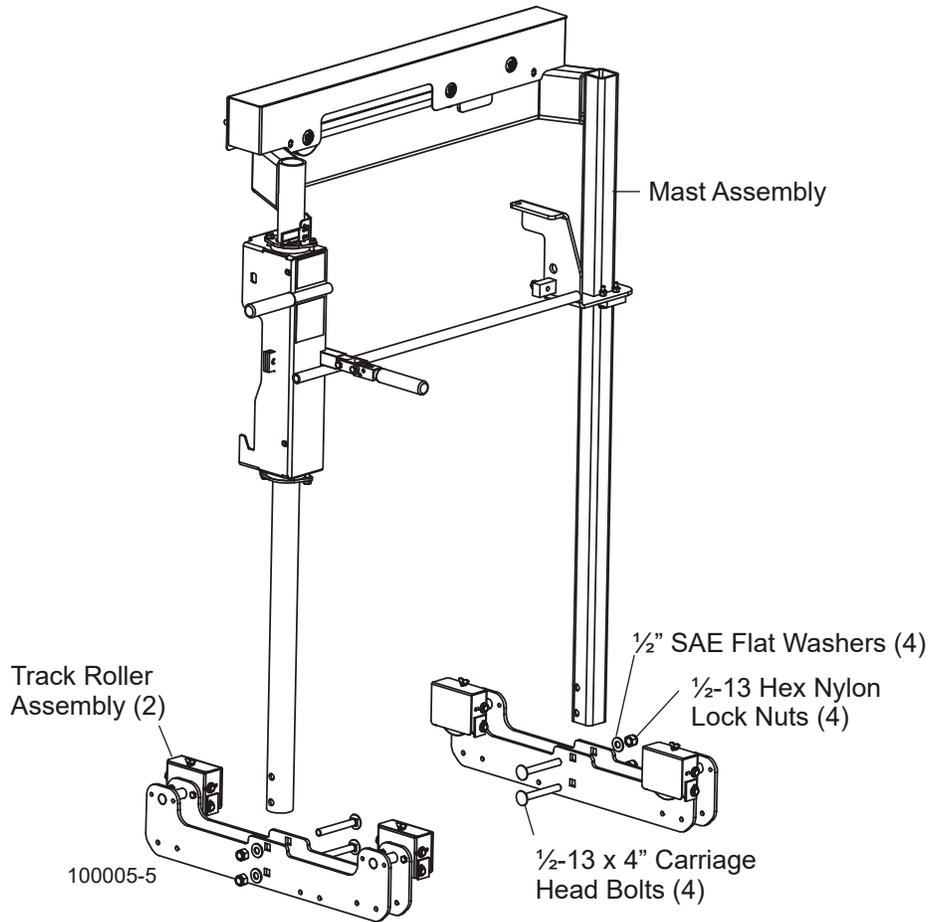


FIG. 3-11 PRIOR TO 4/08 ONLY

See **Figure 3-12, Rev. A1.00 - B3.03**: Install one end of the two provided feed cables to the mast roller assemblies as shown below. Use the provided hardware to secure the feed cables to the mast. **NOTE:** Do not tighten the hex nylon lock nut on the operator side of the mast assembly.

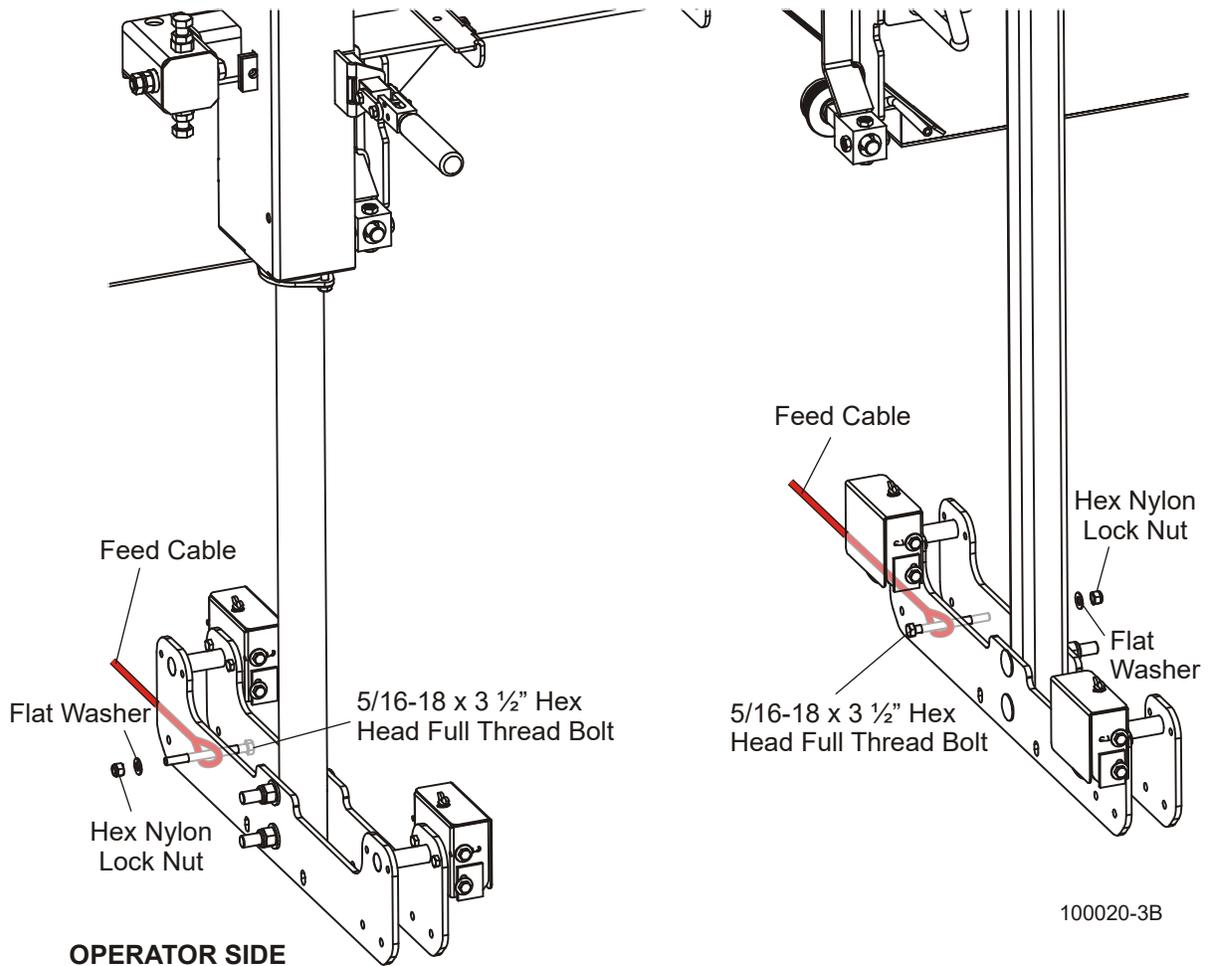


FIG. 3-12 REV. A1.00 - B3.03

IMPORTANT: Make sure to use the proper feed cable kit for the sawmill. The sawmill equipped with two bed sections requires two 365" (9.3m) long cables (003217) with eye bolts. Use two 533" (13.5m) long cables (003217-1) for the sawmill equipped with one bed extension, 701" (17.8m) long cables (003217-2) with two bed extensions, and 869" long cables (003217-3) with three bed extensions.

3 Setup

Mast Assembly

See Figure 3-13. Rev. A1.00 - B3.03: Install the cable mount plates to both sides of the front end of the lower roller weldment. Use the provided fasteners to secure the cable mount plates in place. **NOTE:** Make sure the hex head bolts are installed as shown below.

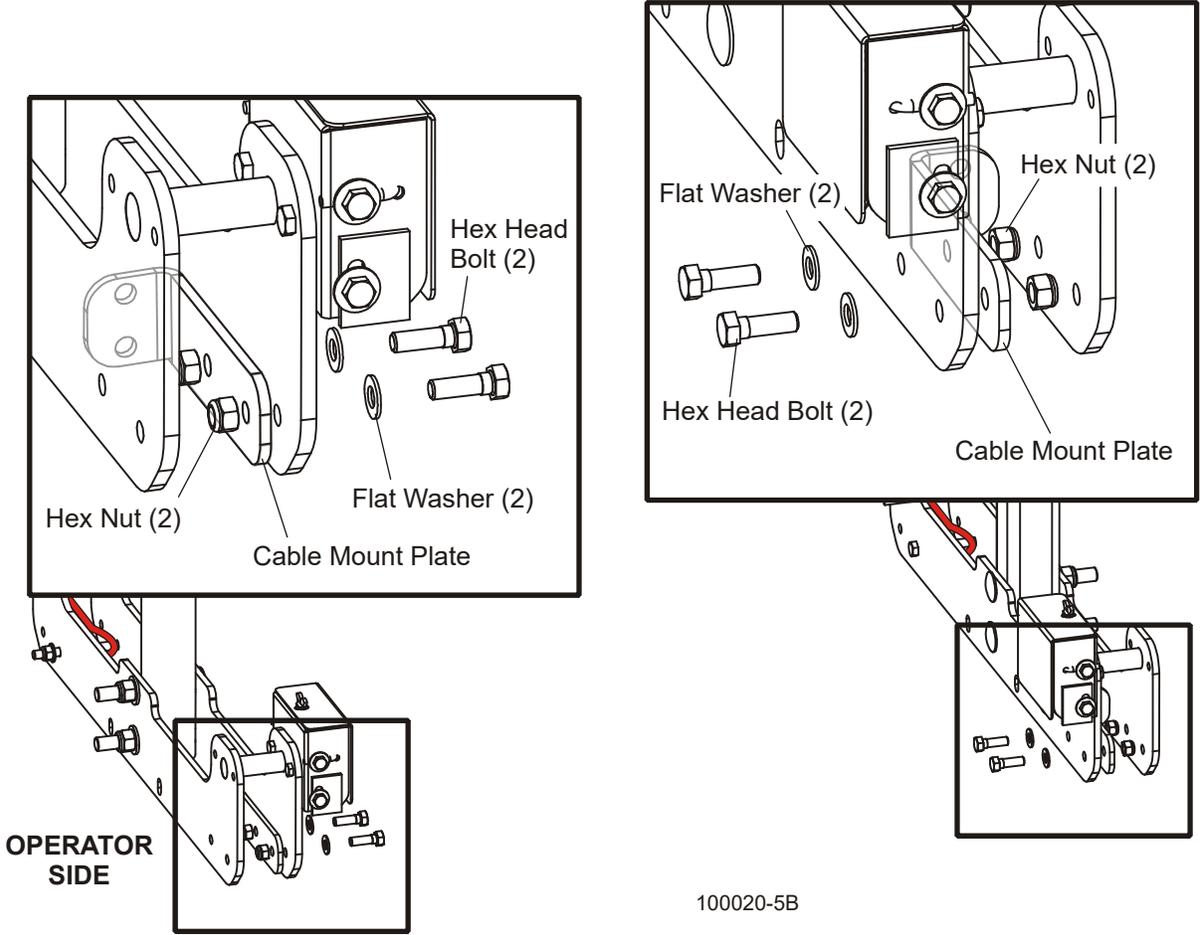


FIG. 3-13 REV. A1.00 - B3.03

See Figure 3-14. Rev. A4.00+:

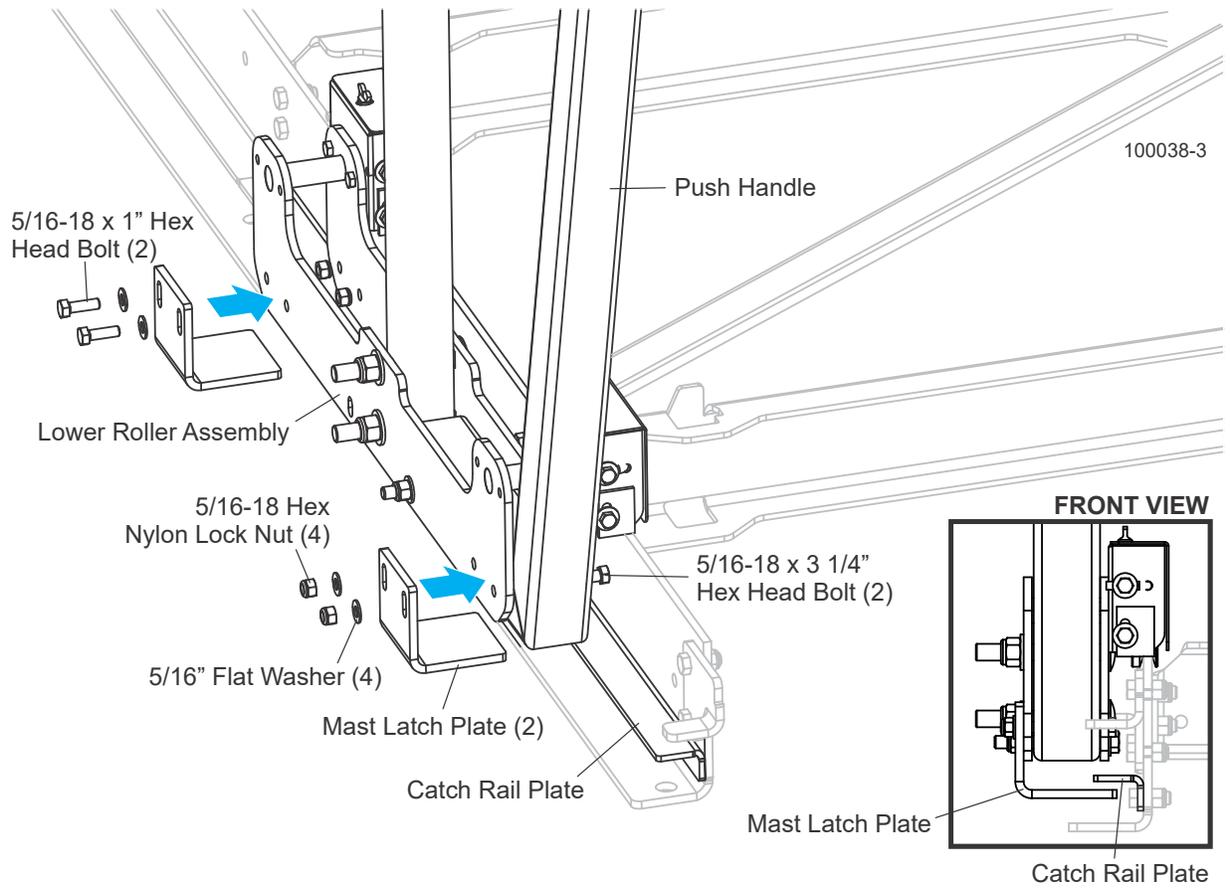


FIG. 3-14

3 Setup

Mast Assembly

See Figure 3-15. Rev. A4.00+:

4. Use a large square on the track rail to position the mast upright to true vertical.
5. When square, tighten the roller mounting bolts.
6. Repeat on the other side of the mast.
7. If necessary, adjust the track scrapers so they just touch the track rails.
8. Install the end stop plates to the bed sections as shown.

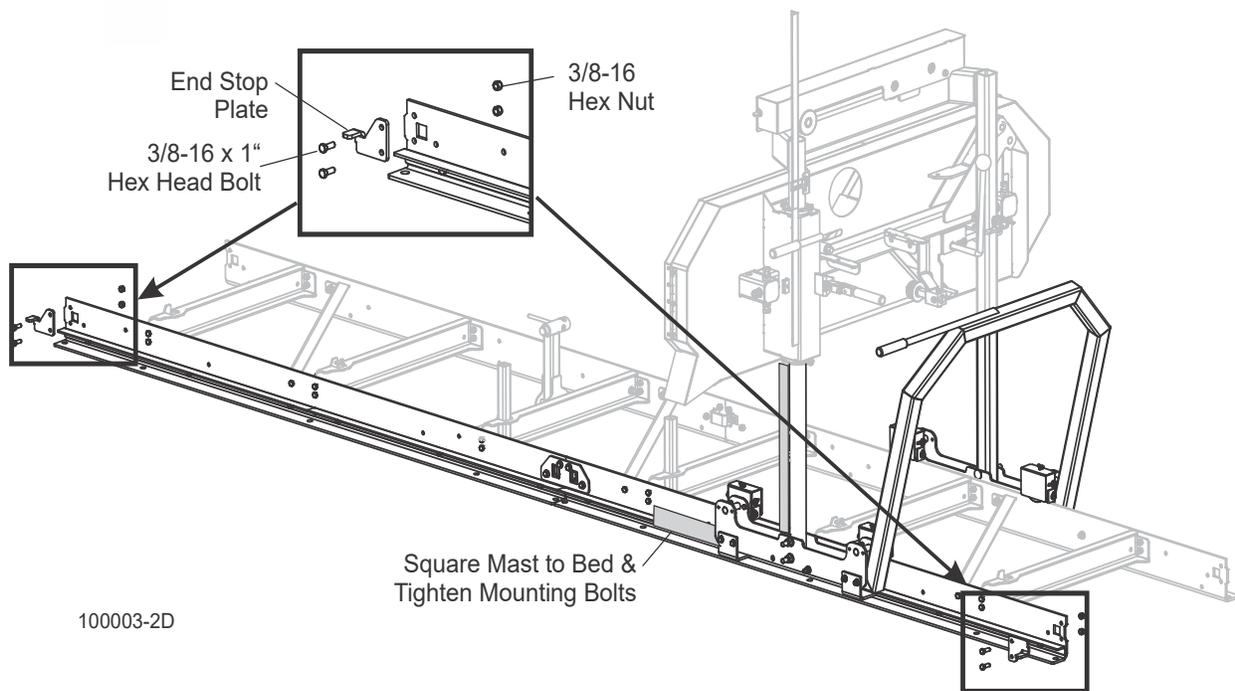


FIG. 3-15

See Figure 3-16. Rev. A1.02 - B3.03 (After 4/08): Assemble the mast assembly to the bed frame. Make sure the track rollers are positioned on top of the track rails. Set a large square on the track rail and position against the mast upright. Adjust the mast so it is against the square and tighten the roller mounting bolts. Repeat on the other side of the mast. Assemble the scale bracket to the carriage assembly with two 5/16-18 x 1" hex head bolts and flat washers. Assemble the feed handle and mast retainer brackets to the operator-side roller assembly using three 5/16-18 x 1" hex head bolts, two 5/16-18 x 1 1/4" hex head bolts, flat washers and nylon lock nuts. Adjust the mast retainers vertically so they are close to, but not touching, the track rail. Adjust the track scrapers if necessary so they just touch the track rails.

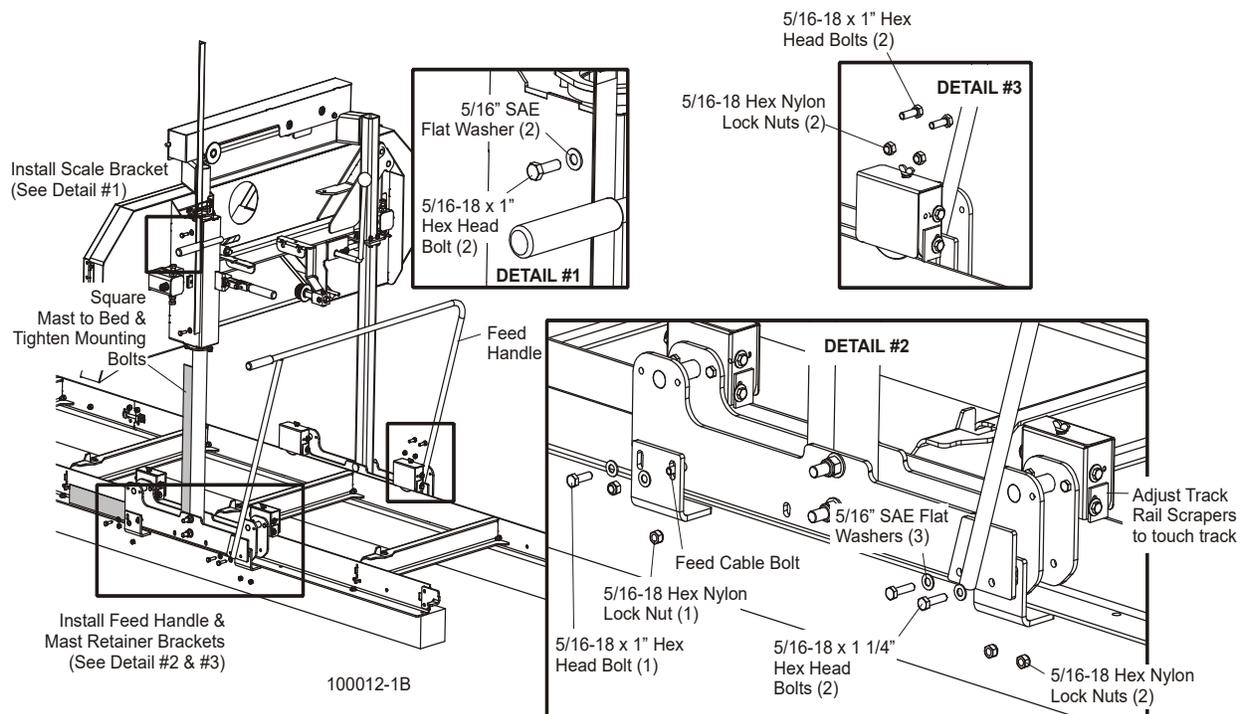


FIG. 3-16

3 Setup

Mast Assembly

See Figure 3-17. Rev. A1.02 - B3.03 (Before 4/08): Assemble the mast assembly to the bed frame. Make sure the track rollers are positioned on top of the track rails. Set a large square on the track rail and position against the mast upright. Adjust the mast so it is against the square and tighten the roller mounting bolts. Repeat on the other side of the mast. Assemble the scale bracket to the carriage assembly with two 5/16-18 x 1" hex head bolts and flat washers. Assemble the feed handle and mast retainer brackets to the operator-side roller assembly using four 5/16-18 x 1" hex head bolts, two 5/16-18 x 1 1/4" hex head bolts, flat washers and nylon lock nuts. Adjust the mast retainers vertically so they are close to, but not touching, the track rail. Adjust the track scrapers if necessary so they just touch the track rails.

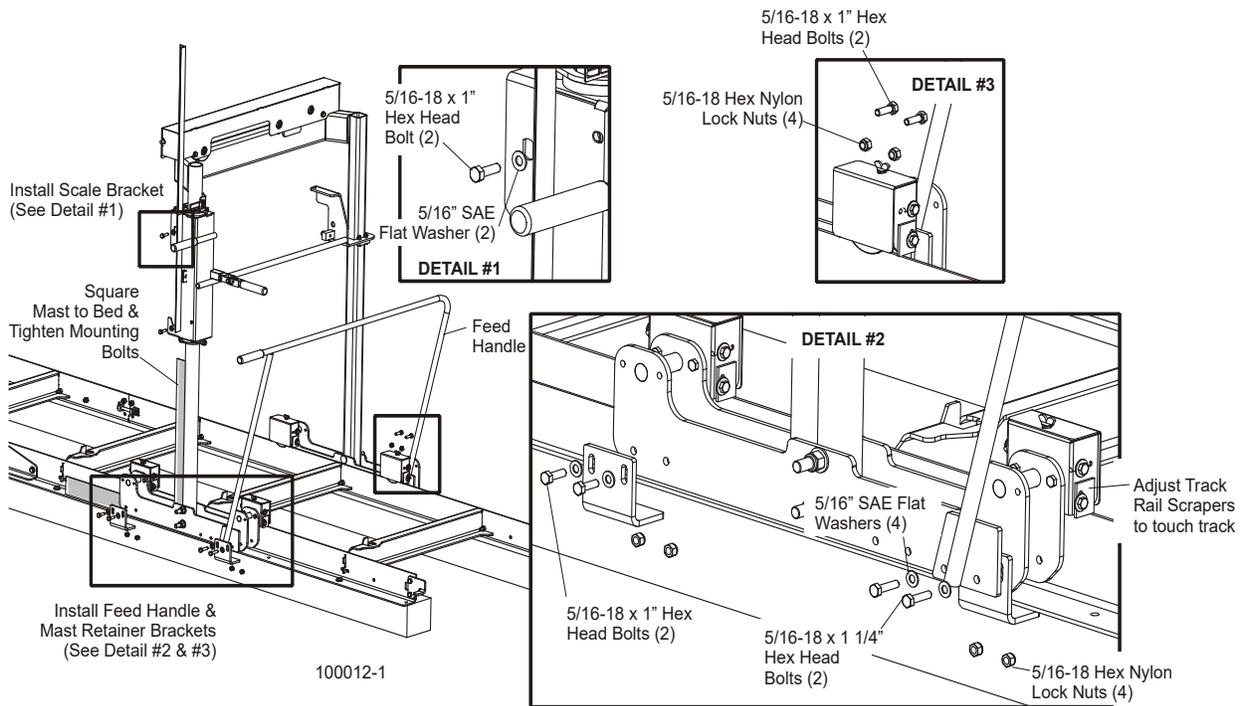


FIG. 3-17 PRE-ASSEMBLED SAW HEAD (AFTER 4/08) NOT SHOWN

See Figure 3-18. Rev. A1.00 - A1.01: Assemble the mast assembly to the bed frame. Make sure the track rollers are positioned on top of the track rails. Set a large square on the track rail and position against the mast upright. Adjust the mast so it is against the square and tighten the roller mounting bolts. Repeat on the other side of the mast. Assemble the scale bracket to the carriage assembly with two 5/16-18 x 1" hex head bolts and flat washers. Assemble the feed handle and mast retainer brackets to the operator-side roller assembly using eight 5/16-18 x 1" hex head bolts, flat washers and nylon lock nuts. Adjust the mast retainers vertically so they are close to, but not touching, the track rail. Adjust the track scrapers if necessary so they just touch the track rails.

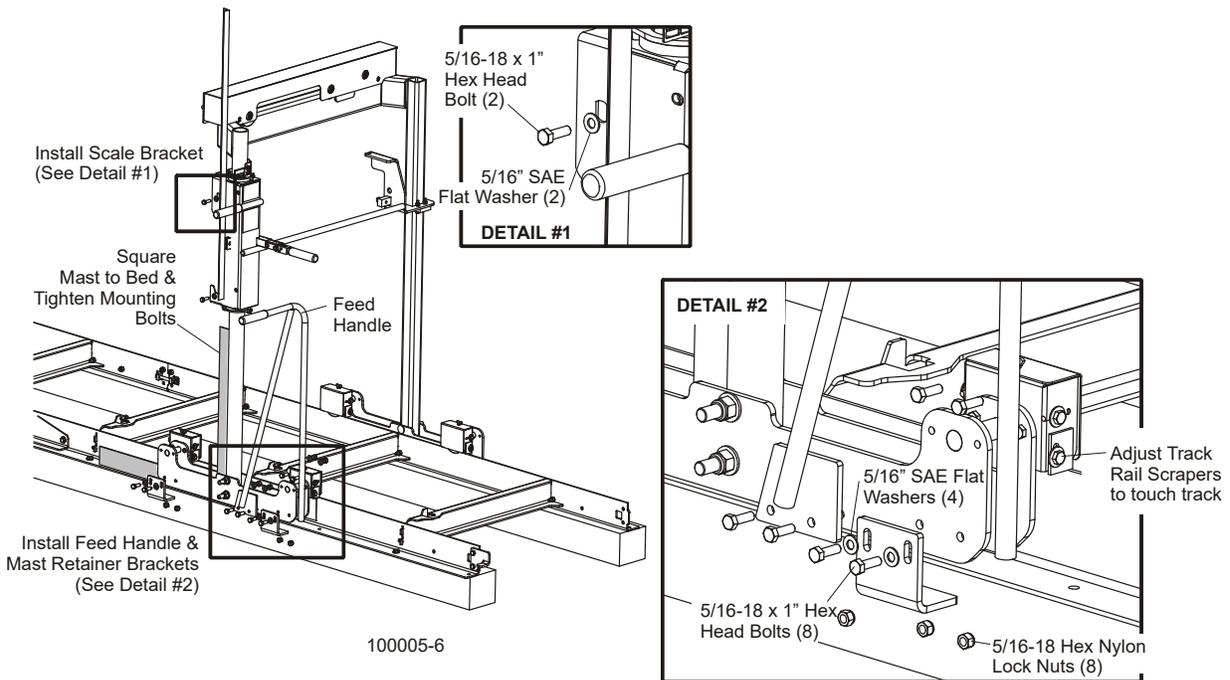


FIG. 3-18

3.5 Engine Assembly

The pulleys are mounted with split tapered bushings. These bushing have four holes -- two smooth holes for mounting and two threaded holes for dismounting.

See Figure 3-19.

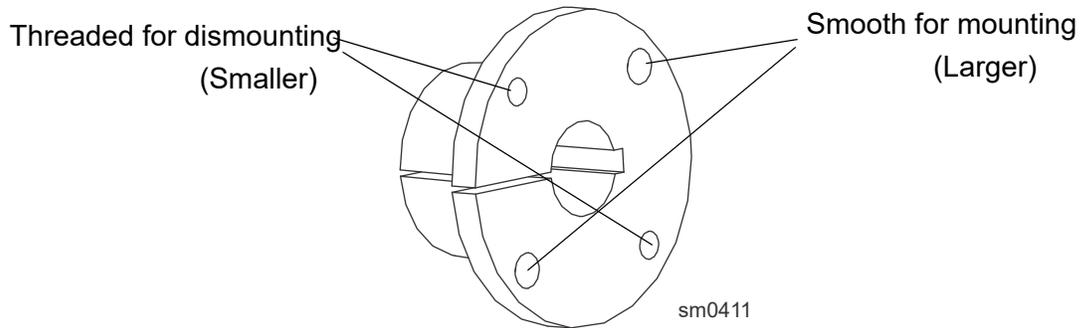


FIG. 3-19

See Figure 3-20. Sawmill without pre-assembled engine only (2/12 and later): Remove the engine from the box. Install the provided pulley and the bushing to the engine as shown below.

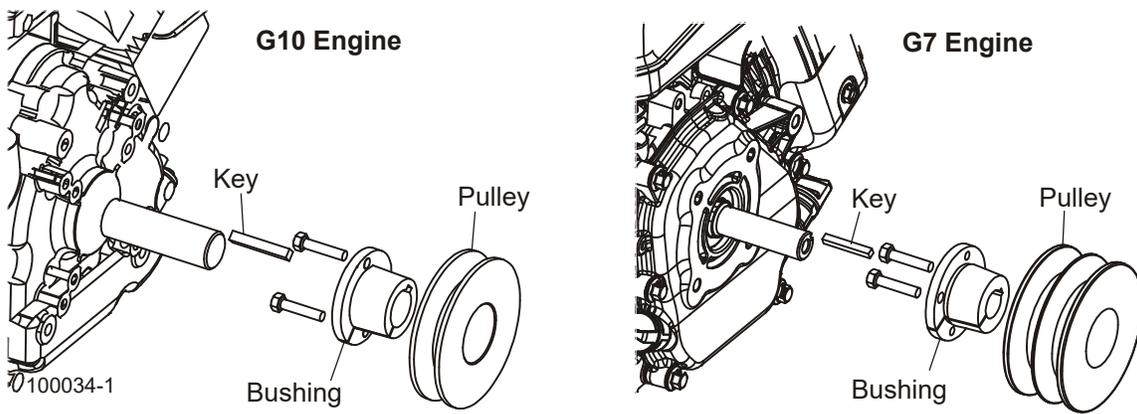


FIG. 3-20

See Figure 3-21. Sawmill without pre-assembled engine only (2/12 and later): Adjust and secure the pulley and the bushing to the engine shaft as shown below.

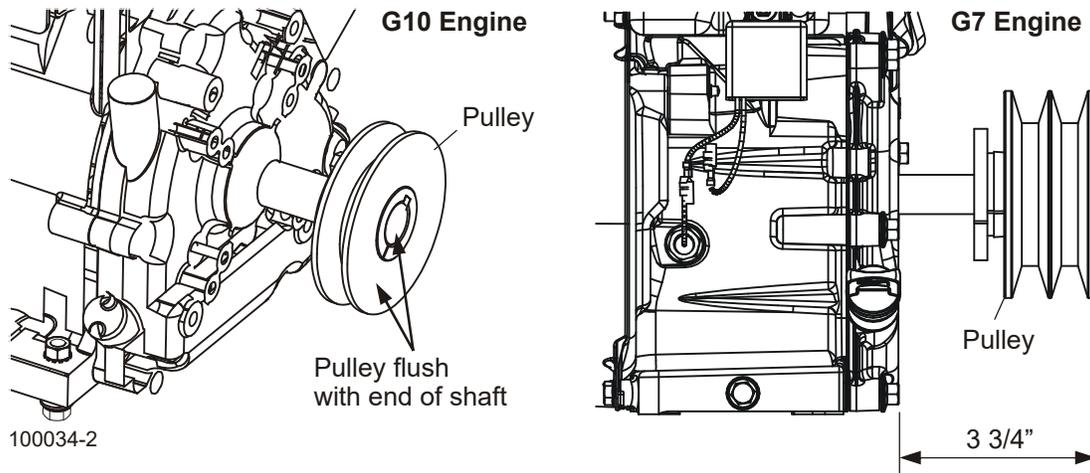


FIG. 3-21

Sawmill with pre-assembled saw head without engine Rev. B3.00 and later only:

See Figure 3-22. Place the engine on the mount plate, positioning the engine pulley through the hole in the saw head housing. Secure the engine to the mount plate with mounting hardware as indicated below:

G7 (7HP) (Briggs engine Rev. B3.00 - B3.01): Use four 5/16-18 x 1 1/2" hex head bolts, flat washers and nylon lock nuts.

G7 (7HP) (Kohler engine Rev. B3.02+): Use four 3/8-16 x 1 3/4" hex head bolts, eight flat washers and four nylon lock nuts.

G10 (10HP): Use four 5/16-18 x 1 1/2" hex head bolts, flat washers, split lock washers and hex nuts.

Before tightening the bolts, check the alignment of the engine pulley with the drive pulley.

- Open the blade housing cover and place a flat edge against both pulleys.
- Position the engine so both pulleys are aligned.
- Be sure the engine does not contact the saw head.
- Tighten the mounting bolts.
- Place the drive belt around the pulleys and check/adjust the drive belt tension. ([See Section 5.6](#))

3 Setup Engine Assembly

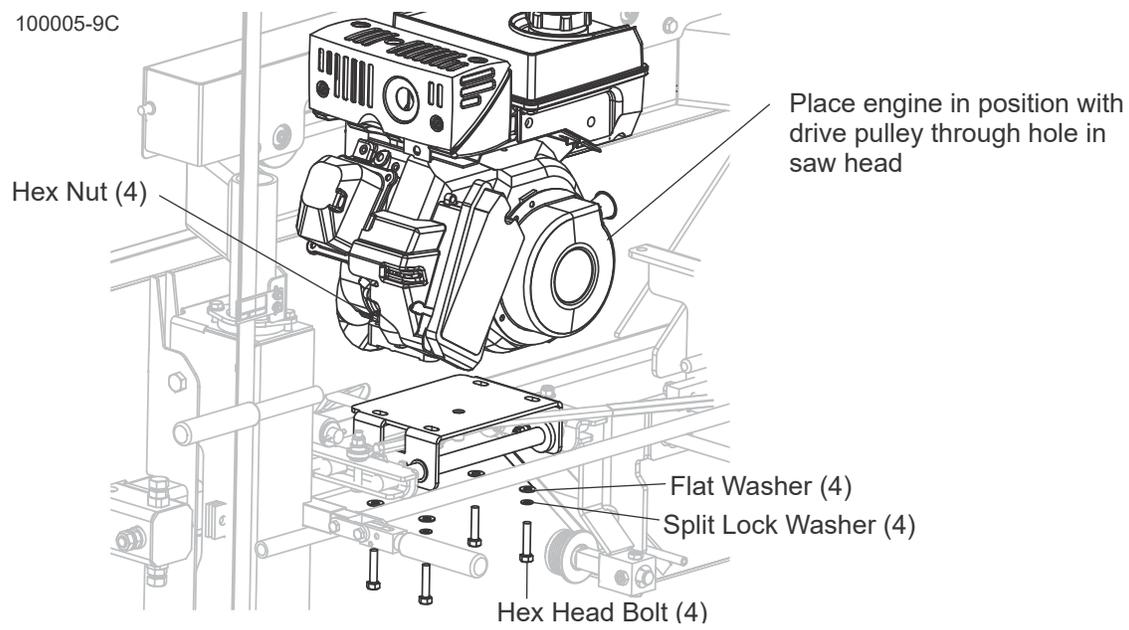


FIG. 3-22

Prior to 2/12 only: IMPORTANT! The engine is filled with engine oil by Wood-Mizer. Check  ke sure the engine oil level is correct. Add engine oil if necessary (see Engine manual for oil type).

2/12 and later only: **IMPORTANT!** Fill the engine with the provided engine oil. Check to make sure the engine oil level is correct. Add engine oil if necessary (see Engine Manual for oil type).

See Figure 3-23. Adjust the engine slide stop bolt so that the stop bolt head is at least 1/2" (13mm) away from the engine mount.

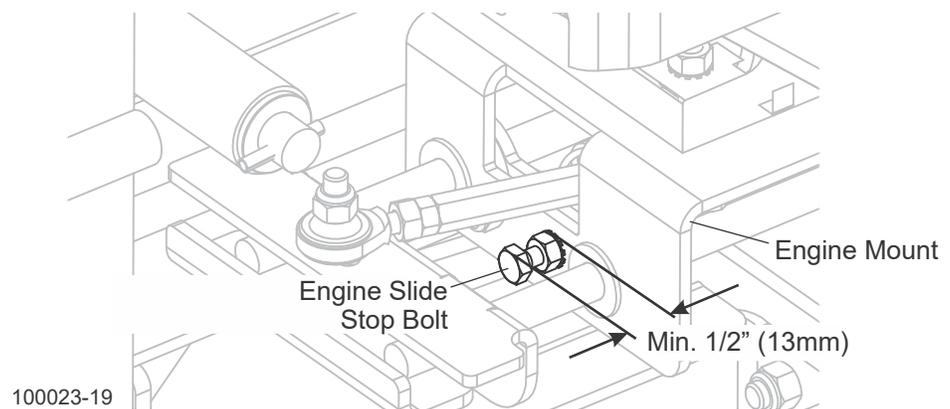


FIG. 3-23

3.6 Head Assembly

Sawmill without pre-assembled saw head prior to 4/08 only:

See Figure 3-24. Assemble the head to the mast carriage. First, turn the blade tension handle so it is pointing downward. Be sure the mast carriage is at the top position on the mast and the up/down lock is engaged. Lift the head and angle the idle side toward the mast. Insert the head pin into the hole on the idle side of the carriage. Set the rest pin on the head into the slot on the drive side of the carriage. Secure the head with the 1/2-13 x 1 1/4" hex head bolt and locknut provided. Tighten the nut so it just contacts the head mounting bracket. Overtightening may bend the bracket. Open the blade housing and install the 5/16-18 x 1" hex head bolt, washers and lock nut to secure the housing to the carriage. Adjust the stop bolt on the idle side of the carriage so the head of the bolt is against the saw head frame. Adjust the stop bolt away from the saw head for easier disassembly and reassembly.

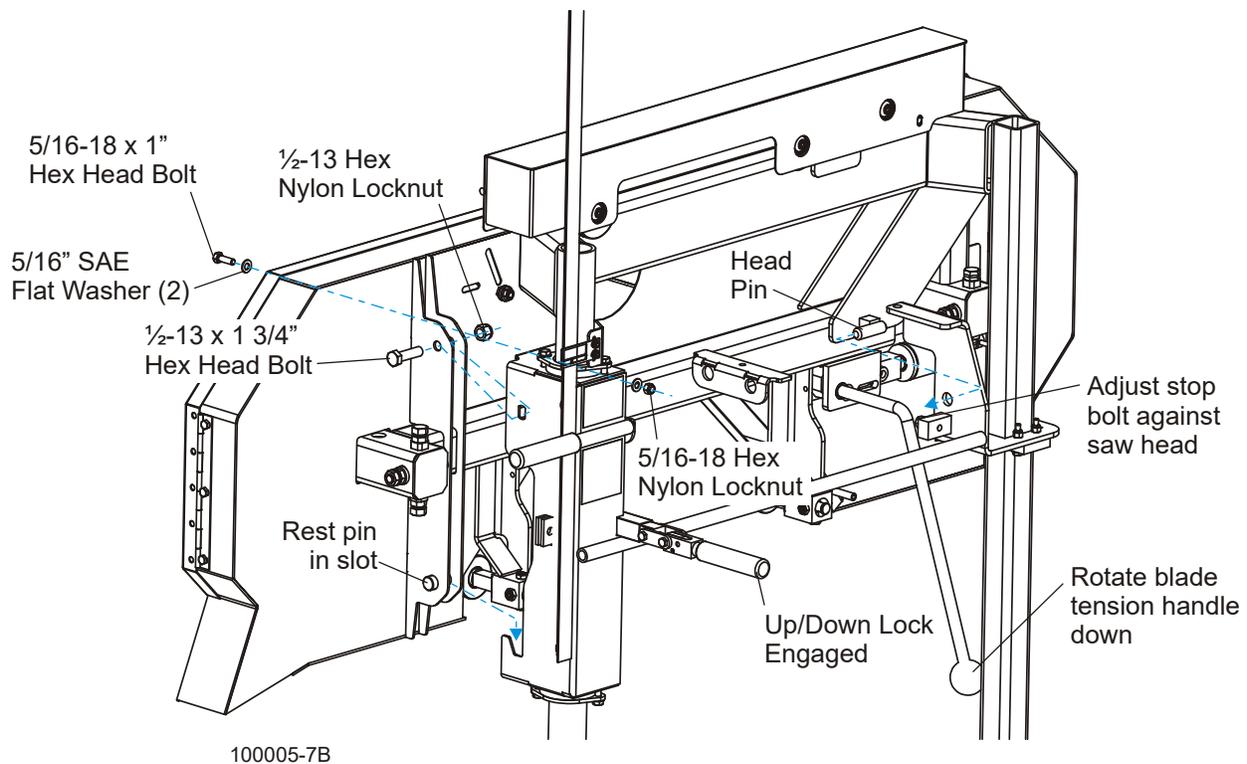


FIG. 3-24

See Figure 3-25. Place the engine on the mount plate, positioning the engine pulley through the hole in the saw head housing. Secure the engine to the mount plate with four 5/16-18 x 1 1/2" hex head bolts, flat washers and nylon lock nuts. Before tightening the bolts, check the alignment of the engine pulley with the drive pulley. Place a flat edge against both pulleys and position the engine so both pulleys are aligned. Be sure the

3

Setup

Water Lube Installation

engine does not contact the saw head and tighten the mounting bolts. Place the drive belt around the pulleys and check/adjust the drive belt tension ([See Section 5.6](#)).

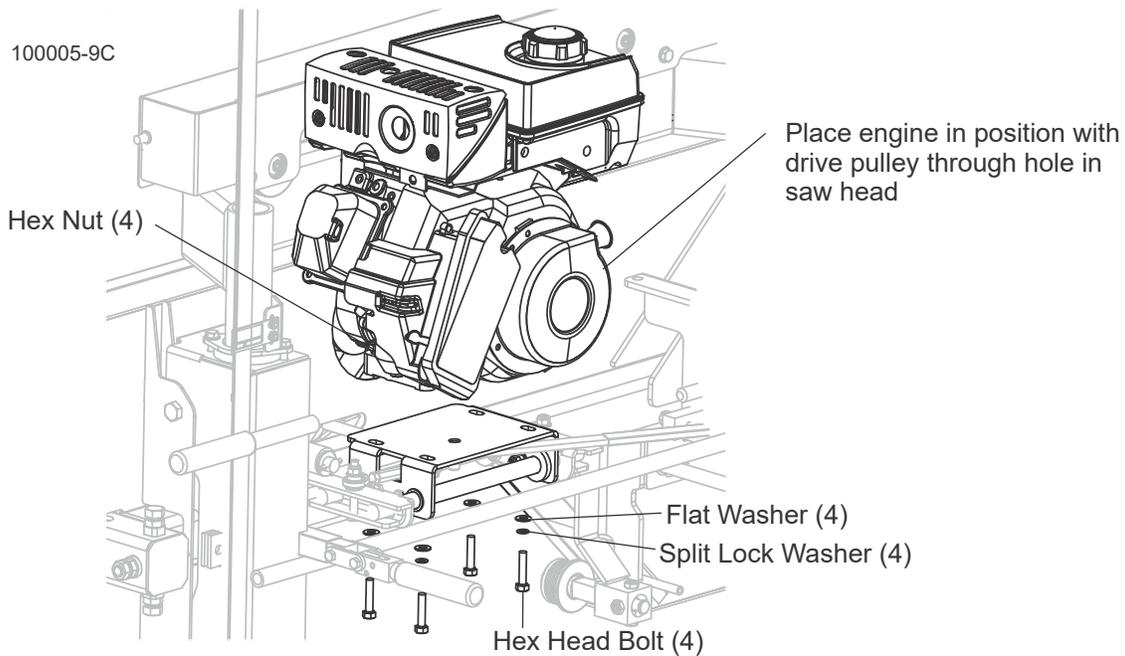


FIG. 3-25

3.7 Water Lube Installation

See Figure 3-26.

1. Lower the sawhead all the way down.
2. Install the water bottle bracket at the top of the saw head mast.

3. Connect the hose from the water bottle valve to the metal tube near the outer blade guide assembly.

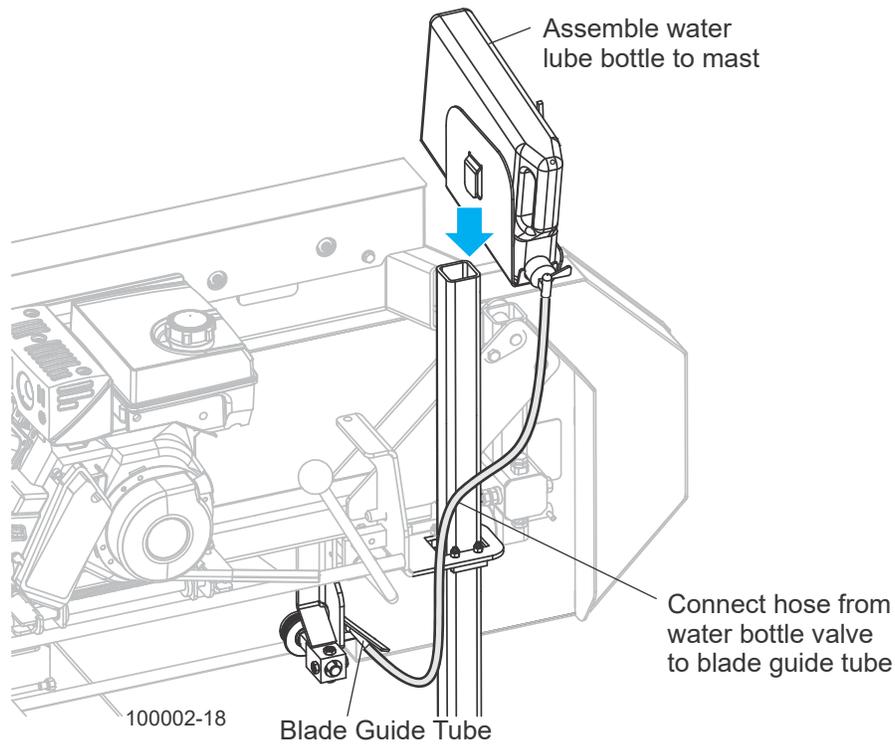


FIG. 3-26

NOTE: If necessary, shorten the water hose.

3.8 Carriage Lock Bolts

Rev. A2.00+: Two bolts with washers and lock nuts are supplied to secure the saw carriage to the bed frame during transport of the assembled LT10.

1. Align the lower roller assembly slotted holes with an unused hole in the bed.
2. Secure each lower roller assembly with a 3/8-16 x 4 1/2" hex head bolt, a flat washer, and a locknut.

3 Setup

Feed Cable Assembly (Rev. B4.05+)

See Figure 3-27.

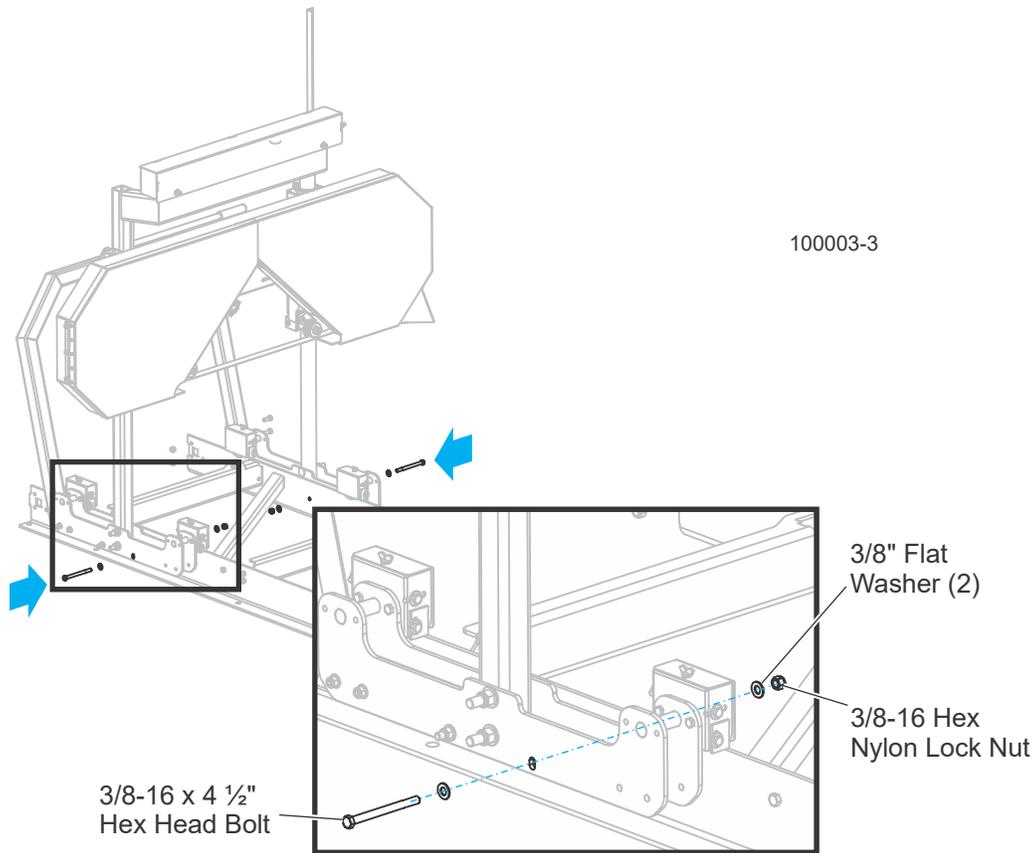


FIG. 3-27

3.9 Feed Cable Assembly (Rev. B4.05+)

This feed cable assembly helps stabilize the saw head for safer and more accurate operation.

See Figure 3-28.

1. Use the provided fasteners to securely install the pulley brackets and pulleys to the front end of the sawmill bed.

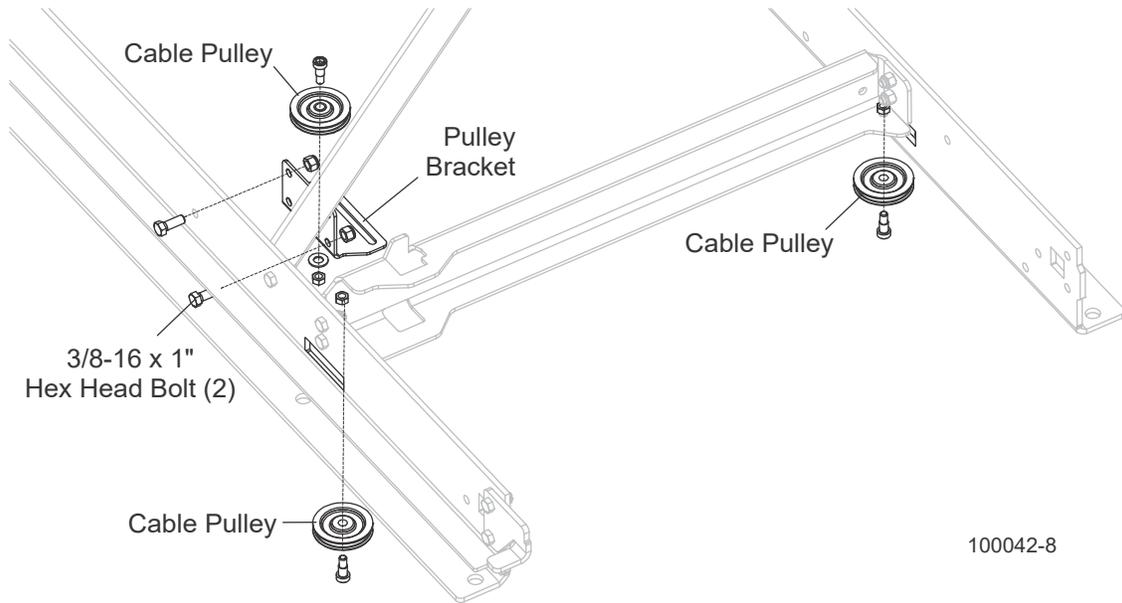


FIG. 3-28

3 Setup

Feed Cable Assembly (Rev. B4.05+)

See Figure 3-29.

2. Use the provided fasteners to securely install the pulley brackets and pulleys to the rear end of the sawmill bed

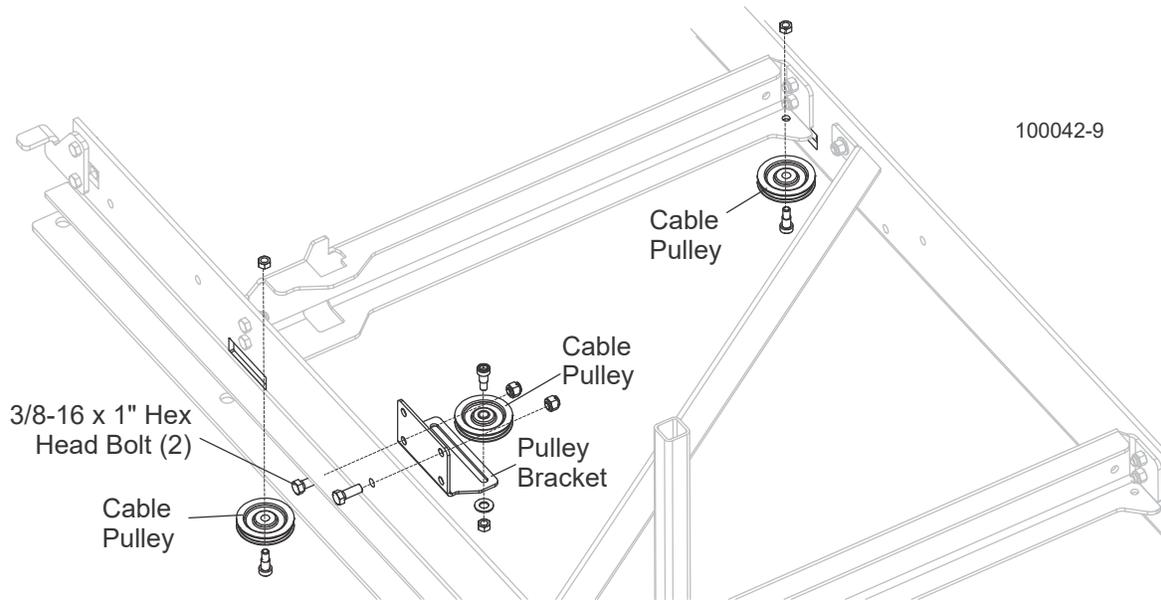


FIG. 3-29

3. Attach the cable to a bolt located at the bottom of the roller.

See Figure 3-30.

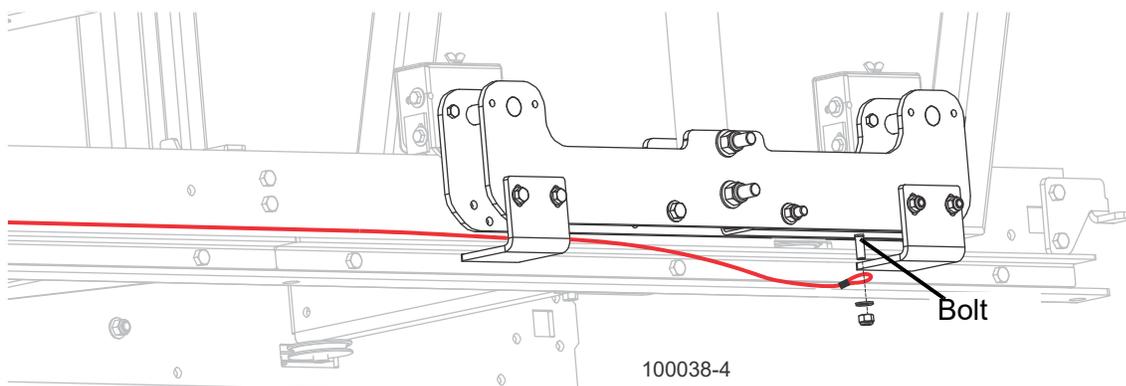


FIG. 3-30

4. Route the saw head feed cables as shown.

See Figure 3-31.

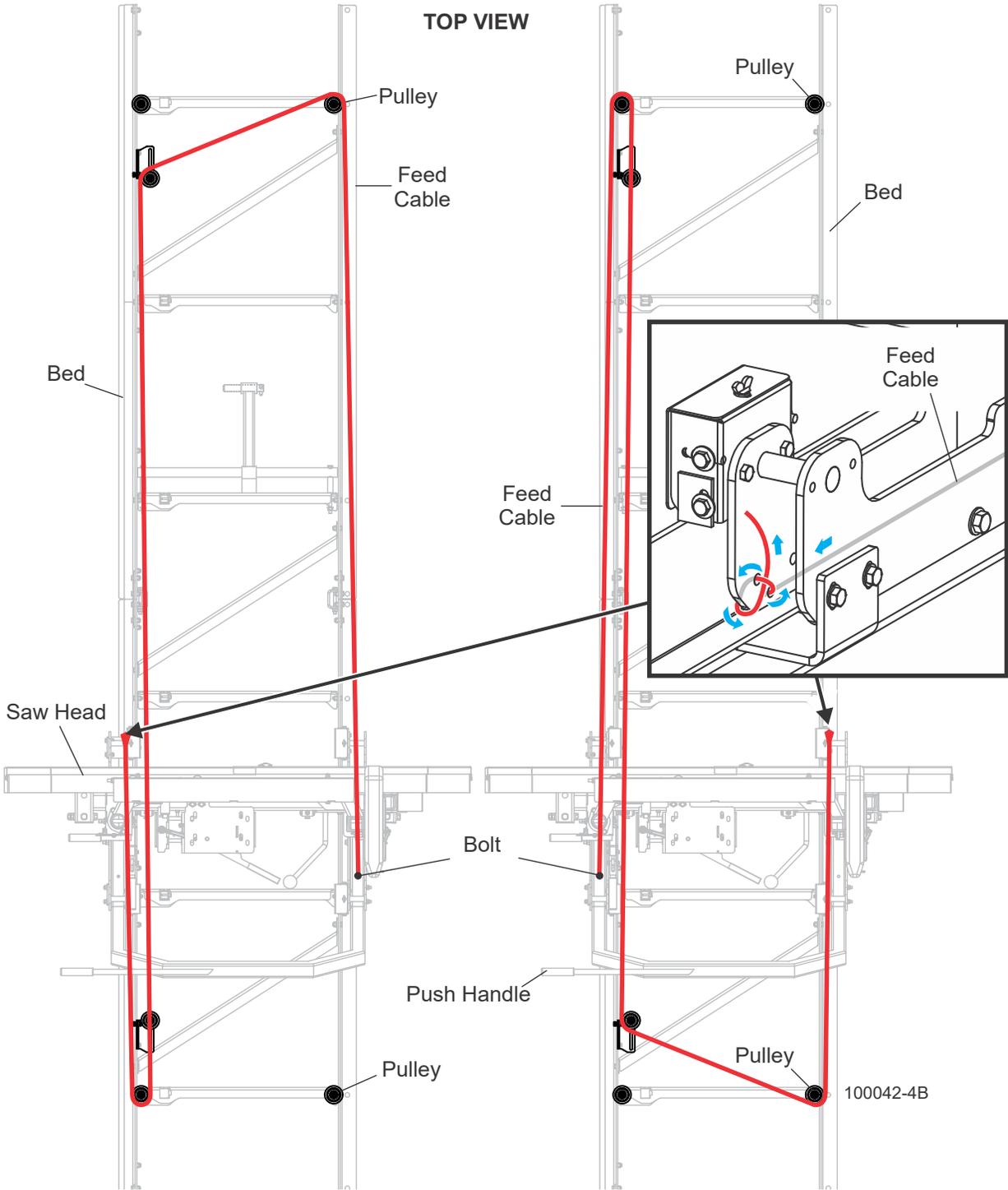


FIG. 3-31

3

Setup

Feed Cable Assembly (Rev. B4.05+)

See **Figure 3-32**. Use the pulleys on the pulley tensioner brackets to tighten the feed cables evenly so the lower roller assemblies align with the bed rail as shown below. Tighten the pulley nuts when the alignment procedure is complete.

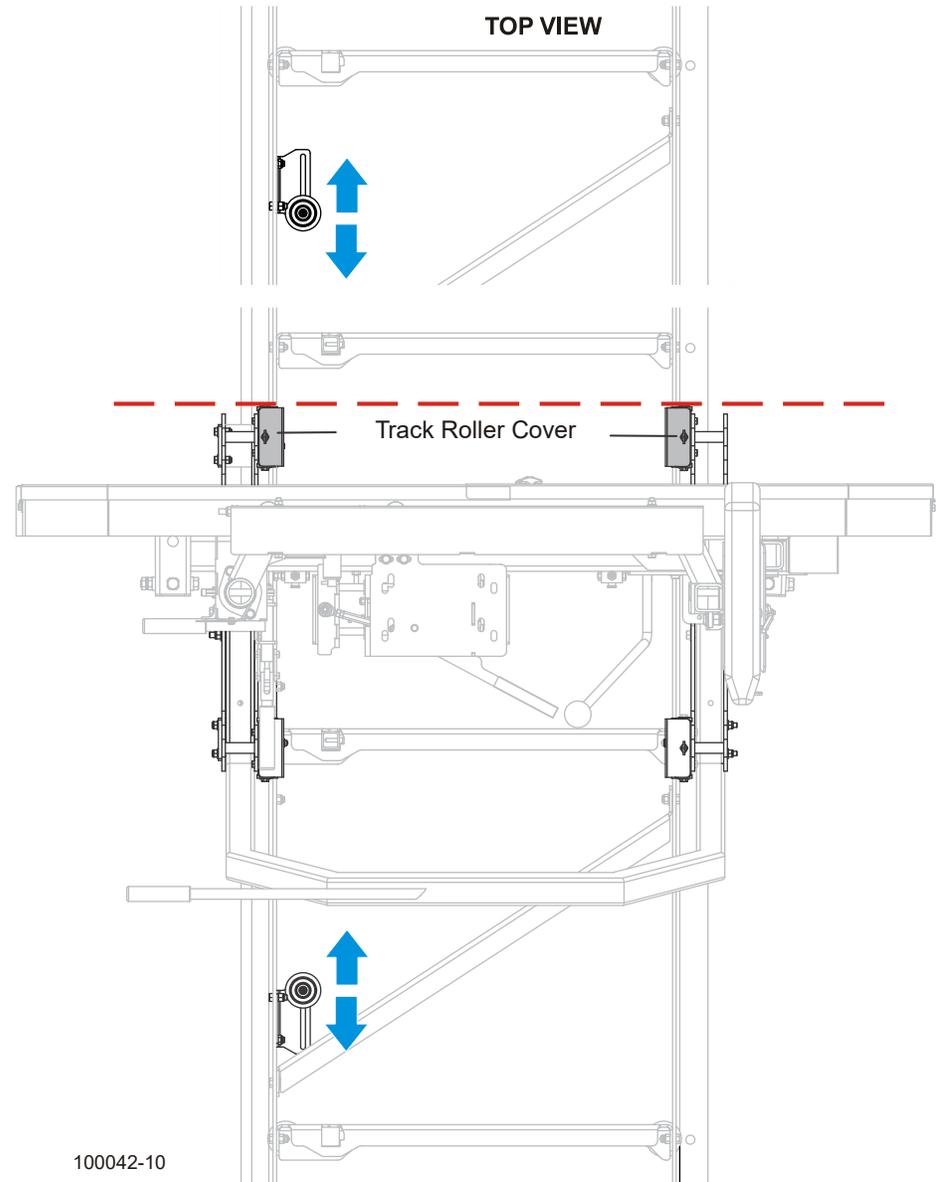


FIG. 3-32



IMPORTANT! Make sure the lower roller assemblies are aligned and the saw head carriage is not twisted. If the feed cables are too loose, the head will shake and the cables will come off the pulleys. If the feed cables are too tight, the head will be hard to push and the pulleys and rollers will wear prematurely.

3.10 Feed Cable Assembly (Rev. B4.04)

This feed cable assembly helps better stabilize the saw head for safer and more accurate operation. Follow the instructions below to properly install and adjust the feed cables.

See Figure 3-33. Install the front feed cable assembly and the front end stop plate to the front end of the sawmill bed. Use the provided fasteners to secure the feed cable assembly and the front end stop plate to the bed.

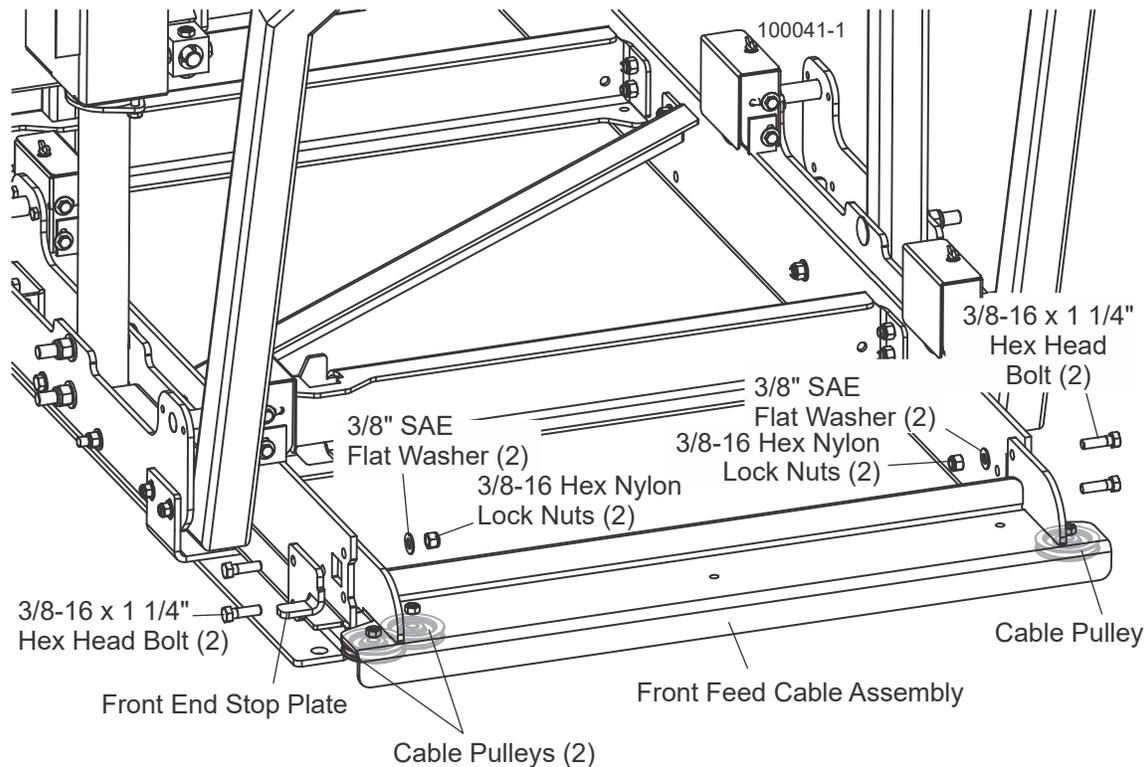


FIG. 3-33

3 Setup

Feed Cable Assembly (Rev. B4.04)

See **Figure 3-34**. Install the rear feed cable assembly and the rear end stop plate to the rear end of the sawmill bed. Use the provided fasteners to secure the feed cable assembly and the rear end stop plate to the bed.

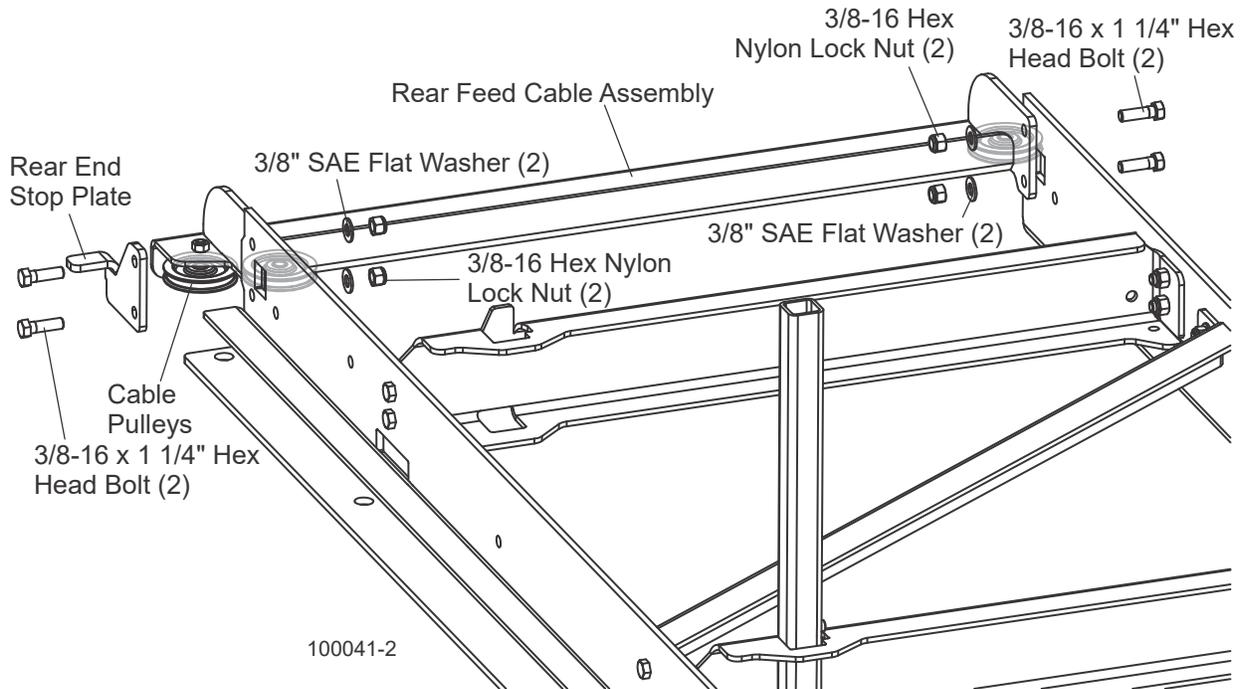


FIG. 3-34

See Figure 3-35. Route the saw head feed cables as shown.

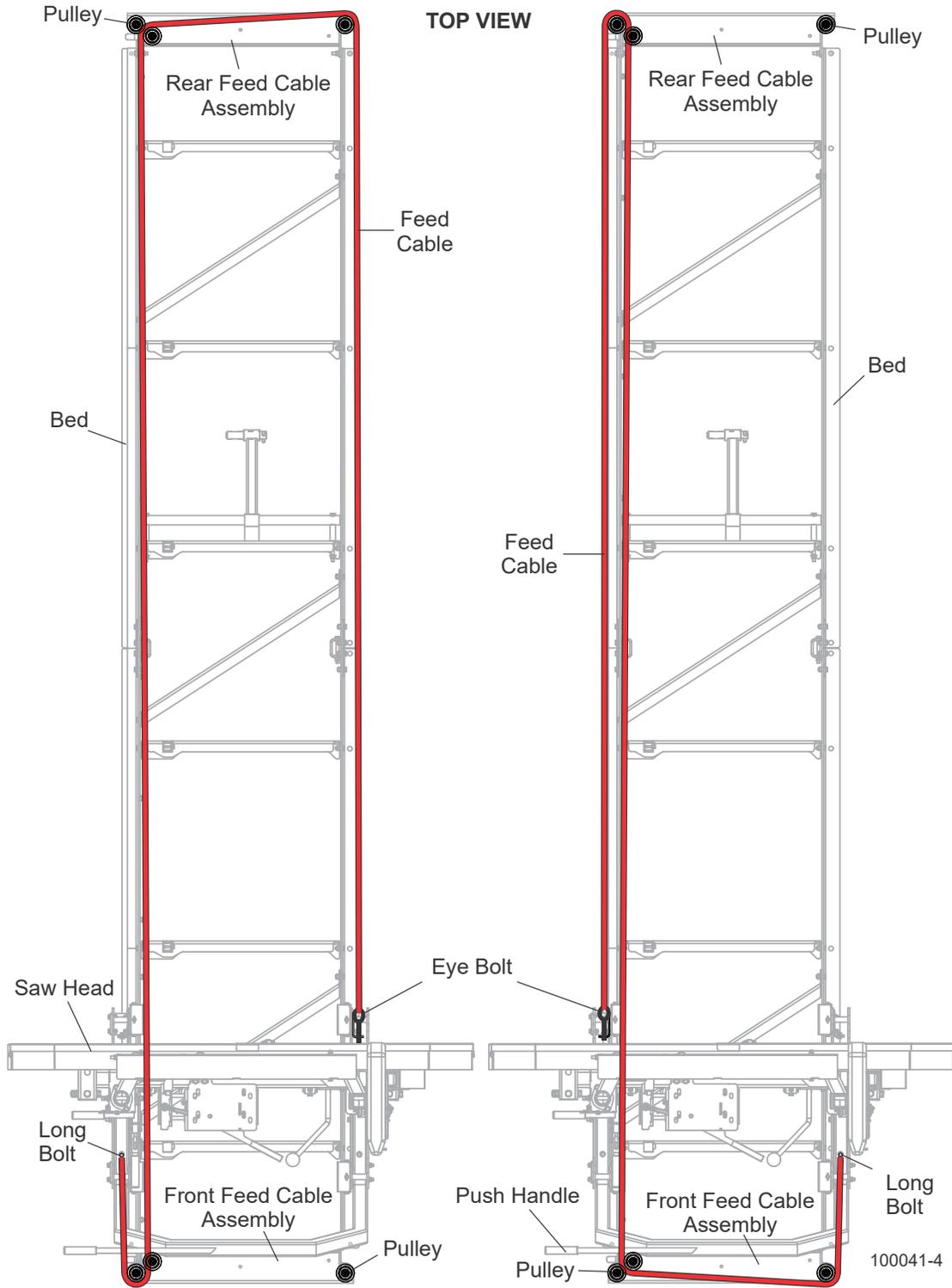


FIG. 3-35

3 Setup

Feed Cable Assembly (Rev. B4.04)

See Figure 3-36. Install both feed cable eye bolts to the bottom holes of the cable mount plates. Secure the eye bolts with the provided hex nuts.

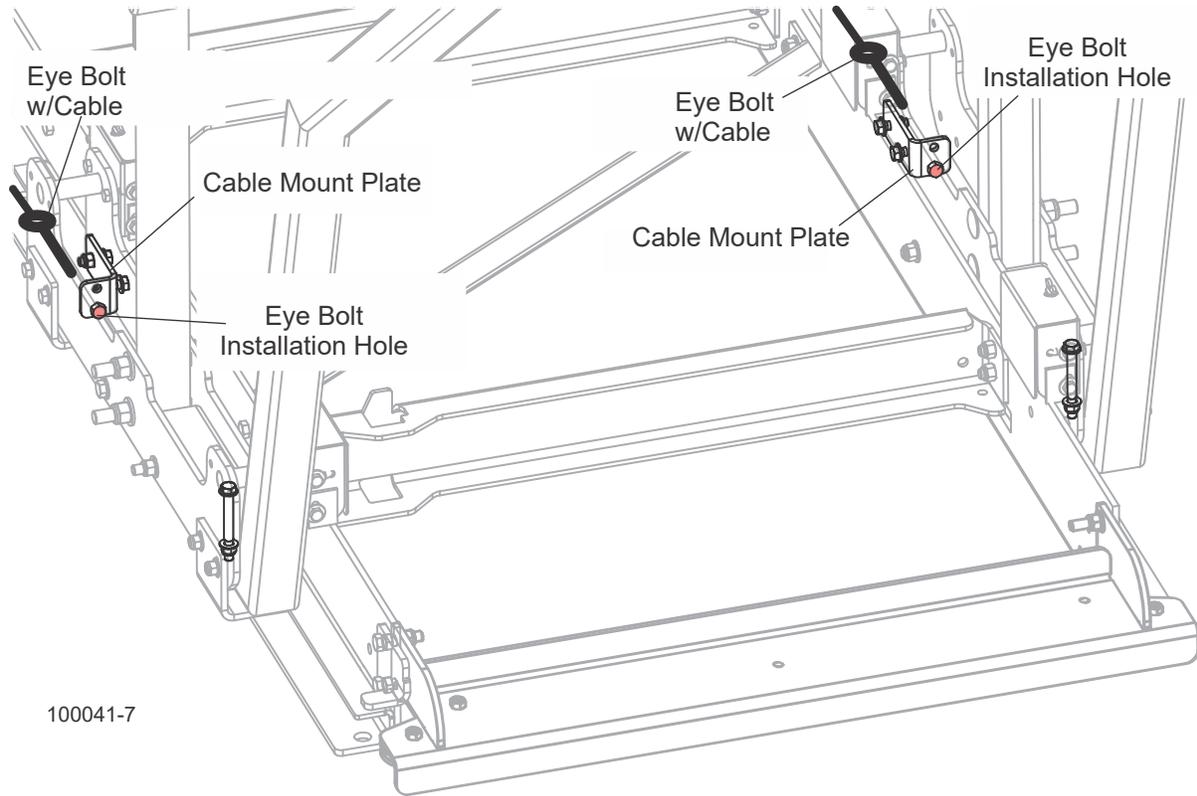


FIG. 3-36

See Figure 3-37. Use the eye bolt nuts to tighten the feed cables evenly so the lower roller assemblies align with the bed rail as shown below. Tighten the eye bolt nuts when the alignment procedure is complete.

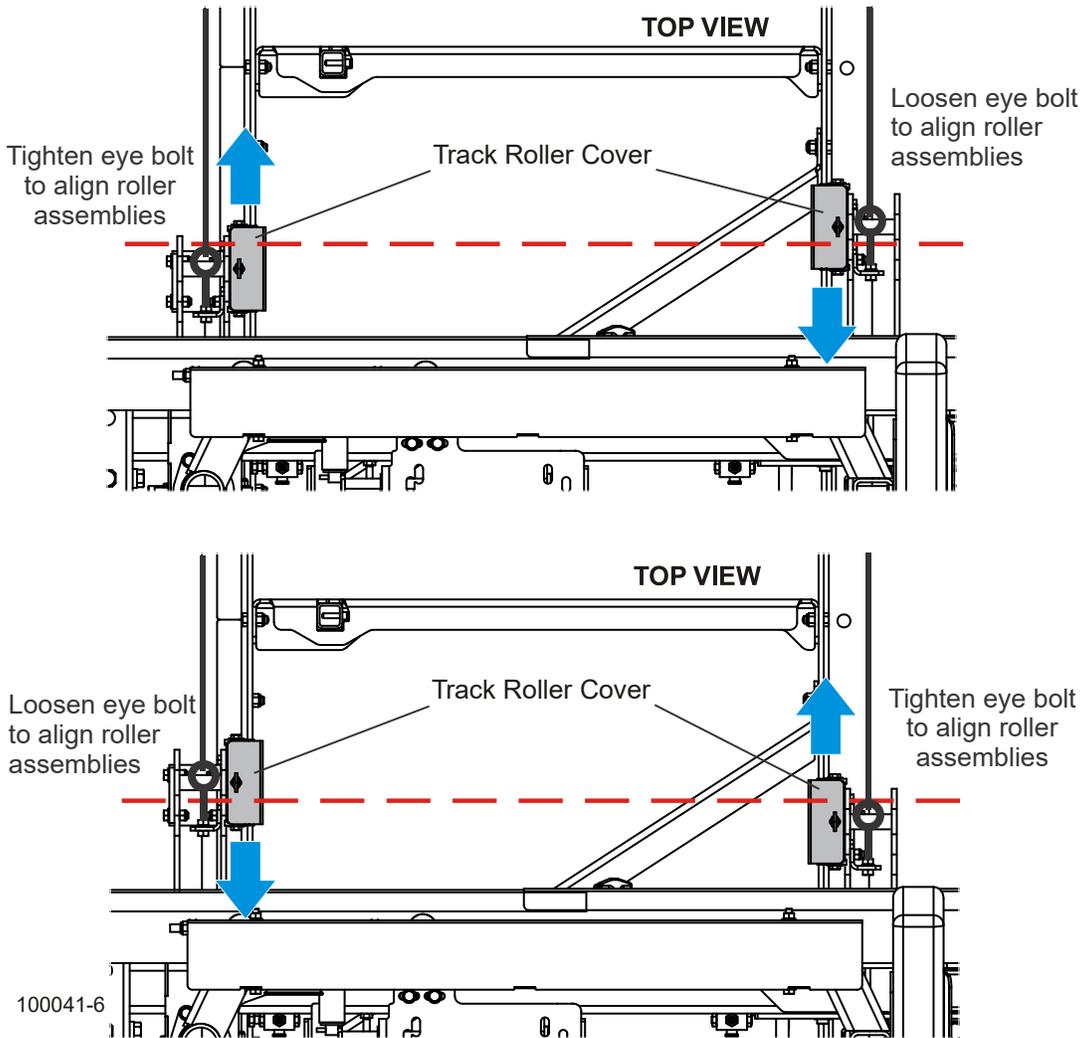


FIG. 3-37

IMPORTANT! Make sure the lower roller assemblies are aligned and the saw head carriage is not twisted. If the feed cables are too loose, the head will shake and the cables will come off the pulleys. If the feed cables are too tight, the head will be hard to push and the pulleys and rollers will wear prematurely.

3.11 Feed Cable Assembly (Rev. A1.00 - B3.03)

This feed cable assembly helps better stabilize the saw head for safer and more accurate operation. Follow the instructions below to properly install and adjust the feed cables.

3 Setup

Feed Cable Assembly (Rev. A1.00 - B3.03)

See Figure 3-38. Install the front feed cable assembly and the front end stop plate to the front end of the sawmill bed. Use the provided fasteners to secure the feed cable assembly and the front end stop plate to the bed.

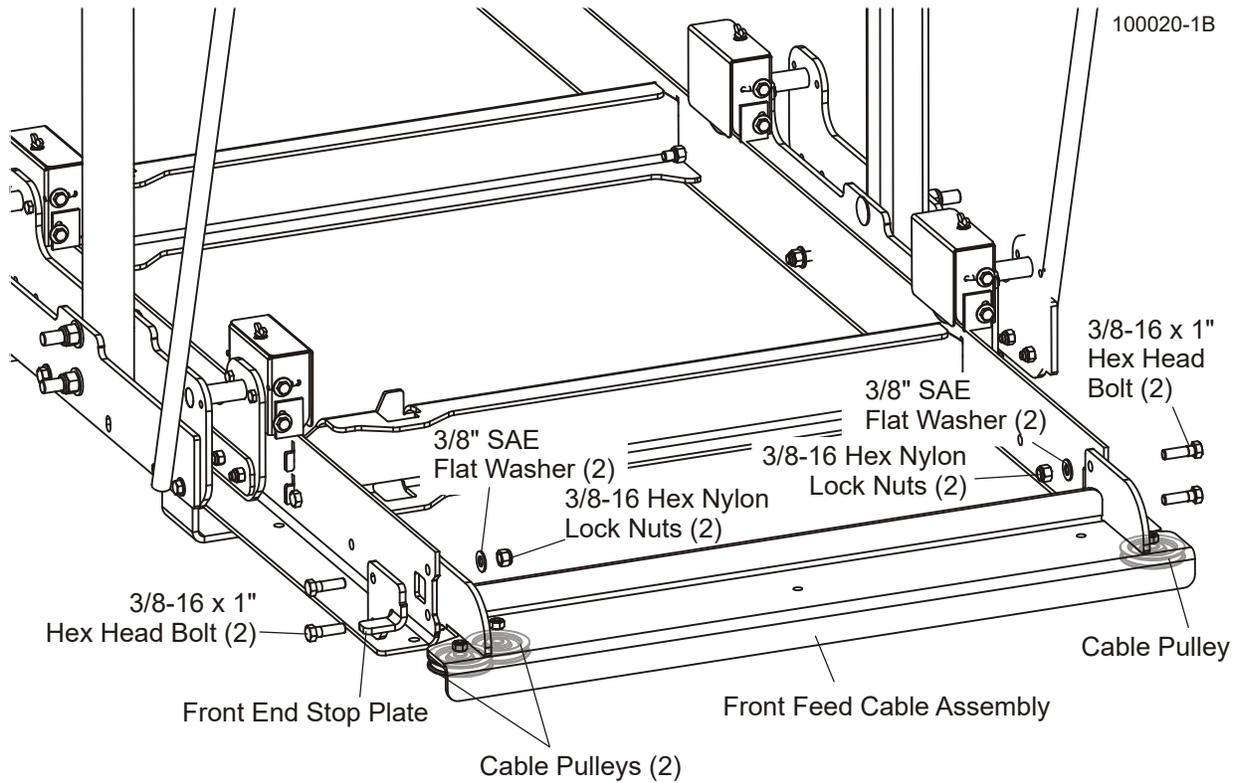


FIG. 3-38

See Figure 3-39. Install the rear feed cable assembly and the rear end stop plate to the rear end of the sawmill bed. Use the provided fasteners to secure the feed cable assembly and the rear end stop plate to the bed.

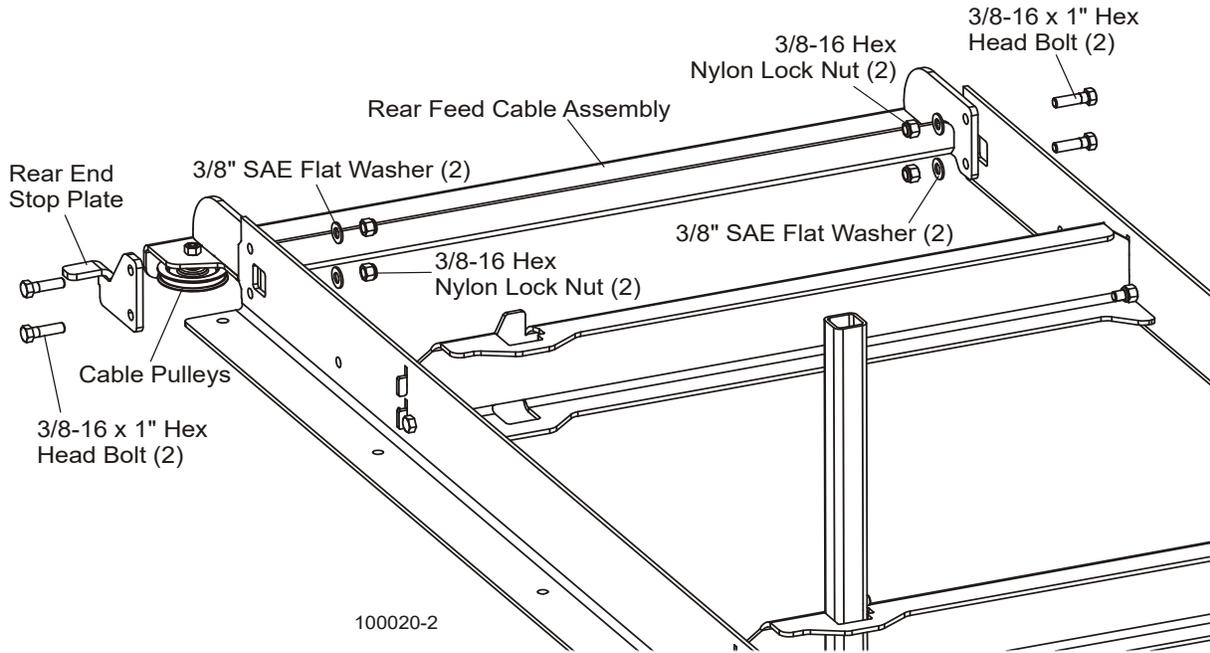


FIG. 3-39

3 Setup

Feed Cable Assembly (Rev. A1.00 - B3.03)

See Figure 3-40. Route the saw head feed cables as shown.

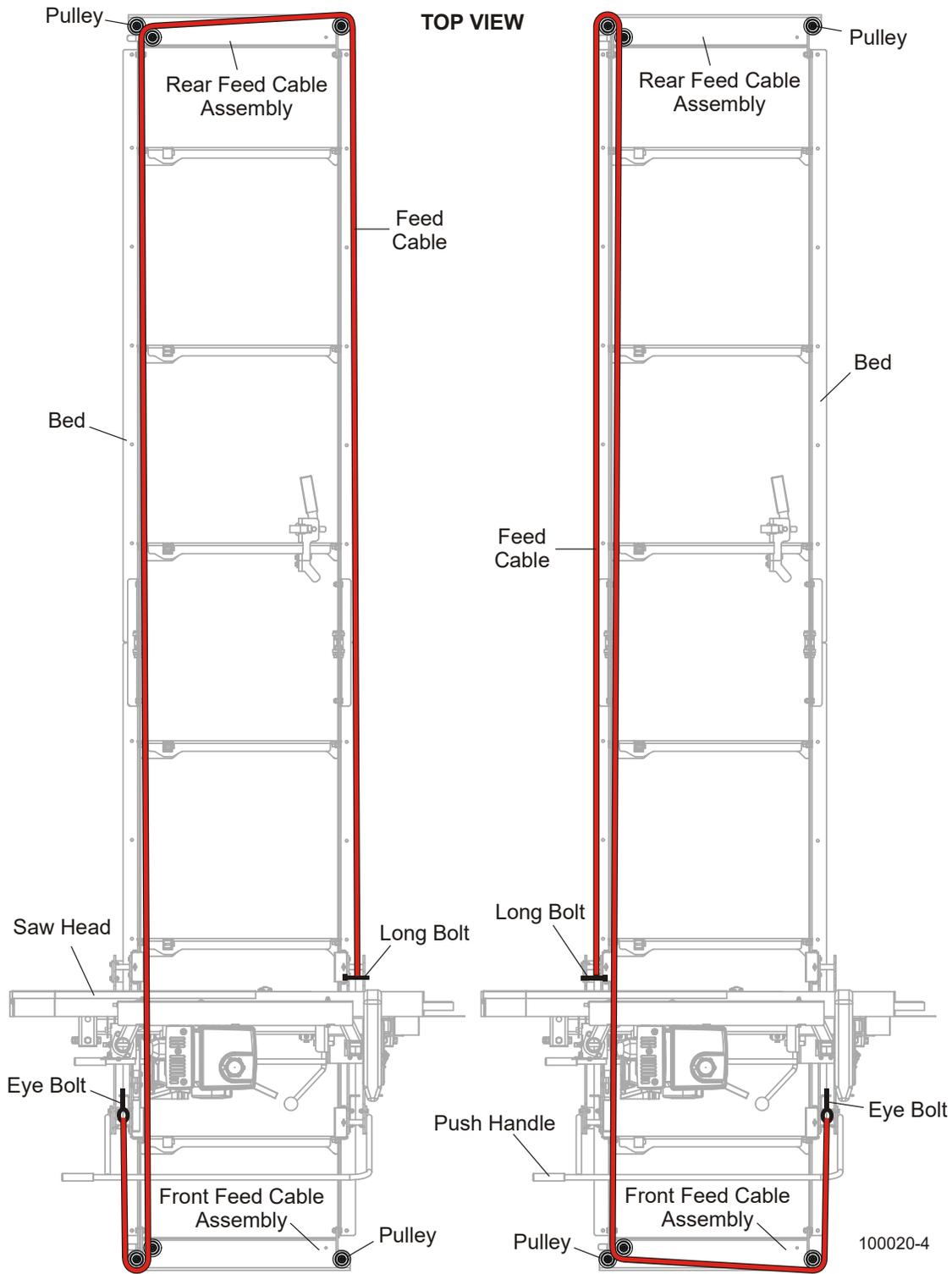


FIG. 3-40

See **Figure 3-41**. Install both feed cable eye bolts to the bottom holes of the cable mount plates. Secure the eye bolts with the provided hex nuts.

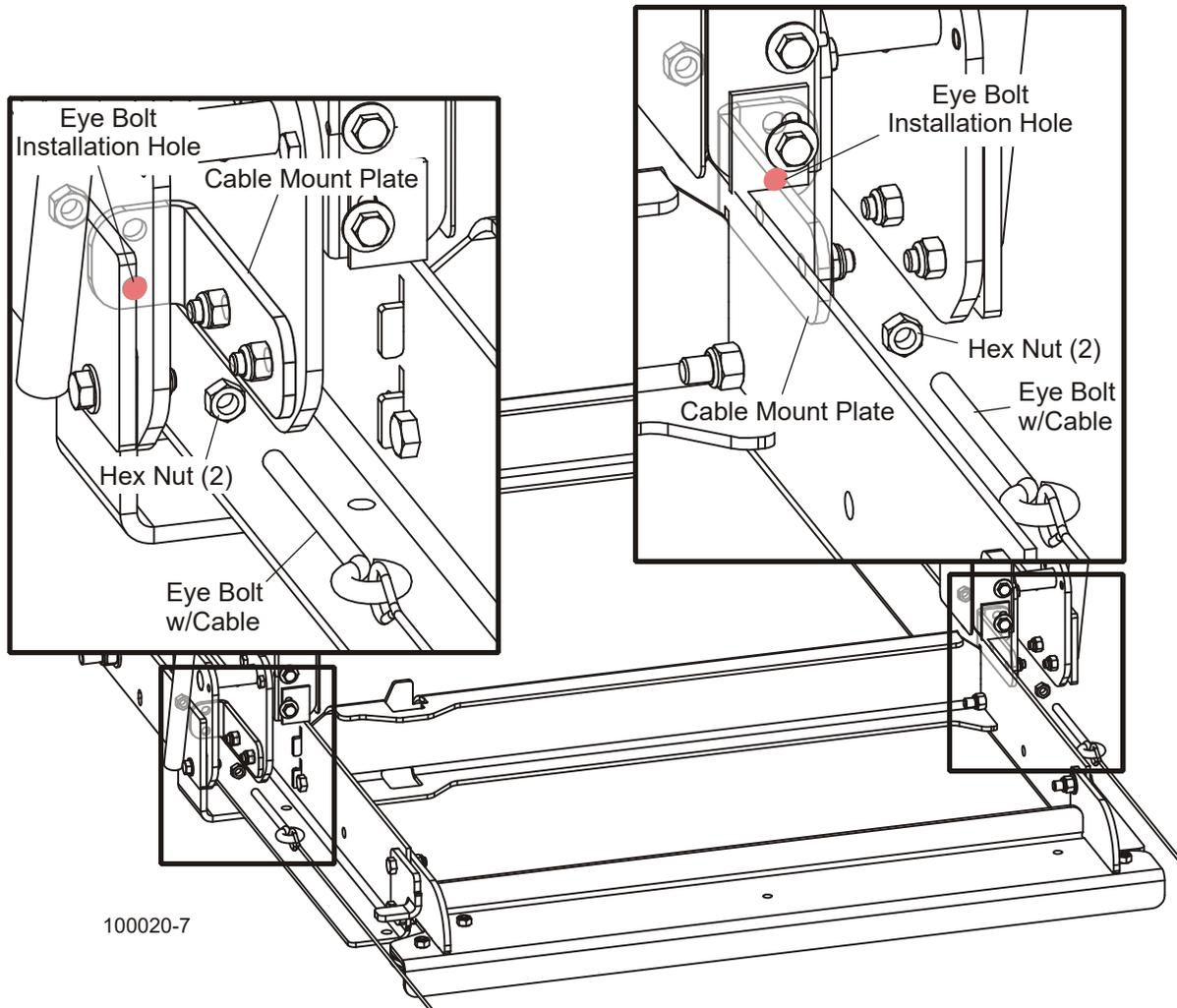


FIG. 3-41

3

Setup

Feed Cable Assembly (Rev. A1.00 - B3.03)

See Figure 3-42. Use the eye bolt nuts to tighten the feed cables evenly so the lower roller assemblies align with the bed rail as shown below. Tighten the eye bolt nuts when the alignment procedure is complete.

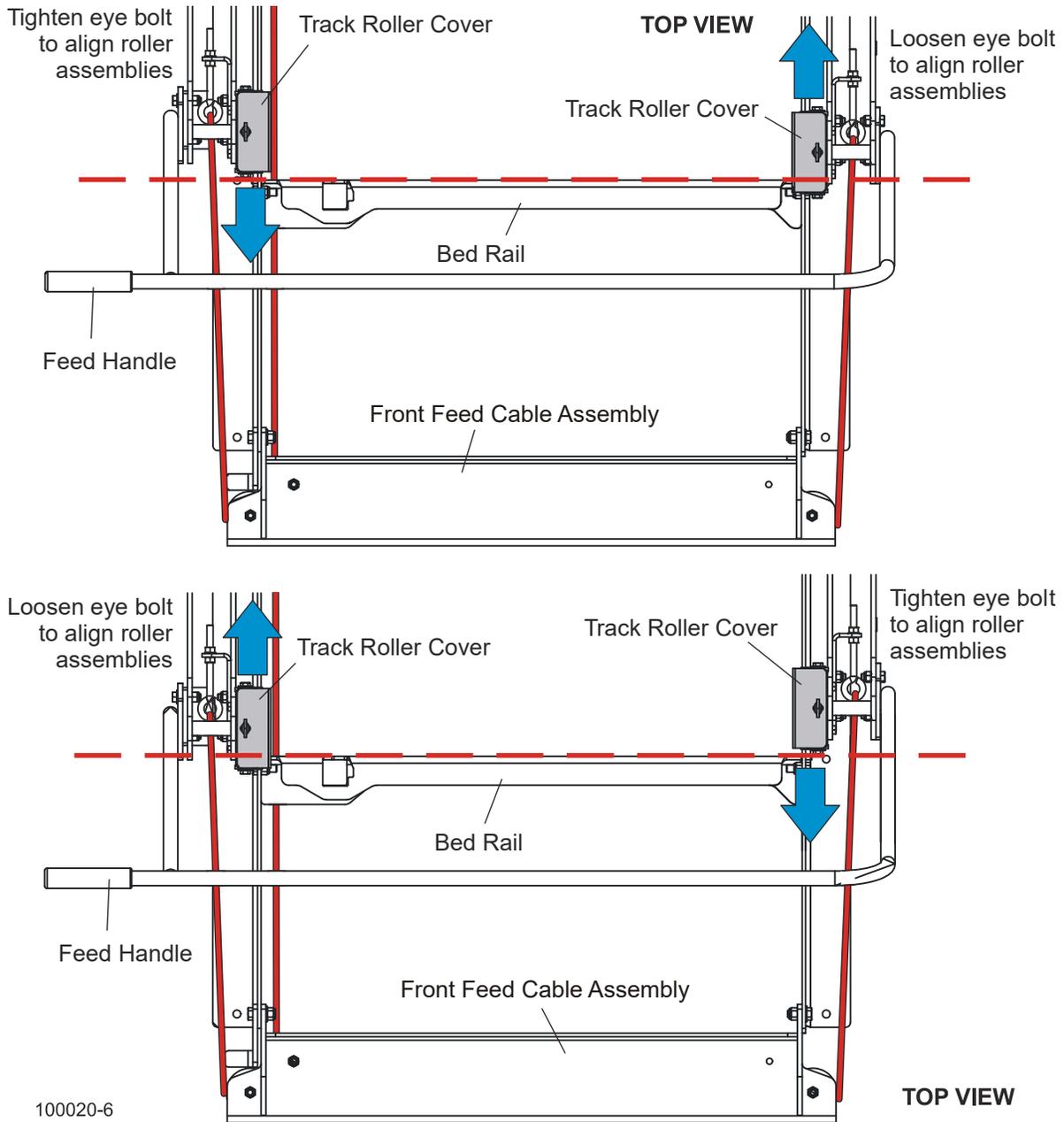


FIG. 3-42

IMPORTANT! Make sure the lower roller assemblies are aligned and the saw head carriage is not twisted. If the feed cables are too loose, the head will shake and the cables will come off the pulleys. If the feed cables are too tight, the head will be hard to push and the pulleys and rollers will wear prematurely.

3.12 Blade Installation

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

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

1. Open the two blade housing covers that cover the blade wheels.
2. Turn the blade tension handle down (5 o'clock position) to move the idle-side blade wheel in.
3. Make sure the teeth are pointing the correct direction. The lower teeth should be pointing toward the sawdust chute.

See Figure 3-43.

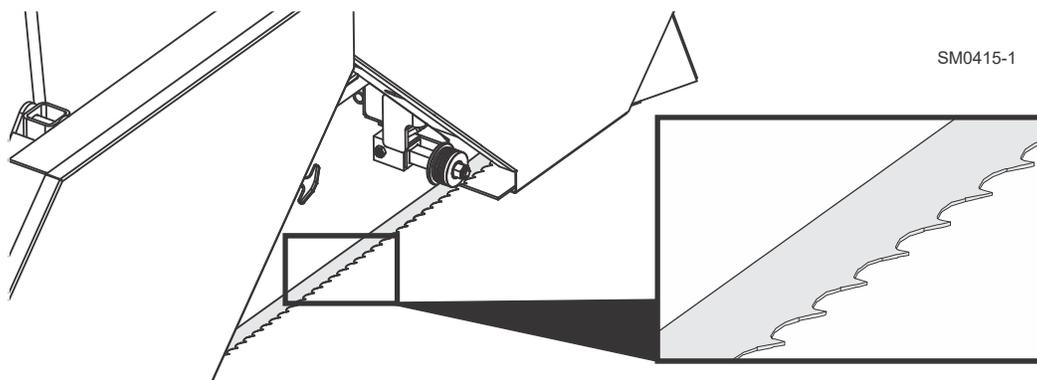


FIG. 3-43

4. Place the blade around the wheels.
5. Position 1 1/4" wide blades on the wheels so the gullet is 1/8" (3.0 mm) out from the edge of the wheel.

See Figure 3-44.

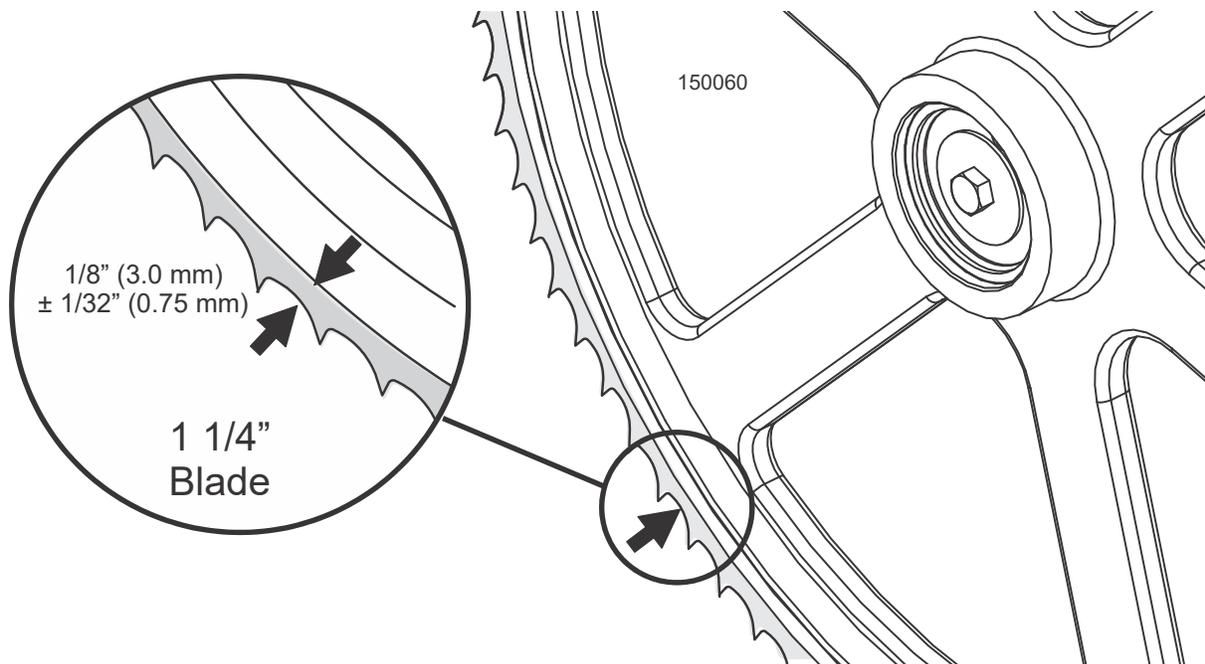


FIG. 3-44

6. Close and latch the blade housing covers.
7. Tension the blade.

3.13 Blade Tension



WARNING! Use both hands to operate the blade tensioner handle. Failure to do so may result in injury.

The blade tensioner is factory-set so proper blade tension is achieved when the rubber spring is compressed 3/16" (4.8 mm).

Rev. A1.01+: An indicator gauge is provided to indicate when the rubber spring has been compressed properly.

See Figure 3-45.

1. Turn the blade tension handle up until it locks in place.
2. Check the back side of the rubber spring washer is aligned with the indicator gauge.

- If not, release the blade tension and turn the tension adjustment pin to compress or decompress the rubber spring as needed.

Re-tension the blade and recheck the alignment of the rubber spring washer with the indicator gauge.

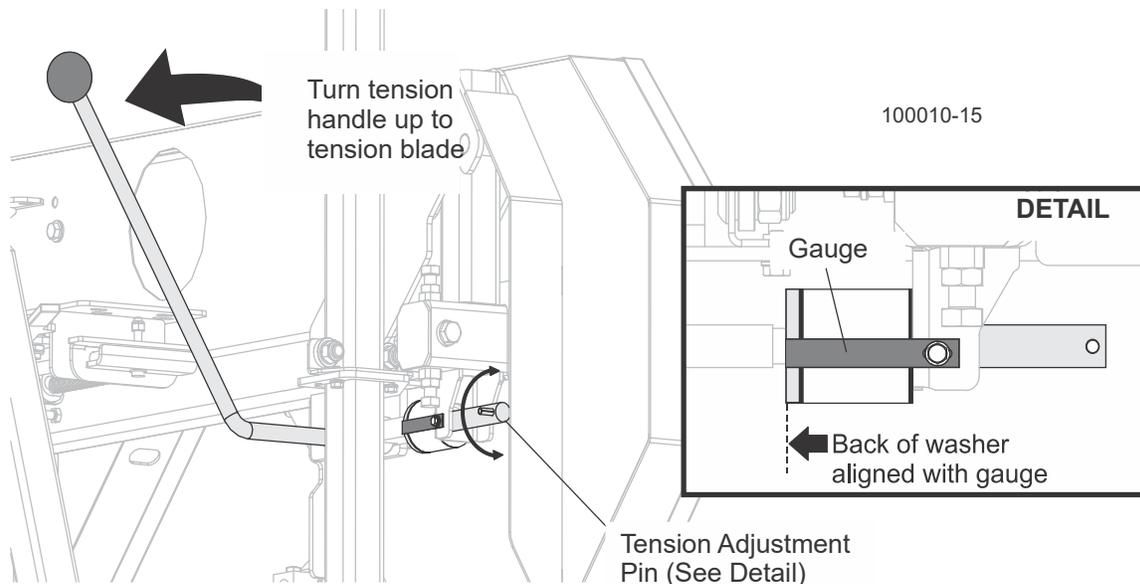


FIG. 3-45 LT10 REV. A1.01+

1. Check the back side of the rubber spring washer is aligned with the indicator gauge.
 - If not, release the blade tension and turn the tension adjustment pin to compress or decompress the rubber spring as needed.
 - Re-tension the blade and recheck the alignment of the rubber spring washer with the indicator gauge.
2. During operation, the blade and belts heat up and stretch, and the blade tension will change. Check the blade tension occasionally while cutting.

Adjust the tension pin as necessary to keep the rubber spring washer aligned with the indicator gauge. **Rev. A1.00:** A stripe on the tensioner adjustment pin is provided to indicate when the rubber spring has been compressed properly. To tension the blade, turn the blade tension handle up until it locks in place.

See Figure 3-46. Check the back side of the stripe on the adjustment pin is aligned with the indicator screw. If not, release the blade tension and turn the pin clockwise to move the stripe closer to the screw; counterclockwise to move the stripe away from the screw. Tension the blade and recheck the alignment of the stripe with the indicator screw.

3 Setup

Blade Tension

Check the blade tension occasionally when adjusting the cant control or while cutting. As the blade and belts heat up and stretch, the blade tension will change. Adjust the tension pin as necessary to keep the stripe aligned with the indicator screw.

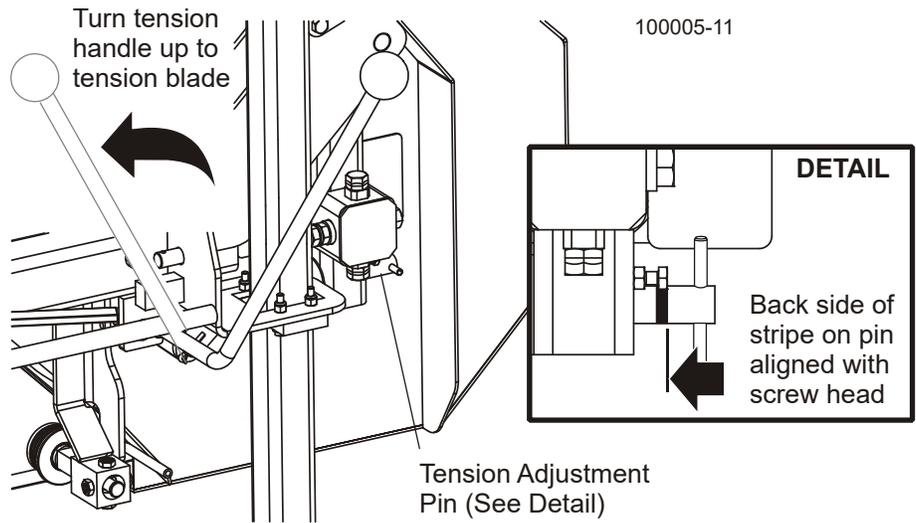


FIG. 3-46 LT10 REV. A1.00

3.

3.14 Blade Height Indicator Adjustment

1. Unpack and assemble the blade height indicator as shown below:

See Figure 3-47.

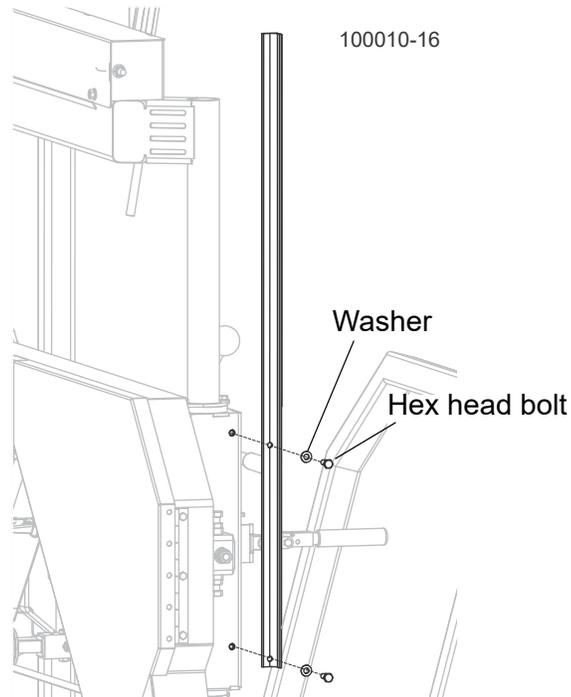


FIG. 3-47

2. Position the saw head so that the blade is over a bed rail.
3. Measure the **actual distance** from the bed rail to the bottom of the blade.
4. Install the blade height indicator to the scale at the actual measurement. Use the provided screws and hex nuts to secure the blade height indicator in place.

3 Setup

Blade Height Indicator Adjustment

See Figure 3-48.

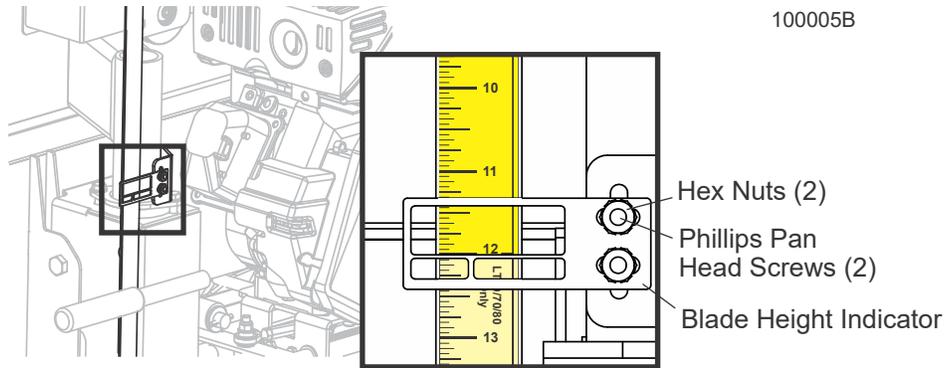


FIG. 3-48

SECTION 4 OPERATION

4.1 Loading, Turning And Clamping Logs

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

See Figure 4-1.

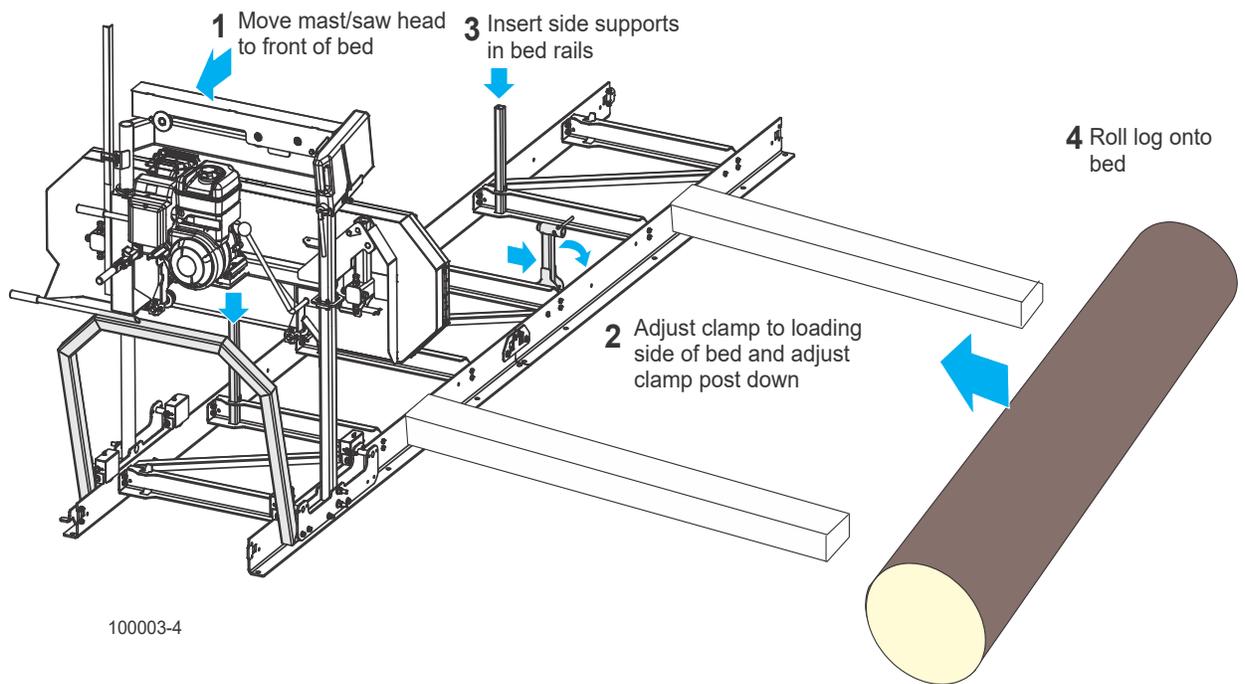


FIG. 4-1 REV. B4.00+

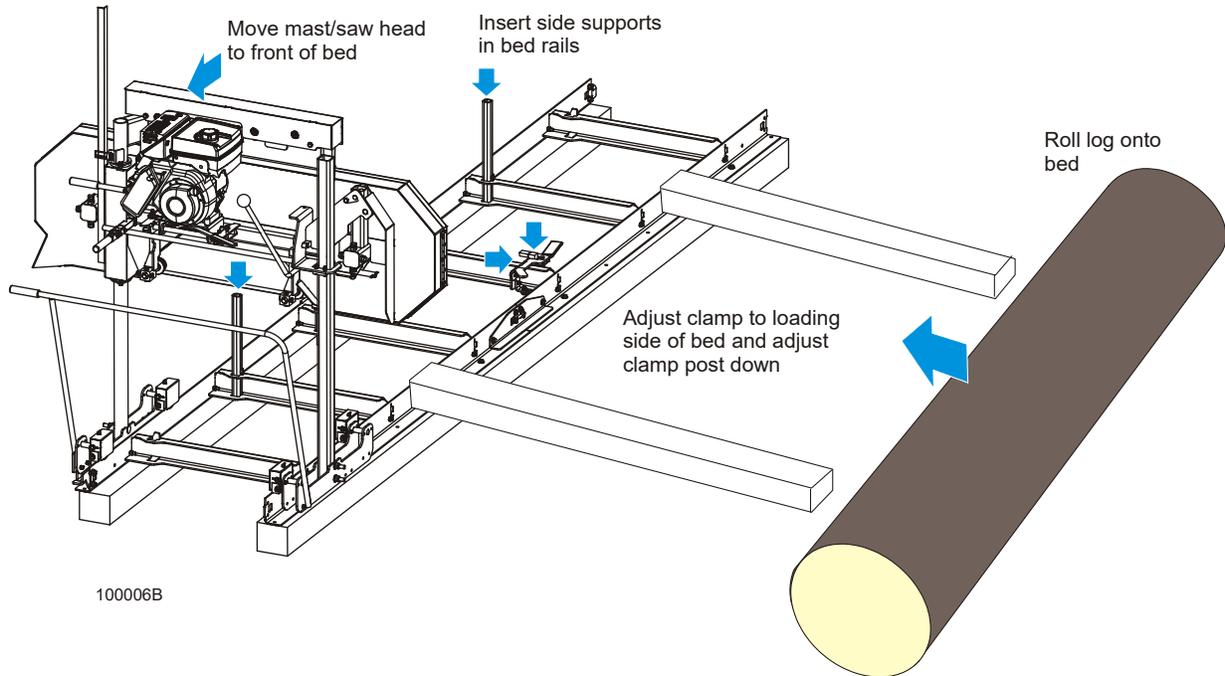


FIG. 4-1 REV. A1.00 - B3.03



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

2. Adjust the log clamp all the way down and move toward the loading side of the sawmill frame.



CAUTION! Be sure the log clamp is adjusted out of the path of the log before loading a log onto the bed. Failure to do so may result in machine damage.

3. Install the side supports to the sawmill bed.
4. Roll log onto bed.



CAUTION! Roll or lower log onto the sawmill bed. Do not drop it from any height. Failure to do so may result in machine damage.

NOTE: Use boards for ramps to load the log on the sawmill bed. Use a cant hook to roll the log up the ramps onto the sawmill bed and into cutting position against the side supports. Logs also may be loaded

4

Operation

Loading, Turning And Clamping Logs

onto the mill with a tractor or other equipment specifically designed for that purpose.

NOTE: Position the log on the bed sections to maximize support of the log by the bed. If the log overhangs the bed, (particularly if the optional bed extension is installed) it may tend to sag, resulting in inaccurately sawn lumber.

5. Rev. B4.00+: Slide the clamp against the log and turn the locking handle to lock the clamp against the log.

See Figure 4-2.

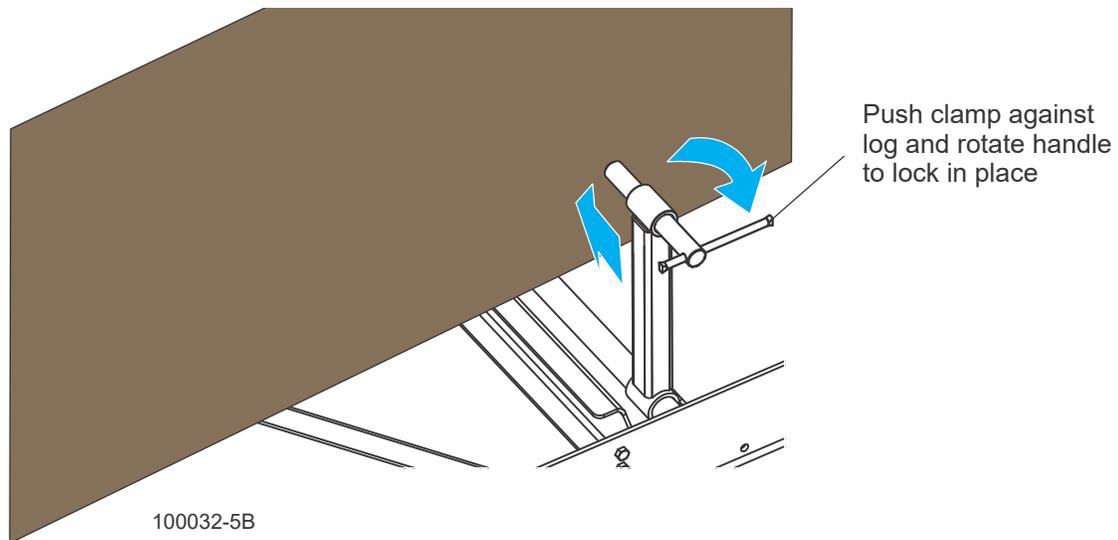


FIG. 4-2 REV. B4.00+

6. Rev. A1.00 - B3.03: Position the clamp post up or down as necessary. Slide the clamp against the log and turn the locking handle to lock the clamp against the log.

See Figure 4-3.

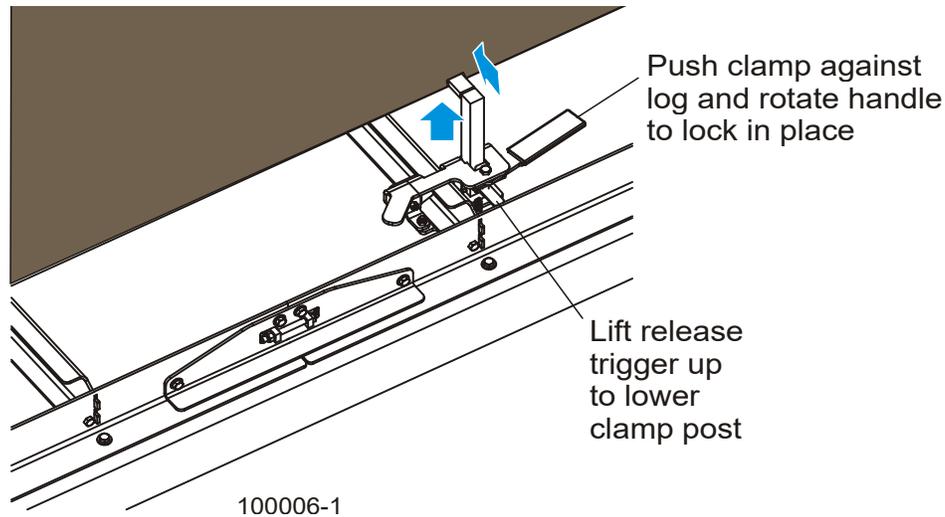


FIG. 4-3 REV. A1.00 - B3.03

7. Make sure the side supports are positioned low enough for the blade to pass over them. If not, loosen the clamp off and readjust the side supports.
8. If necessary, use shims to raise either end of a tapered log. Shim the log so that the heart of the log is parallel to the sawmill bed.

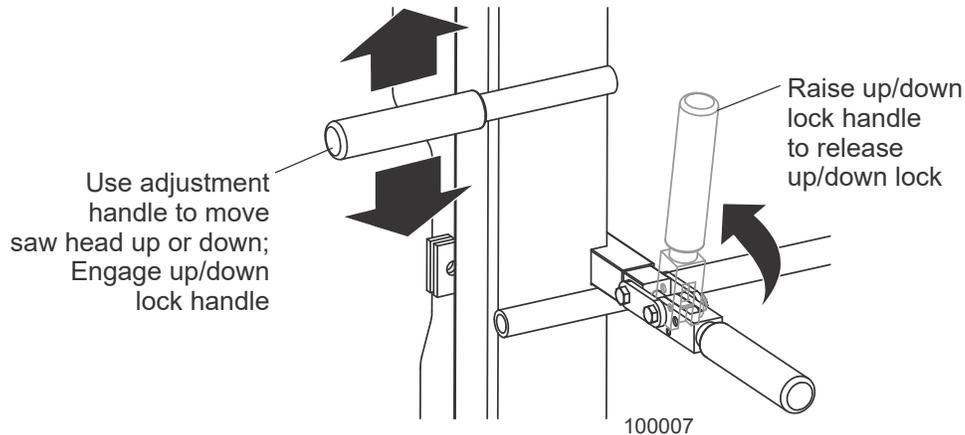
4.2 Up/Down Adjustment

1. Check for correct blade tension before cutting. ([See Section 3.12](#)).
2. Position the blade for the first cut by raising or lowering the saw head on the mast.

See Figure 4-4.

3. Pull the up/down lock handle up to release the lock.
4. Use the adjustment handle to move the saw head up or down until the blade is positioned as desired.

5. Push the up/down lock handle down to set the lock.

**FIG. 4-4**

4.3 Blade Operation



DANGER! Make sure all guards and covers are in place and secured before operating the sawmill. Be sure the blade housing and pulley covers are in place and secure. Failure to do so may result in serious injury.

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

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



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

1. Clear loose objects from the area around the blade, engine, and drive belt.
2. Be sure the blade housing covers are in place and secure before starting the engine. Use the rubber latch to fasten the blade housing covers shut.
3. Make sure the clamp and side supports are adjusted below the level of cuts.
4. Make sure the blade engage lever located under the engine is in the OFF position.

See Figure 4-5.

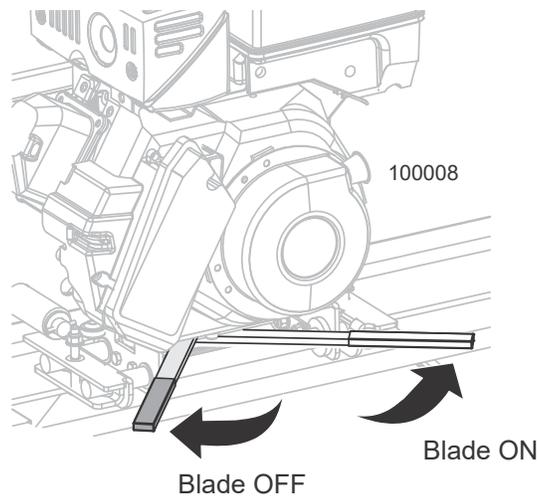


FIG. 4-5

5. Start the engine and increase the throttle as instructed in the engine manufacturer's manual.
6. Move the blade engage lever to the ON position to start the blade spinning.
7. To stop the blade and engage the brake, move the lever to the OFF position. Return the engine to idle speed.

4.4 Water Lube Operation

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

See Figure 4-6.

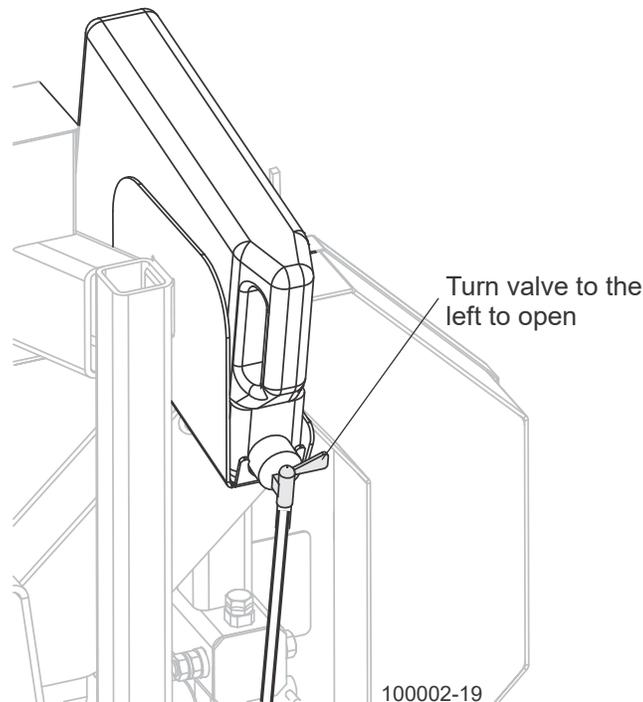


FIG. 4-6

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

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

For further lubrication benefits, add 3 oz. (0.9 liter) of Wood-Mizer Lube Additive to 1.25 gallons (4.7 liters) of water. Wood-Mizer Lube Additive enables some previously impossible timbers to be cut by significantly reducing resin buildup on the blade. It helps to reduce heat buildup, wavy cuts, and blade noise. This biodegradable and environmentally friendly pre-mix includes a water softener additive, so it works with hard water.



WARNING! Use ONLY water and Wood-Mizer Lube Additive with the water lube accessory. Never use flammable fuels or liquids such as diesel fuel. Failure to do so can damage the equipment and may result in serious injury or death.

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

4.5 Feed Operation

1. Push the feed handle forward to start the blade into the log.

See Figure 4-7.

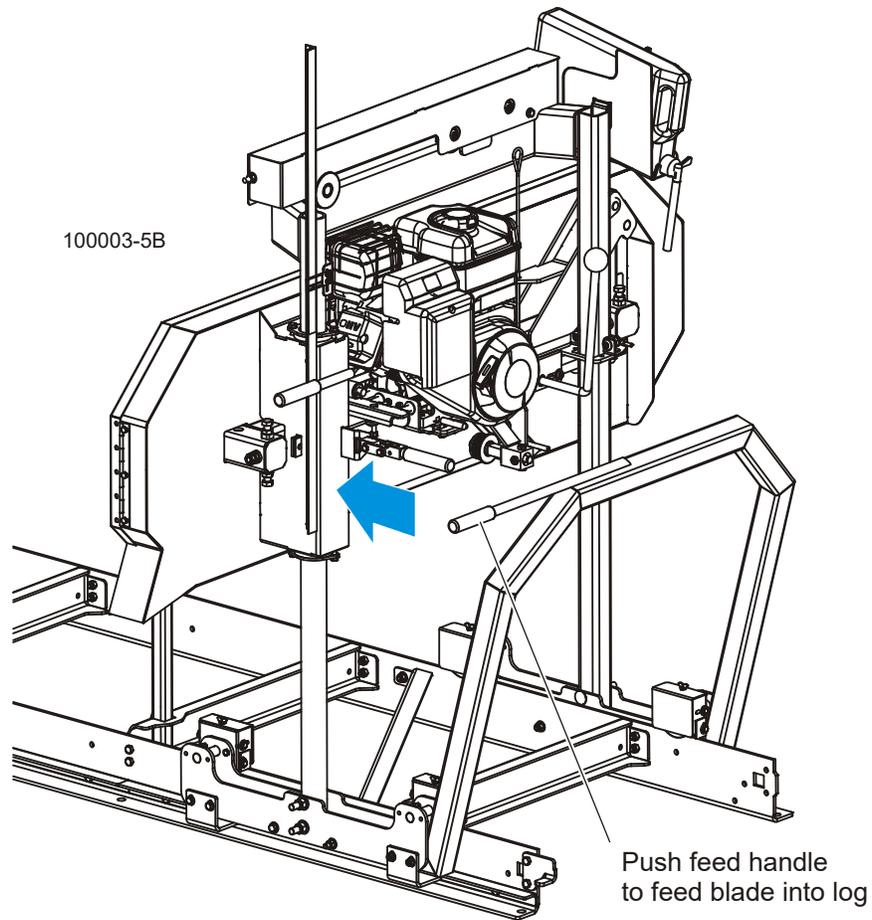


FIG. 4-7 REV. A4.00+

4 Operation

Feed Operation

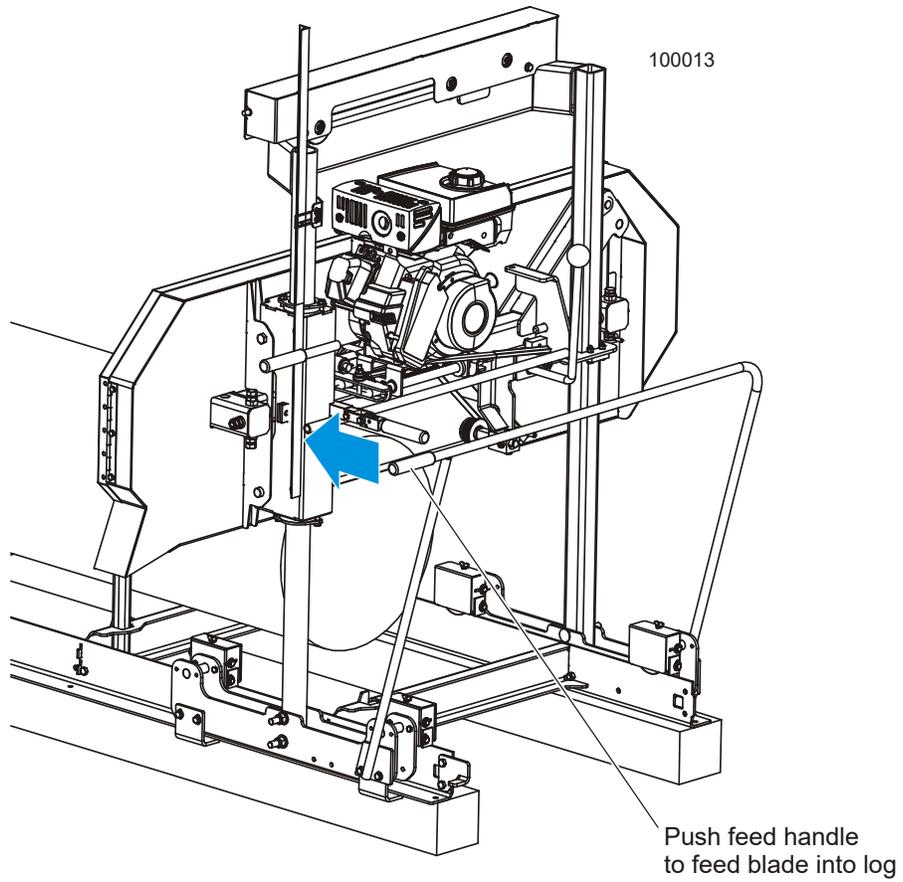


FIG. 4-7 REV. A1.02 - B3.03

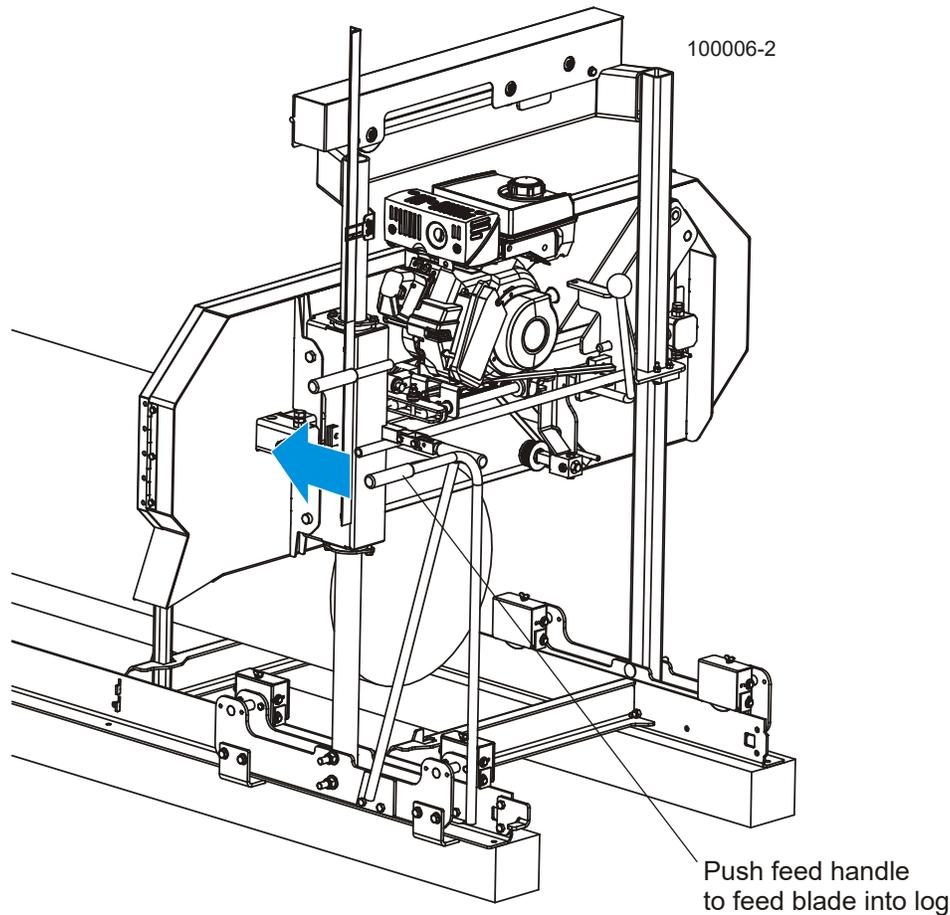


FIG. 4-7 REV. A1.00 - A1.01

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

2. Stop the carriage at the end of the cut.
3. Move the blade engage lever to the OFF position.
4. Set the engine to idle.
5. Remove the board from the top of the log.
6. **Always disengage the blade before returning the carriage for the next cut.** This will not only prevent the blade from being pulled off and ruined by a wood sliver, but also will increase the life of the blade.



CAUTION! Be sure to stop the blade when returning the carriage. Failure to do so may result in machine damage.

7. Raise the saw head to make sure the blade clears the log when returned.
8. Pull back on the feed handle to return the carriage to the front of the log.

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

4.6 Cutting The Log

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

1. Clamp the log firmly in position.
2. Move the blade close to the end of the log.
3. Move the saw head to position the blade for the desired first cut ([See Section 4.2](#)).
4. Make sure that the blade will clear all side supports and the clamp.
5. Make sure all covers and guards are in place.
6. Start the engine and increase the throttle.
7. Move the blade engage lever to the ON position to start the blade spinning ([See Section 4.3](#)).
8. If necessary, start the water lube to prevent sap buildup on the blade ([See Section 4.4](#)).
9. Feed the blade into the log slowly ([See Section 4.5](#)). Once the blade completely enters the log, increase the feed rate as desired.

HINT: Cutting at the fastest speed you can while keeping an accurate cut will increase blade life and production!

10. Slow down toward the end of the log.
11. When the teeth exit the end of the log, stop and move the blade engage lever to the OFF position.
12. Return the engine to idle speed.

13. Remove the slab that you have just cut from the log.
14. Return the carriage to the front of the mill.
15. Lower the saw head to position the blade for the next cut. Use the blade height scale to help determine the correct position of the blade for the thickness board you want.

NOTE: Be sure to add 1/16 - 1/8" (1.6-3.2 mm) to account for the kerf of the blade. If you want 1" (25.4 mm) thick boards, lower the carriage 1 1/16 - 1 1/8" (27-28.6 mm) for each board.

16. Repeat until the first side of the log is cut as desired. Set aside the usable flitches (boards with bark on one or both edges) to edge mill them later.
17. If you used shims to level a tapered log, remove them.
18. Unclamp the log and turn the log 90 or 180 degrees.
19. Make sure the flat on the log is placed flat against side supports if turned 90 degrees. Make sure it is flat on the bed rails if turned 180 degrees. If the log was turned 90 degrees, use the shims again to level a tapered log until the heart is parallel with the bed.
20. Repeat the steps used to cut the first side of the log until the log is square. Cut boards from the remaining cant by adjusting the blade height for the thickness of boards that you want.

4.7 Edging

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

1. Stack the flitches on edge against the side supports.
2. Clamp the flitches against the side supports halfway up the flitch height. (Wider flitches should be placed to the clamp side. When they are edged, flip them over to edge the second side without disturbing the other flitches or without having to pull them from the middle of the stack).
3. Adjust the blade height to edge a few of the widest boards. Make the cut and remove the scrap edges.
4. Loosen the clamp and turn the edged boards over to edge the other side.
5. Repeat steps 1-4.

4**Sawmill Operation***Edging*

6. Loosen the clamp and remove the boards that have good clean edges on both sides. Clamp the remaining flitches and repeat steps 1-5.

SECTION 5 MAINTENANCE

5.1 Blade Guides



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

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

5.2 Sawdust Removal



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



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



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

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

5.3 Carriage Track, Rollers & Scrapers

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

See Figure 5-1.



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

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



CAUTION! Keep track rails free of rust. Formation of rust on the track rail in the areas contacting the track rollers can cause rapid deterioration of the track rail's surface.

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

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

Remove the track roller housing covers and brush any sawdust buildup from the housings. Soak the felt track roller wipers with Dexron III transmission fluid.

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

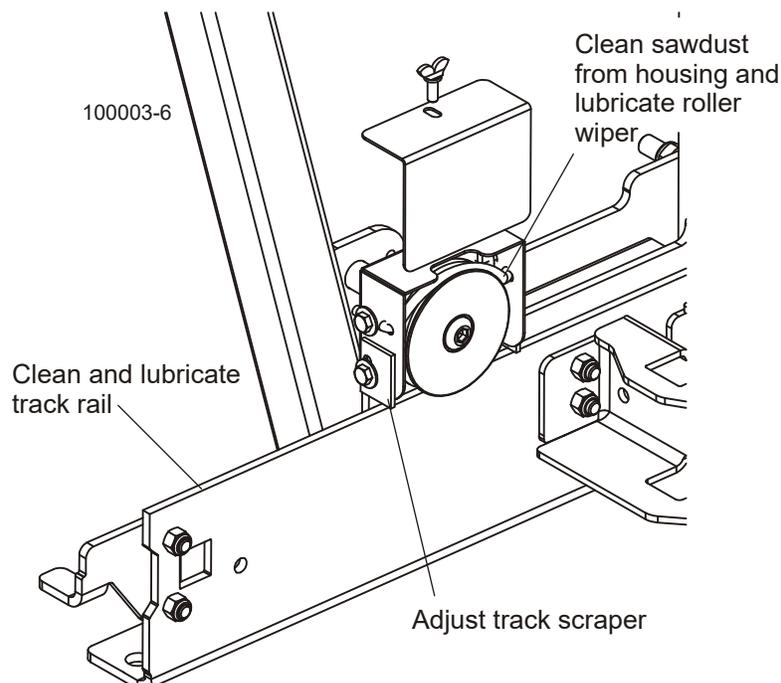


FIG. 5-1

5.4 Vertical Mast Rails

50 ▷

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



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

5.5 Miscellaneous

- 50 **1.** Grease the clamp and up/down lock handle pivots with a NLGI No. 2 grade lithium grease every fifty hours of operation.
- 2.** Check the mill alignment every setup ([See SECTION 3 Setup](#)).
- AR **3.** Lubricate the blade tensioner screw threads with a NLGI No. 2 grade lithium grease as needed.
- 4.** Make sure all safety warning decals are readable. Remove sawdust and dirt. Replace any damaged or unreadable decals immediately. Order decals from your Customer Service Representative.

5.6 Drive Belt Adjustment



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

- 50 **See Table 5-1.** See the table below for drive belt tension specifications for your model sawmill. Measure the belt tension with a gauge. **NOTE:** Wood-Mizer offers a belt tension gauge (Part No. 016309) that will let you accurately measure the belt tension.

Engine /Motor	New Belt Installation/New Sawmill Operation				Subsequent Adjustment		
	Deflection Inches (mm)	Installation Force lbs. (kg)	Check After First	Acceptable Force lbs. (kg)	Then Check Every	Deflection Inches (mm)	Force lbs. (kg)
ALL	5/16" (7.5mm)	14 lbs. (6.35kg)	20 hrs	14 lbs. (6.35kg)	50 hrs	5/16" (9.5mm)	14 lbs. (6.35kg)

TABLE 5-1

- 1.** Open the blade housing covers and remove the blade.
- 2.** Move the blade engage lever to the ON position to tension the belt. Measure the belt tension and adjust if necessary.

5

Maintenance*Drive Belt Adjustment*

3. To adjust the belt tension, use the turnbuckle underneath the engine. Loosen the turnbuckle jam nuts and turn the turnbuckle to tighten or loosen the belt. Tighten the turnbuckle jam nuts.

See Figure 5-2.

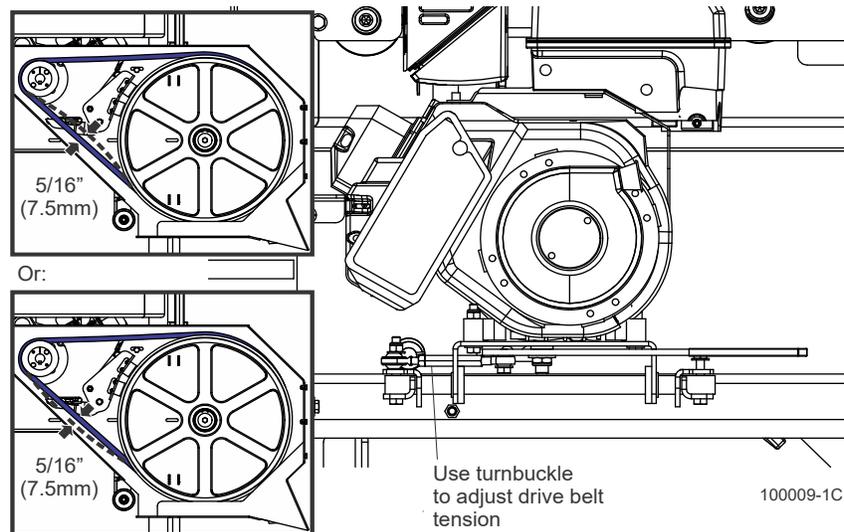


FIG. 5-2

4. **Rev. B1.00+:** After adjusting the drive belt, check the brake actuator adjustment. With the drive belt engaged, the actuator pin should be close to, but not touching the brake plate. Loosen the actuator mounting bolts and adjust the position of the actuator as necessary.

See Figure 5-3.

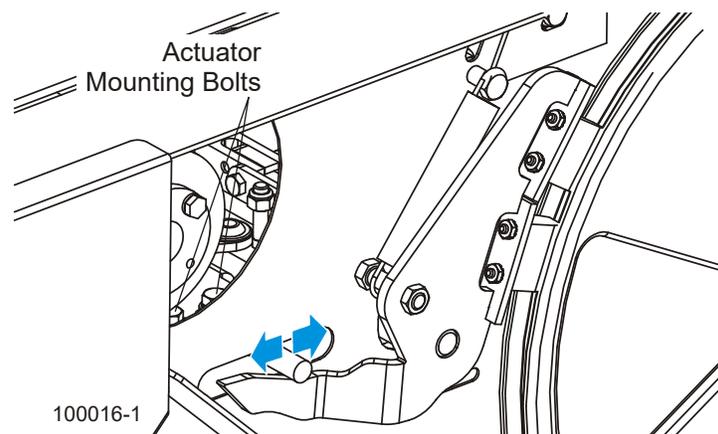


FIG. 5-3



Periodically check the drive belt and idle-side blade wheel belt for wear. Replace any damaged or worn belts as needed.

5.7 Up/Down Assist

The up/down system is equipped with a gas spring assist mechanism to provide improved speed and performance. The saw head must be raised and blocked and tension released from the assist assembly before performing any maintenance to assist components.

 **WARNING!** Release pressure from the up/down assist prior to performing any service to the assembly. Failure to do so may result in the assembly flying apart, causing injury or damage to the equipment.

8 LIFT ASSIST CABLES

Check the up/down lift assist cables daily or between shifts for cuts, cracked coating, fraying, defective cables, or other hazards. Replace as necessary.

LIFT ASSIST

1. Raise the saw head to the full height. Block or secure the saw head with a strap or chain.
2. Locate the up/down assist tension eye bolts. Loosen the jam nuts until tension is removed from the cables.

See Figure 5-4.

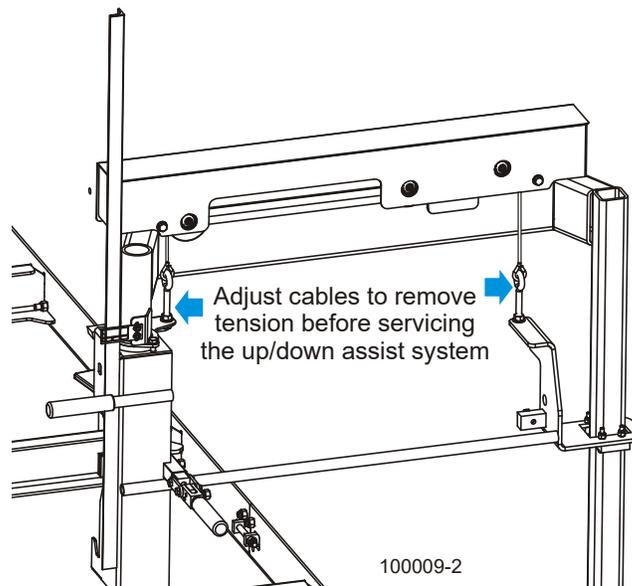


FIG. 5-4

3. The up/down assist assembly can now be safely disassembled and serviced. Do not disassemble the gas spring cylinders.

5 Maintenance

Up/Down Assist

 **WARNING!** Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the machine off and perform the lockout procedure. If the machine is turned on and moving parts activated, serious injury may result.

See Figure 5-5. The LT10 up/down cable routing is shown below.

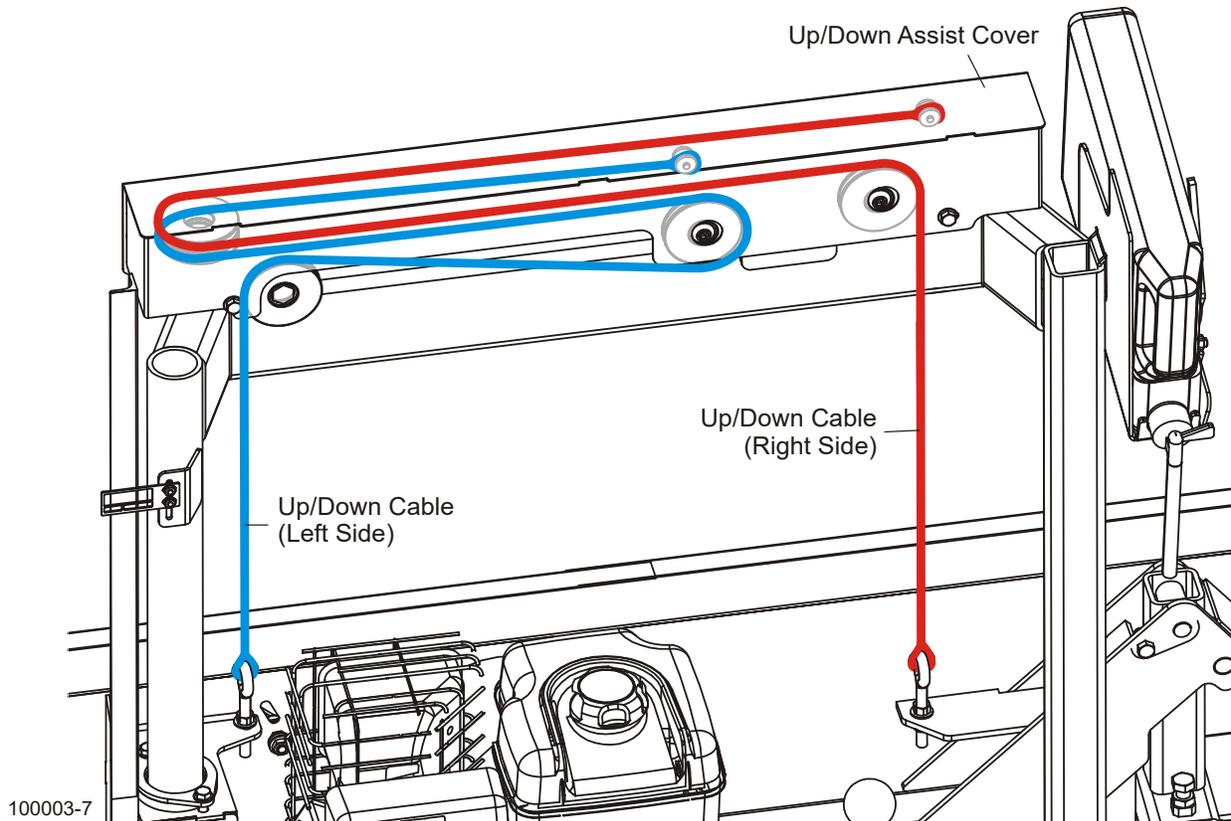


FIG. 5-5

SECTION 6 TROUBLESHOOTING

6.1 Sawing Problems

PROBLEM	CAUSE	SOLUTION
Blades Dull Quickly	Dirty logs	Clean or debark logs, especially on entry side of the cut
	When grinding teeth, heating too much and causing teeth to soften	Grind just enough metal to restore sharpness to the teeth. Use water/coolant while sharpening blade
	Poor sharpening techniques	Make sure the tip is being sharpened completely (See Sharpener Manual)
Blades Break Prematurely	Poor sharpening techniques	See Sharpener Manual
	Rubber belts on blade wheels worn to a point that blade contacts metal pulley - look for shiny spots on edge of wheels	Change blade wheel belts (B-57)
	Tension too tight	Tension blade to recommended specifications
Blade Does Not Track Right on Drive Wheel	Cant adjustment is incorrect	Readjust
	Flat/worn belts	Replace B-57 belts
Blade Guides Do Not Spin While Cutting	Frozen bearings	Replace bearings
Drive Belts Wear Prematurely or Jump	Engine/motor and drive pulleys out of alignment	Align pulleys.

6 Troubleshooting

Sawing Problems

PROBLEM	CAUSE	SOLUTION
Boards Thick Or Thin On Ends Or Middle Of Board.	Stress in log which causes log to not lay flat on the bed.	After log has been squared, take equal cuts off opposing sides. Take a board off the top. Turn the log 180 degrees. Take a board off. Repeat, keeping the heart in the middle of the cant, and making it your last cut.
	Set in teeth.	Resharpen and reset blade.
Head Height Changes	Motor mount clamp too loose.	Tighten motor mount clamp located at the rear of the up/down lock handle.
Lumber Is Not Square	Sawdust or bark between cant and bed rails	Remove particles
	Tooth set problems	Resharpen and reset blade
Sawdust Builds Up On Track	Excessive oiling	Reduce track oiling
	Track wipers worn	Adjust wipers to firmly contact track
	Track is sticky	Clean track with solvent and apply silicone spray
Wavy Cuts	Excessive feed	Slow feed rate
	Improperly sharpened blade (This will be the problem 99% of the time!)	Resharpen blade (See Sharpener Manual - read entire manual!)
	Blade guides improperly adjusted	Adjust blade guides.
	Sap buildup on blade	Use Water Lube.
Saw head hard to move up and/or down	Tooth set problem	Resharpen and reset blade
	Sawdust buildup on gas springs	Clean gas springs
	Binding in the mast on the round post	Fix the binding in the mast on the round post
	Not enough lubrication on the round post	Lubricate the round post with transmission fluid
	Saw head not parallel to the frame	Adjust the saw head so it is parallel to the frame or 1/32" (0.8mm) higher on the outside
	Square post not adjusted properly or plastic bushings too tight	Adjust the square post on the outside of the C-frame and loosen the plastic bushings if necessary
	Up/down cables not in pulleys or not routed properly	Place up/down cables in pulleys and correct routing
	Gas springs not working properly	Replace gas springs

SECTION 7 ALIGNMENT

The Wood-Mizer sawmill is factory aligned. The blade tracking and blade guide adjustment instructions should be performed as necessary to solve sawing problems related to blade performance.

7.1 Blade Tracking

1. Make sure the blade housing covers are closed and all persons are clear of the area around the blade.
2. Start the engine.
3. Engage the blade, rotating the blade until the blade positions itself on the wheels.



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

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

See **Figure 7-1**. Position 1 1/4" wide blades so the gullet is 1/8" (3.0 mm) out from the edge of the blade wheel ($\pm 1/32$ [.75 mm]).

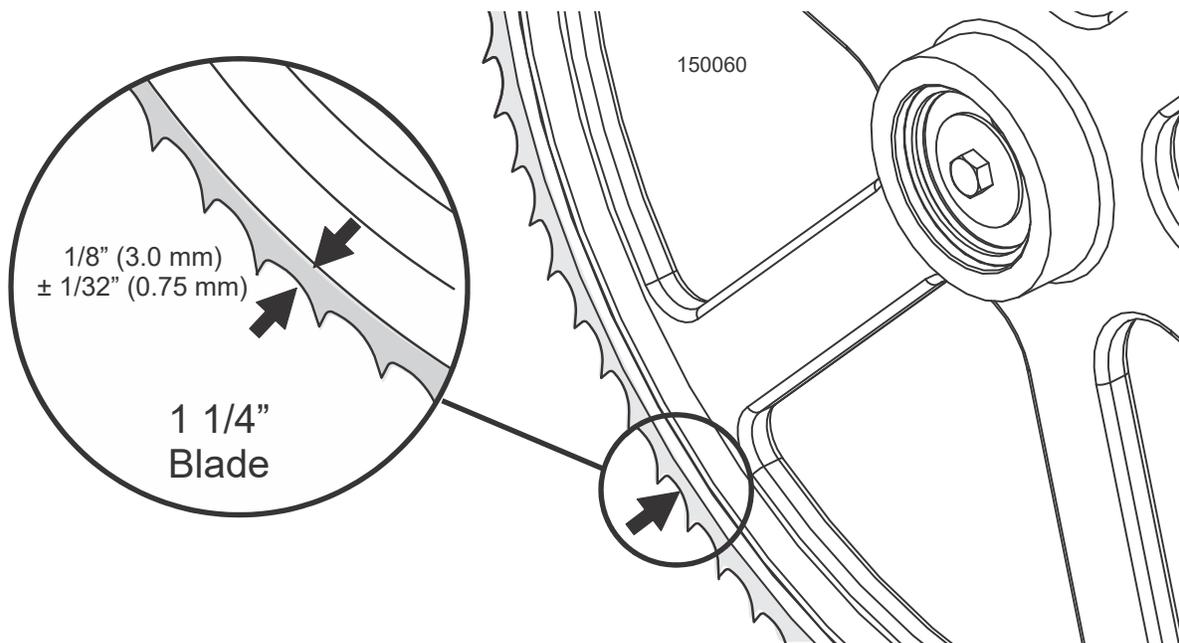


FIG. 7-1

7 Alignment

Blade Tracking

See **Figure 7-2**. To adjust where the blade travels on the blade wheels, use the cant control. **NOTE:** Do not loosen the locking nuts at the other end of the cant control bolt.

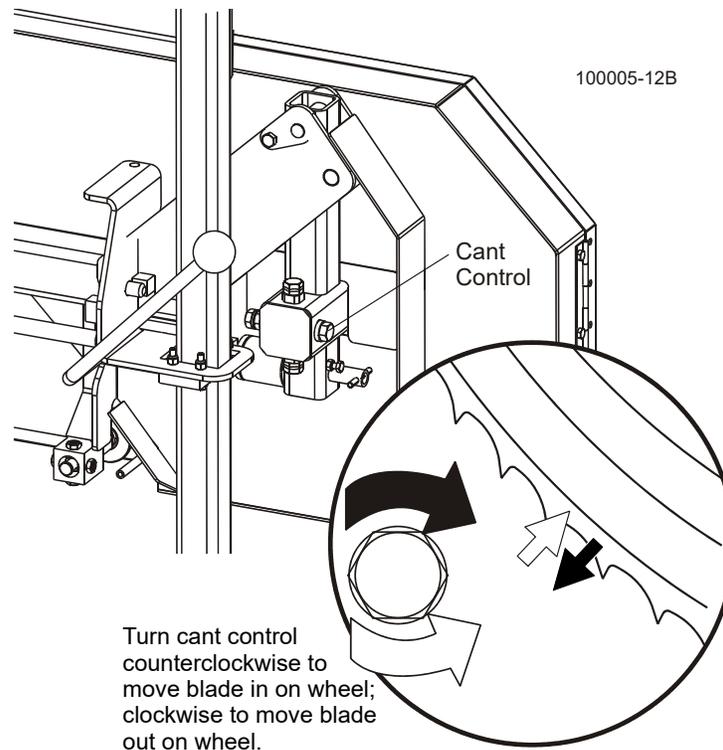


FIG. 7-2

If the blade is too far out, back the blade onto the wheel by turning the cant control counterclockwise. If the blade is too far in, turn the cant control clockwise until the gullet of the blade is the correct distance from the front edge of the wheel.

5. Adjust the blade tension if necessary to compensate for any changes that may have occurred while adjusting the cant control.
6. Close the blade housing covers.

 **DANGER!** Make sure all guards and covers are in place and secured before operating the sawmill. Failure to do so may result in serious injury. Be sure the blade housing and pulley covers are in place and secure.

 **IMPORTANT!** After aligning the blade on the wheels, always double-check the blade guide spacing and location. ([See Section 7.2](#) for more information.)

7.2 Blade Guide Adjustment

After the blade is tensioned and tracked on the blade wheels, check alignment of the blade guide rollers. To check the blade guides, disengage the up/down lock and move the saw head up or down so it is positioned approximately at the center of the vertical mast. Engage the up/down lock handle.

Blade Guide Vertical Tilt Adjustment

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

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

1. Clip the alignment tool on the blade. Position the tool close to the outer blade guide assembly. Be sure the tool does not rest on a tooth or burr, and is lying flat against the bottom of the blade.

See Figure 7-3.

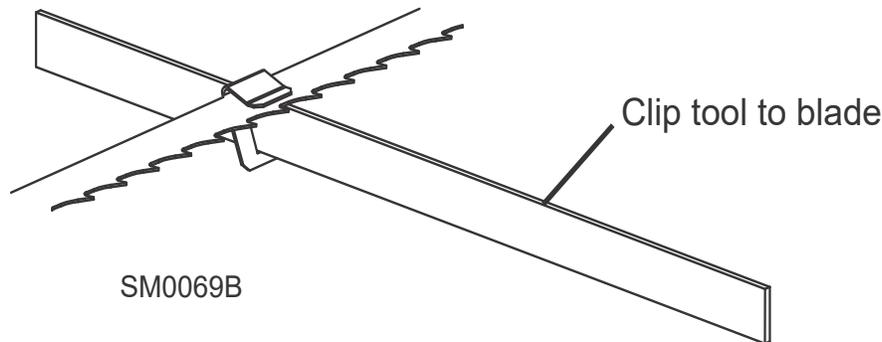


FIG. 7-3

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

7

Alignment

Blade Guide Horizontal Tilt Adjustment

See Figure 7-4. Loosen the jam nuts on the top and bottom vertical tilt adjustment screws. To tilt the roller up, loosen the bottom screw and tighten top screw. To tilt the roller down, loosen the top screw and tighten the bottom screw. Tighten the jam nuts and recheck the tilt of the blade.

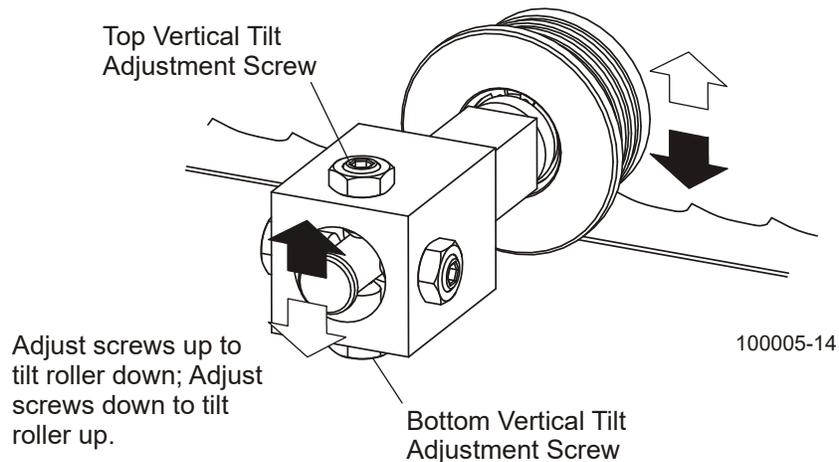


FIG. 7-4

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

Blade Guide Horizontal Tilt Adjustment

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

7. Remove the blade guide alignment tool from the blade.
8. Remove the clip from the blade guide alignment tool. Place the tool against the face of the outer blade guide roller.

See Figure 7-5.

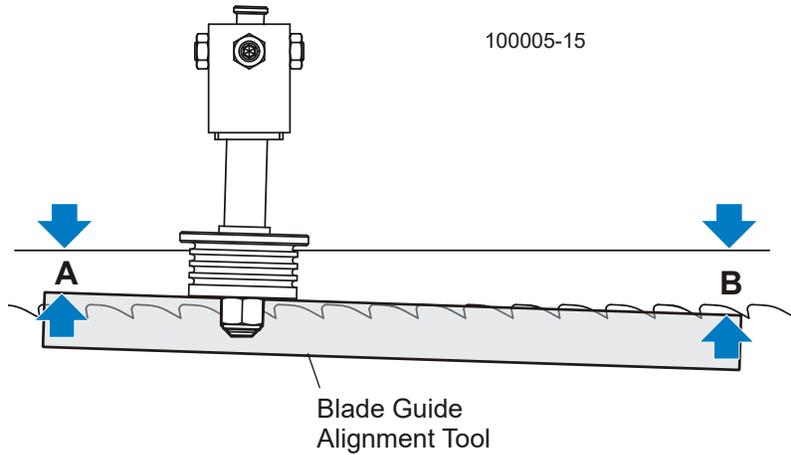


FIG. 7-5

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

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

See Figure 7-6. Loosen the jam nuts on the horizontal tilt adjustment screws. To tilt the roller left, loosen the right screw and tighten left screw. To tilt the roller right, loosen the left screw and tighten the right screw. Tighten the jam nuts and recheck the tilt of the blade.

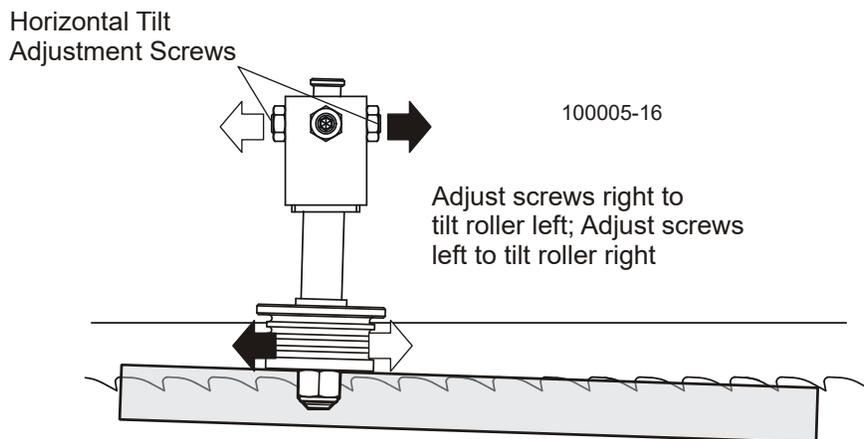


FIG. 7-6

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

7 Alignment

Blade Guide Flange Spacing

Blade Guide Flange Spacing

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

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

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

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

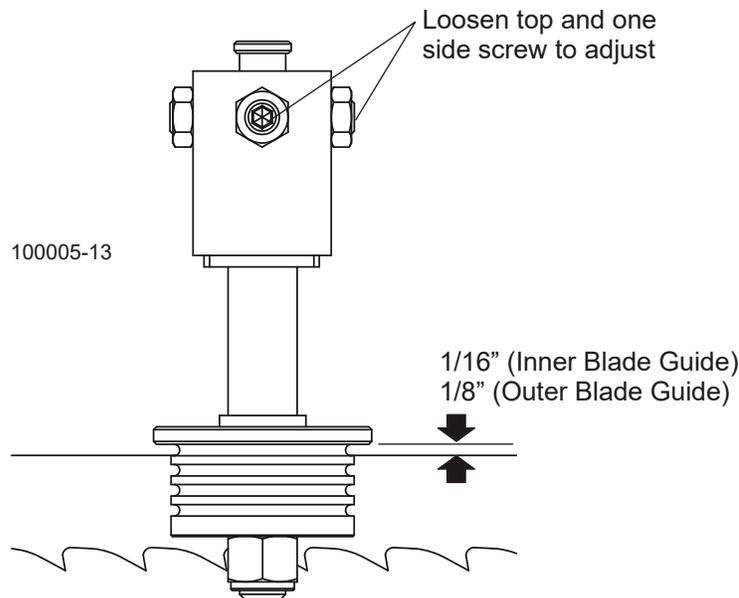


FIG. 7-7

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

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

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