

Resaw Attachment

Safety, Operation, Maintenance, & Parts Manual

RS2

rev. A1.00+



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

August 2009

Form #1624

California
Proposition 65 Warning



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

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

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



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

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

Active Patents assigned to Wood-Mizer, LLC

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

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SECTION 1 SETUP & OPERATION

With the Wood-Mizer Resaw Attachment Option, you can resaw cants up to 9" (225 mm) thick and 18" (450 mm) wide. The Resaw Attachment mounts to the sawmill bed. The carriage head of the sawmill remains stationary (in a fixed position) while a powered conveyor belt on the attachment feeds cants through the saw blade. The following instructions will guide you in installation, operation, and maintenance of the Resaw Attachment.

See Figure 1-1. The Resaw Attachment includes the following:

- Feed assembly
- Two wiring harnesses
- Two carriage locking clamps

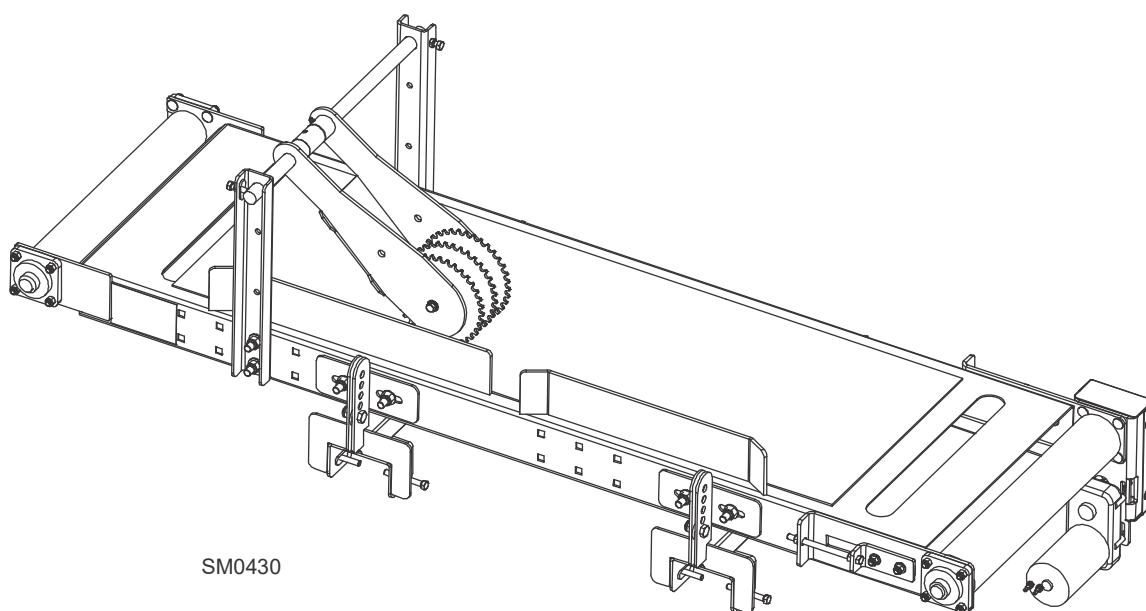


FIG. 1-1

1.1 Pre-Installation

1. Remove the carriage locking clamps from the shafts located across the top of the feed assembly. The clamps will be used later during installation of the Resaw Attachment to the sawmill bed.



WARNING! Before performing any service to the sawmill control box panel, turn the key to the OFF position, disconnect the negative battery lead, and remove all rings, watches, etc.... Failure to do so may cause serious injury and machine damage.

2. Raise the cutting head. Remove the battery/power feed cover. Disconnect the negative lead of the battery.

See Figure 1-2.

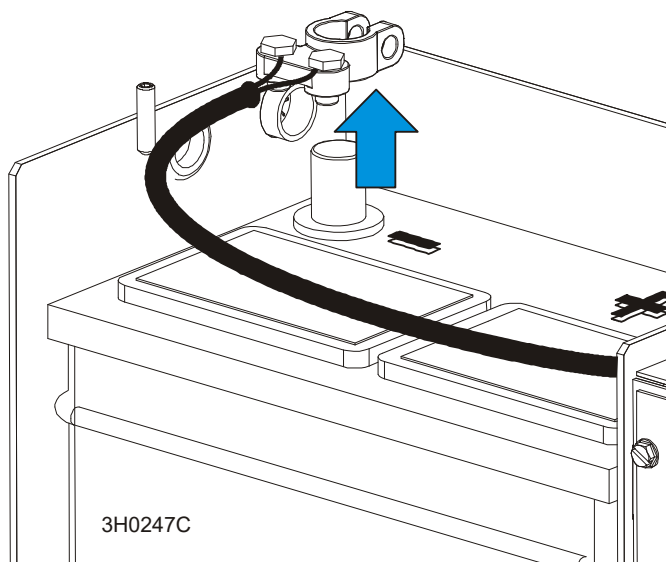



FIG. 1-2

3. Identify the harnesses required for your application.


1 Setup & Operation

Pre-Installation


All Sawmills (except LT28 Rev. A6.02+ and LT35)

								
10" plug harness w/ring terminals	LT15PF Prior to rev B	LT28 Rev. A1.00 - A6.01	LT28 Rev. A6.02+	LT35	'97+ Std. LT30/40	'97+ Super LT30/40/50	'92 - '96 Std. & Super LT30/40	Pre-'92 LT30/40
Connect to:	Feed motor	Feed motor			Feed motor	Feed cable	Feed motor	Feed motor


LT15 with LT15PF rev B and later only

								
10" plug harness w/o terminals	LT15PF After rev B	LT28 Rev. A1.00 - A6.01	LT28 Rev. A6.02+	LT35	'97+ Std. LT30/40	'97+ Super LT30/40/50	'92 - '96 Std. & Super LT30/40	Pre-'92 LT30/40
Connect to:	Feed cable							

LT15, LT28 Rev. A6.02+ and LT35 Only

								
10" plug harness w/o terminals	LT15PF Prior to rev B	LT28 Rev. A1.00 - A6.01	LT28 Rev. A6.02+	LT35	'97+ Std. LT30/40	'97+ Super LT30/40/50	'92 - '96 Std. & Super LT30/40	Pre-'92 LT30/40
Connect to:	Feed control		Feed cable	Feed cable				

All Sawmills (except LT15, LT28 Rev. A6.02+ and LT35)

								
24" plug harness w/ring terminals	LT15	LT28 Rev. A1.00 - A6.01	LT28 Rev. A6.02+	LT35	'97+ Std. LT30/40	'97+ Super LT30/40/50	'92 - '96 Std. & Super LT30/40	Pre-'92 LT30/40
Connect to:		Feed cable			Feed cable	Feed motor	Feed cable	Feed control

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1.2 Electrical Installation for '97+ Super Mills



IMPORTANT! This section contains wiring instructions for 1997 and later SUPER model LT30 Super, LT40 Super, LT30HD Super, or LT40HD Super mills.

If you have a 1997 or later STANDARD model LT30, LT40, LT30HD, LT40HD or LT28 Rev. A1.00 - A6.01 mill or if you have a 1992-1996 model mill, follow the wiring installation instructions found in [Section 1.3 Electrical Installation for '97+ Standard Mills. All '92-'96 Mills and LT35 Rev. A4.00+ Mills.](#)

If you have a mill manufactured prior to 1992, follow the wiring installation instructions found in [Section 1.4 Electrical Installation for Pre-'92 Mills.](#)

If you are installing the RS2 to an LT15 with an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#)

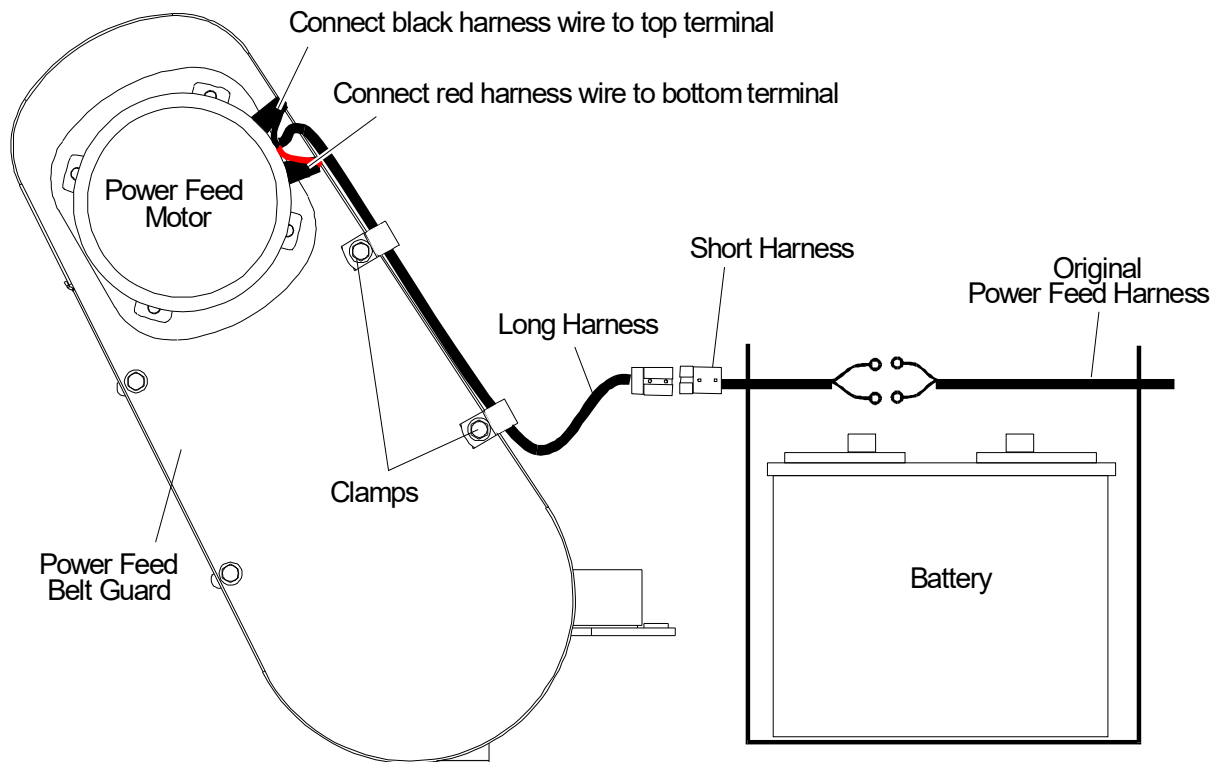
If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF prior to revision B and earlier**, follow the wiring instructions found in [Section 1.7 Electrical Installation for LT15 Mills \(Without H-Bridge\).](#)

1. Remove the existing wires from the two terminal posts on the power feed motor. (Set the top retaining nut, top washer, and rubber boot from each connection aside.)
2. Unclamp the wires from the power feed belt guard and route them back through the side of the battery box.
3. Slide one of the existing rubber boots over each wire of the provided long harness.

Connect the black harness wire to the top motor terminal. Connect the red harness wire to the bottom motor terminal. Secure each connection in place with the existing washers and retaining nuts removed earlier. Cover each connection with the rubber boots installed to the wires earlier.

4. Route the long harness along the side of the power feed belt guard, using the existing clamps to secure in place.
5. Connect the long harness to the provided short harness.
6. Route the short harness through the battery box as shown.

See Figure 1-3.



3-019B

FIG. 1-3

7. Connect the wires that were originally connected to the power feed motor to the short harness with the supplied rubber tubing by bundling the two harness wires together with the small tie wrap.
8. Connect the red power feed wire to the red harness wire with a screw and a self-locking nut.
9. Connect the black power feed wire to the black harness wire with a screw and a self-locking nut.
10. Slip one end of the rubber tube around each wire/harness connection.
11. Secure the tubing around the connections with the large tie wrap.

See Figure 1-4.

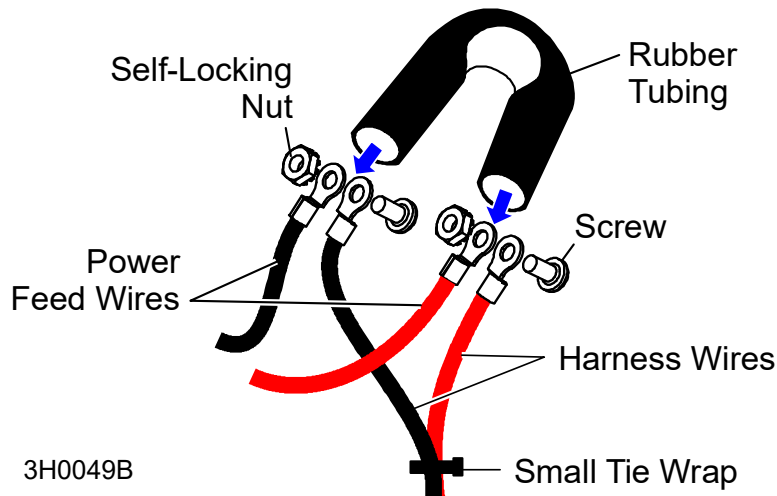


FIG. 1-4

12. Connect the long harness from the power feed motor and the short harness from the battery box.
13. Replace the negative battery lead and check that the power feed operates normally with the control panel.

NOTE: To operate the Resaw Attachment, disconnect the harnesses and connect the harness from the Resaw Attachment to the battery box harness. Use the CARRIAGE switch and FEED RATE dial on the control panel to operate the Resaw Attachment.

14. Replace the battery/power feed cover.

[See Section 1.8](#) to install the Resaw Attachment to the sawmill.

1.3 Electrical Installation for '97+ Standard Mills, All '92-'96 Mills and LT35 Rev. A4.00+ Mills



IMPORTANT! This section contains wiring instructions for 1997 and later STANDARD model LT28 Rev. A1.00 - A6.01 (w/optional power feed), LT35 Rev. A4.00+, LT30, LT40, LT30HD, or LT40HD mills and 1992-1996 model mills.

If you have a 1997 or later SUPER model LT30 Super, LT40 Super, LT30HD Super or LT40HD Super mill, follow the wiring installation

instructions found in [Section 1.2 Electrical Installation for '97+ Super Mills](#).

If you have a mill manufactured prior to 1992, following the wiring installation instructions found in [Section 1.4 Electrical Installation for Pre-'92 Mills](#).

If you are installing the RS2 to an LT28 Rev. A6.02+ or LT35 Rev. A1.00 - A3.00 model sawmill, follow the wiring instructions found in [Section 1.5 Electrical Installation for LT28 Rev. A6.02+ and LT35 Rev. A1.00 - A3.00 Mills](#).

If you are installing the RS2 to an LT15 with an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#).

If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF prior to revision B and earlier**, follow the wiring instructions found in [Section 1.7 Electrical Installation for LT15 Mills \(Without H-Bridge\)](#).

1. Remove the pulley from the power feed motor shaft. Unbolt and remove the power feed motor from the motor mount. If you have a 5 HP motor originally supplied before July

1996, remove the two screws that hold the motor end cap to the motor and remove the cap. Newer motors do not have end caps covering the terminal posts.

See Figure 1-5.

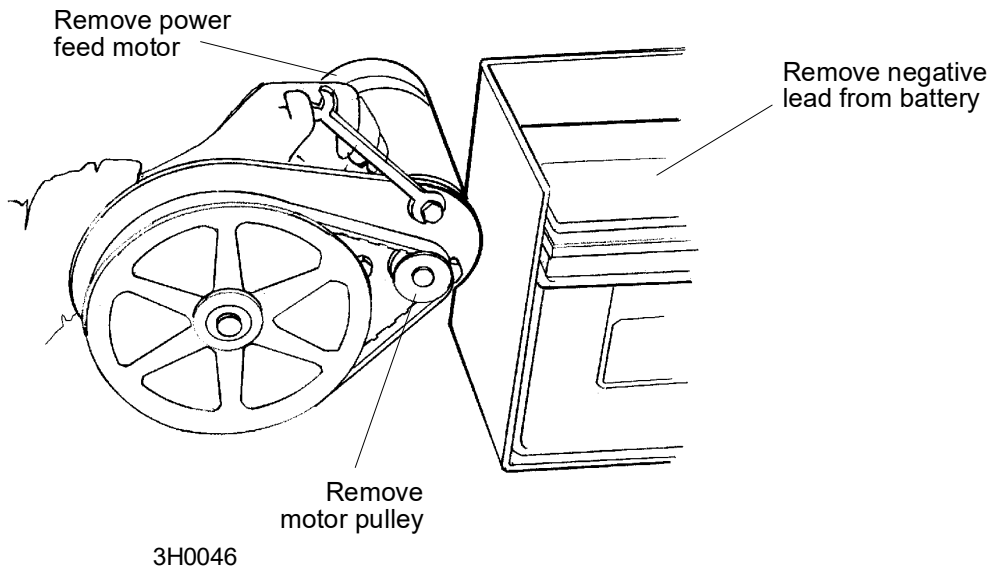


FIG. 1-5

2. Note how the red and black wires are connected to the motor terminals. Remove the retaining nut and wires from each terminal. If applicable, pull the wires out of the motor end cap grommet. Route the wires back through the side of the battery box.
3. If applicable, place the short harness cable through the motor end cap grommet. **NOTE:** A lubricant may be necessary to fit the harness through the grommet. Connect the red harness wire to motor terminal where the old red wire was attached. Connect the black harness wire to the other motor terminal. Secure the wires so the ring terminals will not contact the motor housing or the motor end cap and replace the terminal nuts.

See Figure 1-6.

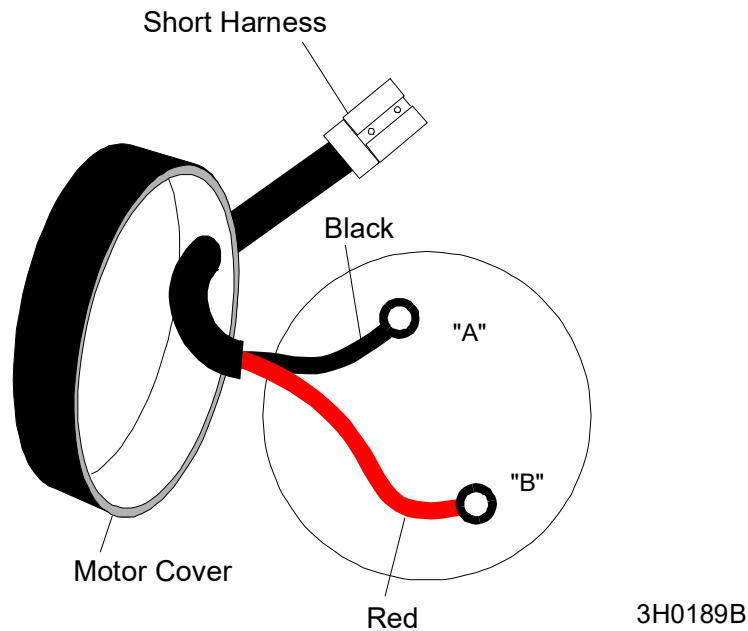


FIG. 1-6

4. If applicable, position the harness at the top left of the motor and replace the motor end cap and screws. Rebolt the power feed motor and replace the pulley and belt guard.
5. Route the long harness through the battery box as shown.

See Figure 1-7.

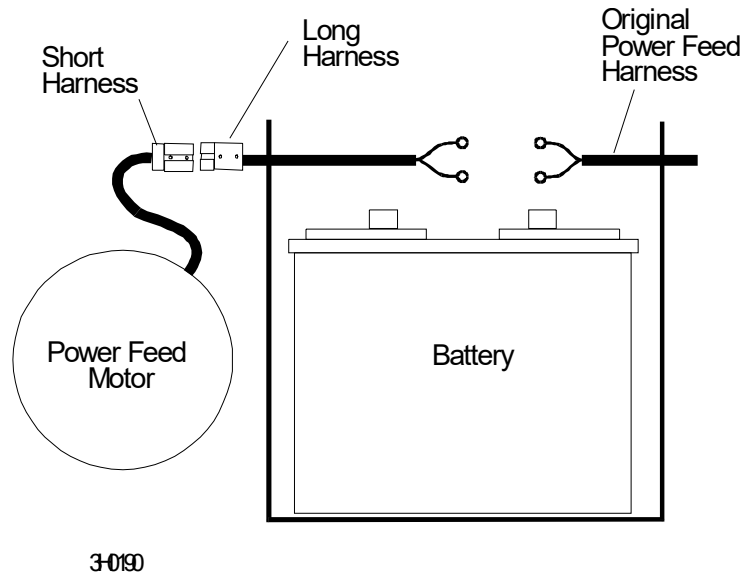


FIG. 1-7

6. Connect the wires that were originally connected to the power feed motor to the long harness with the supplied rubber tubing.

See Figure 1-8. To connect, bundle the two harness wires together with the small tie wrap. Connect the blue power feed wire to the red harness wire with a screw and a self-locking nut. Connect the green power feed wire to the black harness wire with a screw and a self-locking nut. Slip one end of the rubber tube around each wire/harness connection. Secure the tubing around the connections with the large tie wrap.

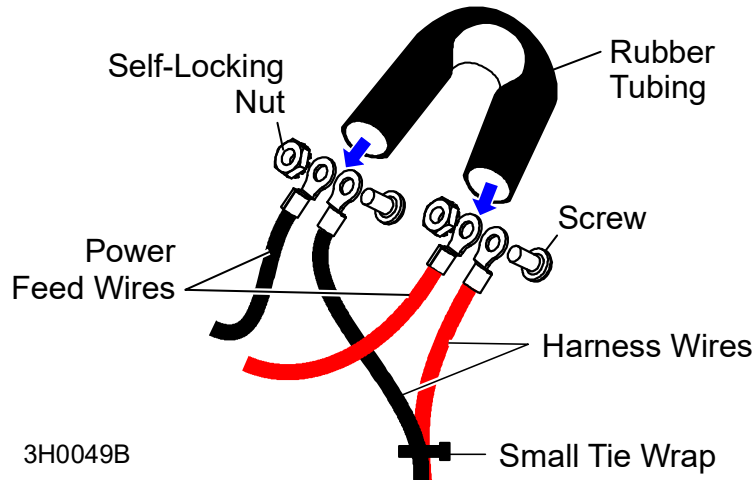


FIG. 1-8

7. Connect the short harness from the power feed motor and the long harness from the battery box. Replace the negative battery lead and check that the power feed operates normally with the control panel. **NOTE:** To operate the Resaw Attachment, disconnect the harnesses and connect the harness from the Resaw Attachment to the battery box harness. Use the CARRIAGE switch and FEED RATE dial on the control panel to operate the Resaw Attachment.
8. Replace the battery/power feed cover.

[See Section 1.8](#) to install the Resaw Attachment to the sawmill.

1.4 Electrical Installation for Pre-'92 Mills



IMPORTANT! This section contains wiring instructions for mills manufactured prior to 1992.

If you have a 1997 or later SUPER model LT30 Super, LT40 Super, LT30HD Super or LT40HD Super mill, follow the wiring installation instructions found in [Section 1.2 Electrical Installation for '97+ Super Mills](#).

If you have a 1997 or later STANDARD model LT30, LT40, LT30HD, LT40HD or LT28 Rev. A1.00 - A6.01 mill or if you have a 1992-1996 model mill, follow the wiring installation instructions found in [Section](#)

[1.3 Electrical Installation for '97+ Standard Mills, All '92-'96 Mills and LT35 Rev. A4.00+ Mills.](#)

If you are installing the RS2 to an LT28 Rev. A6.02+ or LT35 model sawmill, follow the wiring instructions found in [Section 1.5 Electrical Installation for LT28 Rev. A6.02+ and LT35 Rev. A1.00 - A3.00 Mills.](#)

If you are installing the RS2 to an LT15 with an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#)

If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF prior to revision B and earlier**, follow the wiring instructions found in [Section 1.7 Electrical Installation for LT15 Mills \(Without H-Bridge\)](#).

1. Remove the two screws holding the cover to the power feed motor and set the cover aside.
2. Locate the two terminal posts "A" and "B" and remove the retaining nuts from both terminals. Remove all wires from the motor terminals and pull them out through the motor cover grommet.
3. Install the short male harness to the power feed motor.

See Figure 1-6. Route the harness cable through the motor cover grommet. A lubricant may be necessary to fit the harness through the grommet.

4. Connect the red harness wire to motor terminal "B".
5. Connect the black harness wire to motor terminal "A".
6. Replace the terminal nuts being sure the wires are secured in a position so that the ring terminals will not contact the motor cover.
7. Replace the motor cover and screws so that the harness is positioned at the top left of the motor. **See Figure 1-7.**
8. Route the wires that were originally connected to the power feed motor up through the bottom of the control box.
9. Remove the control box cover and connect the motor wires to the long harness with the neoprene tube as described below.

10. Install the long harness through the control box grommet. Use the small tie wrap to bundle the two harness wires together as shown.
11. Connect the blue power feed wire to the red harness wire with a screw and a self-locking nut.
12. Connect the green power feed wire to the black harness wire with a screw and a self-locking nut.
13. Slip the supplied rubber tube around both wire/harness connections as shown. **See Figure 1-8.**
14. Keep the tubing folded tight while using a large tie wrap to secure the bundled connection to the yellow, red and brown wire harness in the control box.
15. Tuck the excess length of wires into the left front corner of the control box and replace the control box cover.
16. Connect the harness from the power feed motor and the harness from the control box. Use the remaining tie wraps to strap the harnesses together as shown.

The power feed should operate normally with the drum switch and control box as before. To operate the Resaw Attachment, disconnect the harnesses and connect the harness from the Resaw Attachment to the control box harness. The drum switch and control box switch will now operate the Resaw Attachment.

See Figure 1-9.

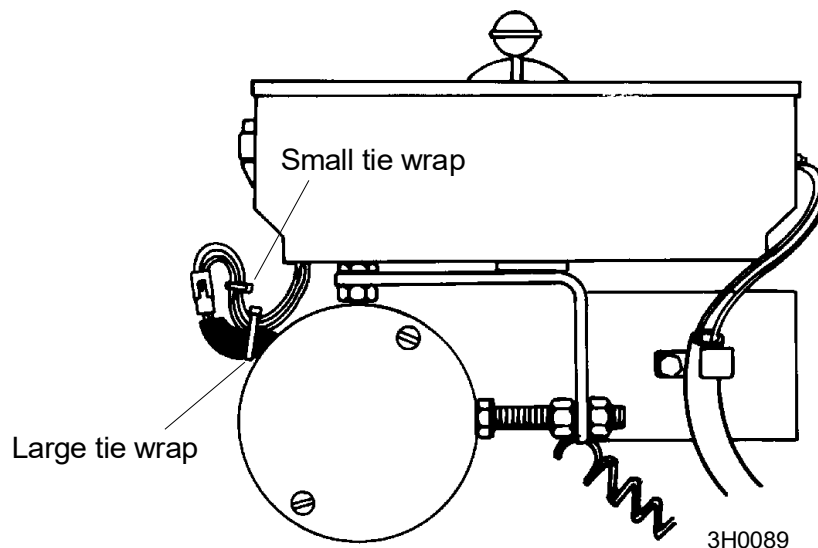


FIG. 1-9

[See Section 1.8](#) to install the Resaw Attachment to the sawmill.

1.5 Electrical Installation for LT28 Rev. A6.02+ and LT35 Rev. A1.00 - A3.00 Mills



IMPORTANT! This section contains wiring instructions for model LT28 Rev. A6.02 and later mills and LT35 mills.

If you have a 1997 or later SUPER model LT30 Super, LT40 Super, LT30HD Super or LT40HD Super mill, follow the wiring installation instructions found in [Section 1.2 Electrical Installation for '97+ Super Mills](#).

If you have a 1997 or later STANDARD model LT30, LT40, LT30HD, LT40HD, LT28 Rev. A1.00 - A6.01 and LT35 Rev. A4.00+ mill or if you have a 1992-1996 model mill, follow the wiring installation instructions found in [Section 1.3 Electrical Installation for '97+ Standard Mills, All '92-'96 Mills and LT35 Rev. A4.00+ Mills](#).

If you have a mill manufactured prior to 1992, follow the wiring installation instructions found in [Section 1.4 Electrical Installation for Pre-'92 Mills](#).

If you are installing the RS2 to an LT15 with an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#).

If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF prior to revision B and earlier**, follow the wiring instructions found in [Section 1.7 Electrical Installation for LT15 Mills \(Without H-Bridge\)](#).

1. Locate and disconnect the power feed cable from the power feed motor. Install a provided 1/4" quick male terminal to each wire of the provided 10" plug harness without terminals.

See Figure 1-10.

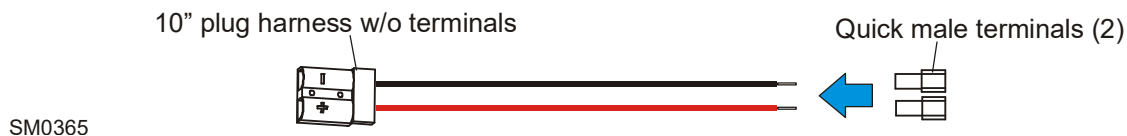


FIG. 1-10

2. Connect one end of the 10" plug harness to the power feed cable from the battery box. Connect the other end of the 10" plug harness to the harness from the Resaw Attachment. The power feed switch will now operate the Resaw Attachment.

See Figure 1-11.

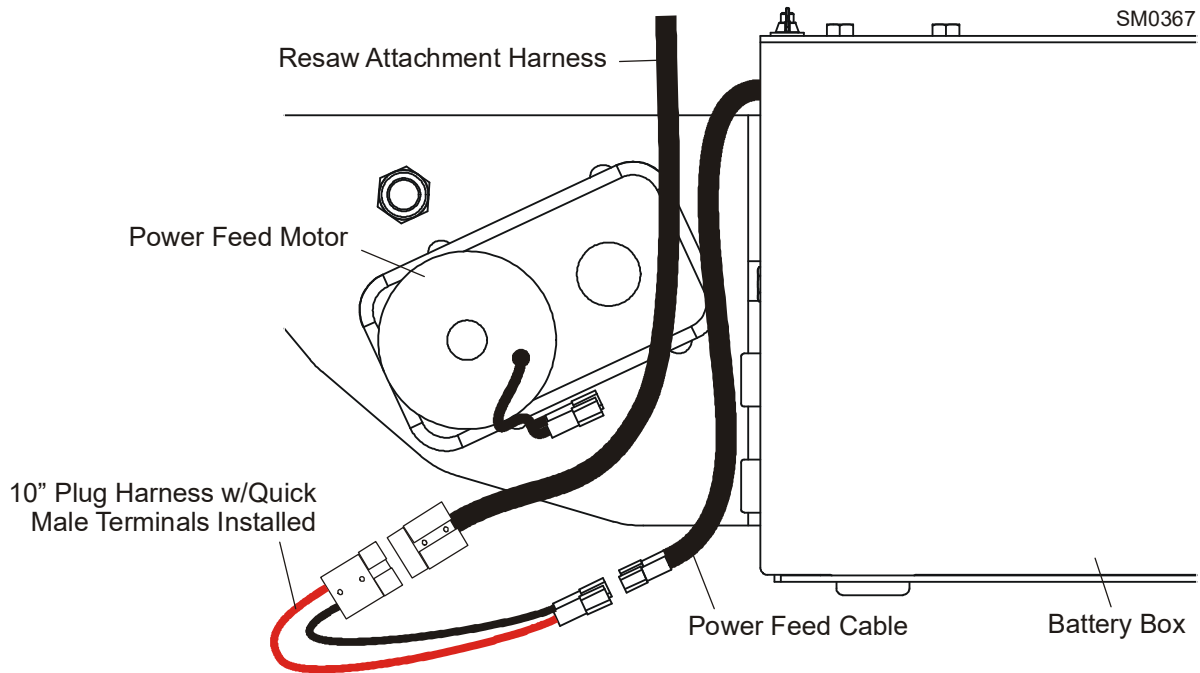


FIG. 1-11

[See Section 1.8](#) to install the Resaw Attachment to the sawmill.

1.6 Electrical Installation for LT15 Mills (With H-Bridge)

AFTER 12/4/2017: LT15PF REVISION B.00 AND LATER



IMPORTANT! This section contains wiring instructions for Rev. E4.00 and later model LT15 mills (equipped with power feed option **LT15PF revision B and later** only).

If you have a 1997 or later SUPER model LT30 Super, LT40 Super, LT30HD Super or LT40HD Super mill, follow the wiring installation instructions found in [Section 1.2 Electrical Installation for '97+ Super Mills](#).

If you have a 1997 or later STANDARD model LT30, LT40, LT30HD, LT40HD or LT28 Rev. A1.00 - A6.01 mill or if you have a 1992-1996

model mill, follow the wiring installation instructions found in [Section 1.3 Electrical Installation for '97+ Standard Mills, All '92-'96 Mills and LT35 Rev. A4.00+ Mills.](#)

If you have a mill manufactured prior to 1992, follow the wiring installation instructions found in [Section 1.4 Electrical Installation for Pre-'92 Mills.](#)

If you are installing the RS2 to an LT28 Rev. A6.02+ or LT35 model sawmill, follow the wiring instructions found in [Section 1.5 Electrical Installation for LT28 Rev. A6.02+ and LT35 Rev. A1.00 - A3.00 Mills.](#)

If you are installing the RS2 to an LT15 with an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#)

If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF prior to revision B and earlier**, follow the wiring instructions found in [Section 1.7 Electrical Installation for LT15 Mills \(Without H-Bridge\).](#)

DRUM SWITCH CONNECTION

1. Remove the clamping nut from the strain relief on the bottom of the power feed control box; slide it down the harness.
2. Remove the control box front cover.

On the drum switch, the red power feed motor wire is on terminal #3 and the black motor wire is on terminal #4.

3. Disconnect the power feed motor wires, cut off the fork terminals, and pull the wires out of the control box.
4. Install the provided ring terminals on the power feed motor wires.
5. Route the provided LT15 wire harness through clamping nut and the strain relief opening into the control box.
6. Remove the precut insulation from the ends of the LT15 wire harness and install the provided fork terminals on the wires.
7. Connect the harness wires to the power feed drum switch.

The red wire connects to terminal #3 and the black wire connects to terminal #4. Bend the fork terminals as necessary.

8. Tighten the clamping nut on the strain relief.
9. Replace the power feed control box front panel.

See Figure 1-12.

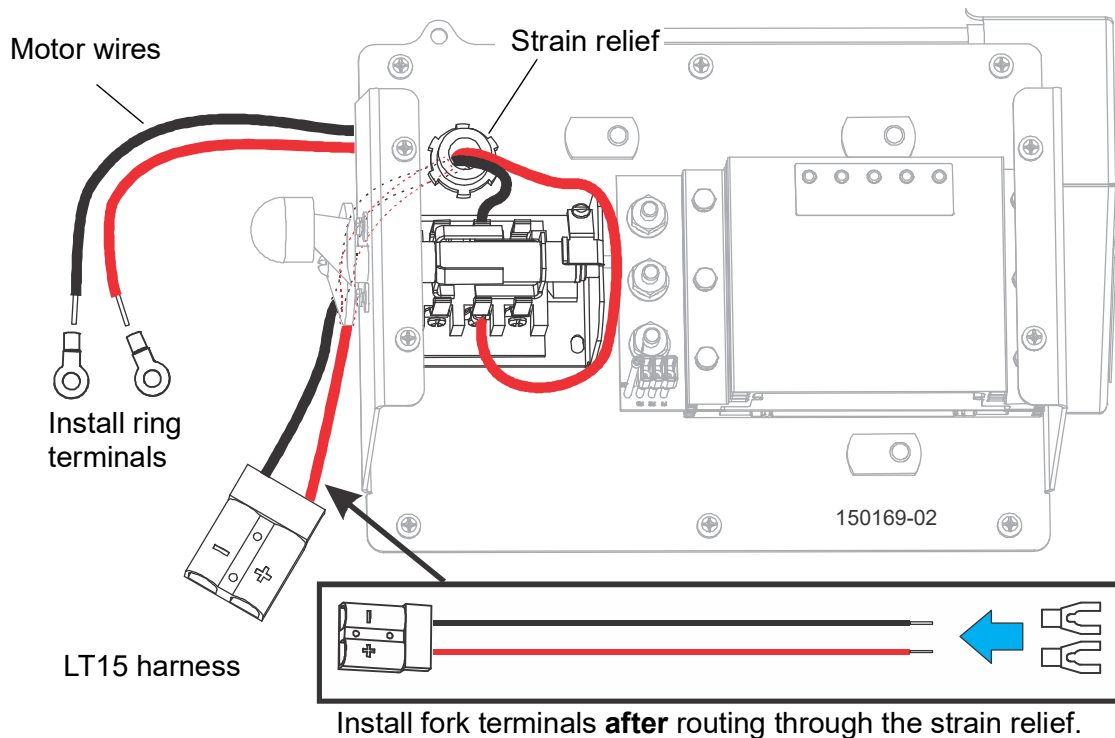


FIG. 1-12

FEED MOTOR WIRES

Refer to Figure 1-13.

10. Bundle the two harness wires together with the small tie wrap.
11. Connect the red power feed wire to the red harness wire with a screw and a self-locking nut.
12. Connect the black power feed wire to the black harness wire with a screw and a self-locking nut.

13. Slip one end of the rubber tube around each wire/harness connection and secure the tubing around the connections with a tie wrap.

See Figure 1-13.

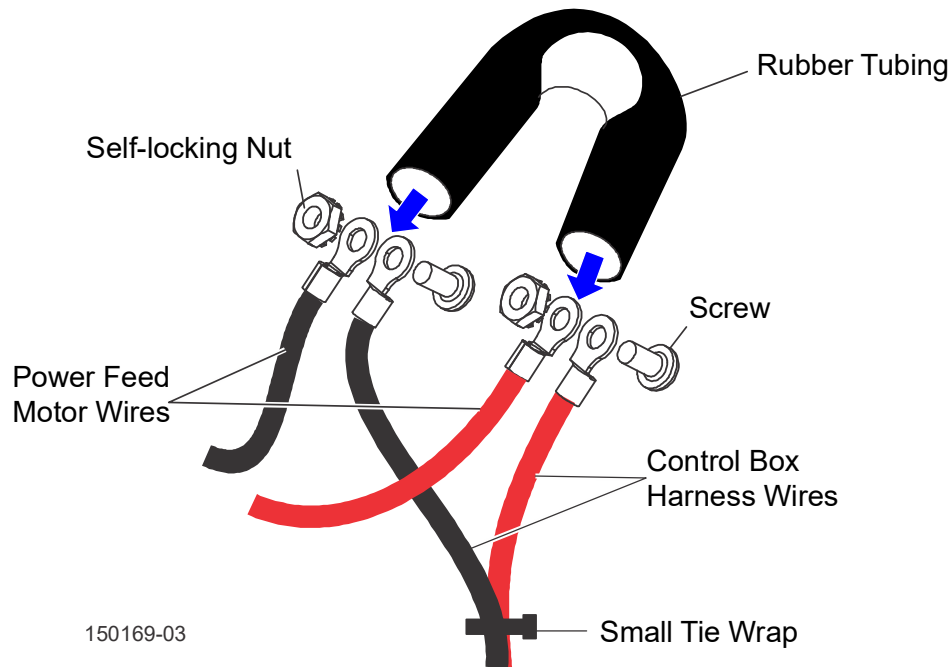


FIG. 1-13

14. Connect the power feed harness and control box harness.
15. Secure excess harness wiring to the power feed motor with the provided 15" tie wraps.
16. Replace the negative battery lead and check that the power feed operates normally.

NOTE: To operate the Resaw Attachment, disconnect the harnesses and connect the harness from the Resaw Attachment to the control box harness. Use the CARRIAGE switch and FEED RATE dial on the control panel to operate the Resaw Attachment.

[See Section 1.9](#) to install the Resaw Attachment to the sawmill.

1.7 Electrical Installation for LT15 Mills (Without H-Bridge)

BEFORE 12/4/2017 : PRIOR TO LT15PF REVISION B.00



IMPORTANT! This section contains wiring instructions for Rev. E4.00 and later model LT15 mills (equipped with power feed option LT15PF prior to revision B.00 only).

If you have a 1997 or later SUPER model LT30 Super, LT40 Super, LT30HD Super or LT40HD Super mill, follow the wiring installation instructions found in [Section 1.2 Electrical Installation for '97+ Super Mills](#).

If you have a 1997 or later STANDARD model LT30, LT40, LT30HD, LT40HD or LT28 Rev. A1.00 - A6.01 mill or if you have a 1992-1996 model mill, follow the wiring installation instructions found in [Section 1.3 Electrical Installation for '97+ Standard Mills, All '92-'96 Mills and LT35 Rev. A4.00+ Mills](#).

If you have a mill manufactured prior to 1992, follow the wiring installation instructions found in [Section 1.4 Electrical Installation for Pre-'92 Mills](#).

If you are installing the RS2 to an LT28 Rev. A6.02+ or LT35 model sawmill, follow the wiring instructions found in [Section 1.5 Electrical Installation for LT28 Rev. A6.02+ and LT35 Rev. A1.00 - A3.00 Mills](#).

If you are installing the RS2 to an LT15 without an H-bridge model sawmill, power feed **LT15PF revision B and later**, follow the wiring instructions found in [Section 1.6 Electrical Installation for LT15 Mills \(With H-Bridge\)](#).

1. Remove the power feed control front panel and locate the power feed motor wires connected to the driver module.
2. Disconnect the wires and pull the wires from the control box.
3. Remove the pre-cut insulation from the end of the harness wires from the provided LT15 plug harness (10", no ring terminals).
4. Route the harness wires through the back of the control box and connect the wires to the driver module (black wire to M1 terminal and red wire to M2 terminal).
5. Install a provided 1/4" ring terminal to each of the feed motor wires.

See Figure 1-14.

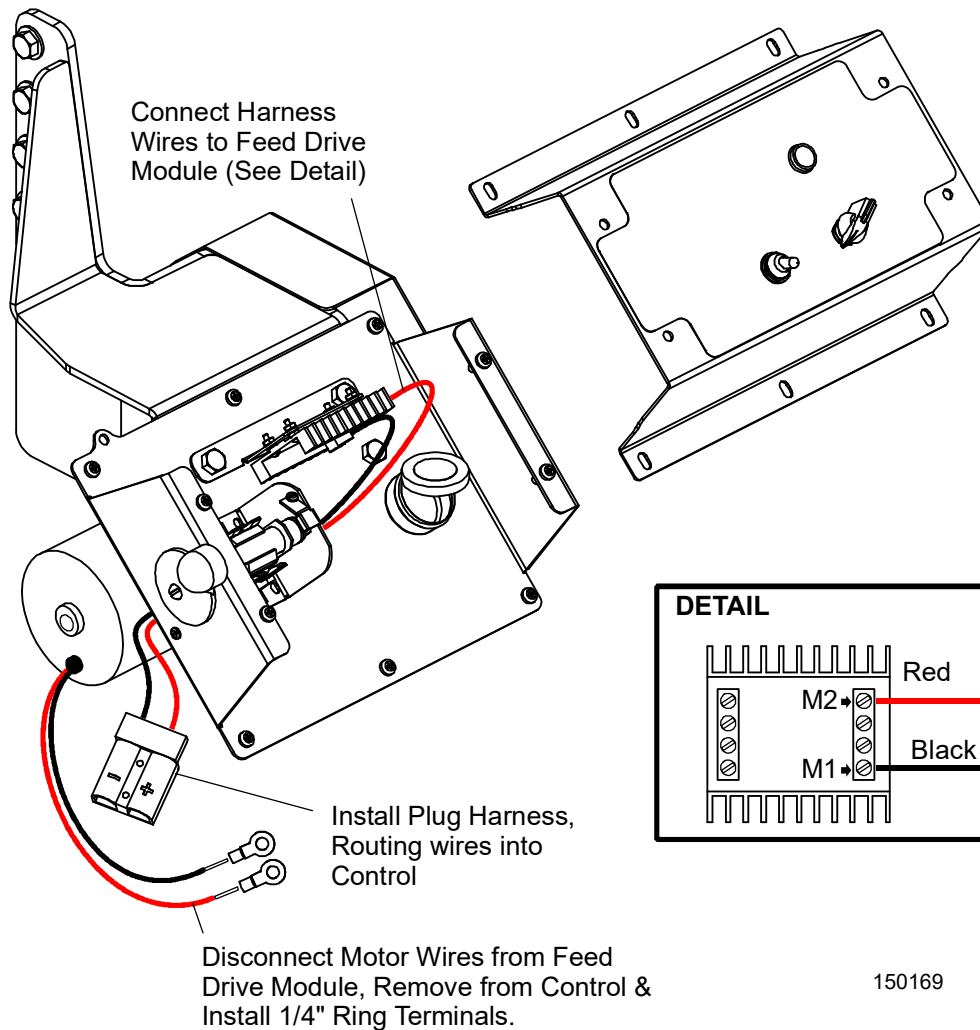


FIG. 1-14

6. Locate the feed motor plug harness (10", with ring terminals) and connect the harness wires to the power feed motor wires.
7. Connect the harness wires by bundling the two harness wires together with the small tie wrap.
8. Connect the red power feed wire to the red harness wire with a screw and a self-locking nut.
9. Connect the black power feed wire to the black harness wire with a screw and a self-locking nut.

10. Slip one end of the rubber tube around each wire/harness connection. Secure the tubing around the connections with a 6" tie wrap.

See Figure 1-15.

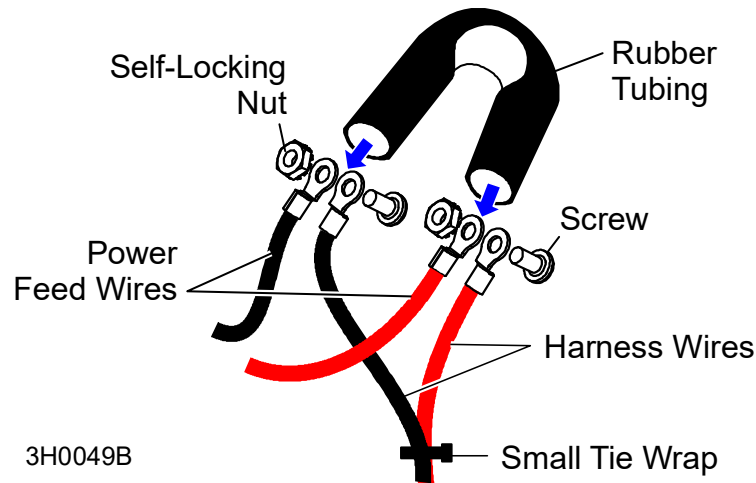


FIG. 1-15

11. Connect the power feed motor harness and control box harness. Secure excess harness wiring to the power feed motor with the provided 15" tie wraps.
12. Replace the negative battery lead and check that the power feed operates normally.

NOTE: To operate the Resaw Attachment, disconnect the harnesses and connect the harness from the Resaw Attachment to the control box harness. Use the CARRIAGE switch and FEED RATE dial on the control panel to operate the Resaw Attachment.

13. Replace the power feed control box front panel.

[See Section 1.9](#) to install the Resaw Attachment to the sawmill.

1.8 Resaw Attachment Installation

NOTE: These instructions describe the installation procedure for all sawmill models except the LT15. For installation instructions for LT15 models, [See Section 1.9](#).

See Figure 1-16.

1. Move the saw head to the front of the bed.
2. Place the resaw on the sawmill bed with the mounting brackets positioned on the middle two bed rails.
3. Push the resaw frame against the bed rail stop block bolt, leaving the mounting bracket bolts loose until the resaw is aligned to the blade as described later.

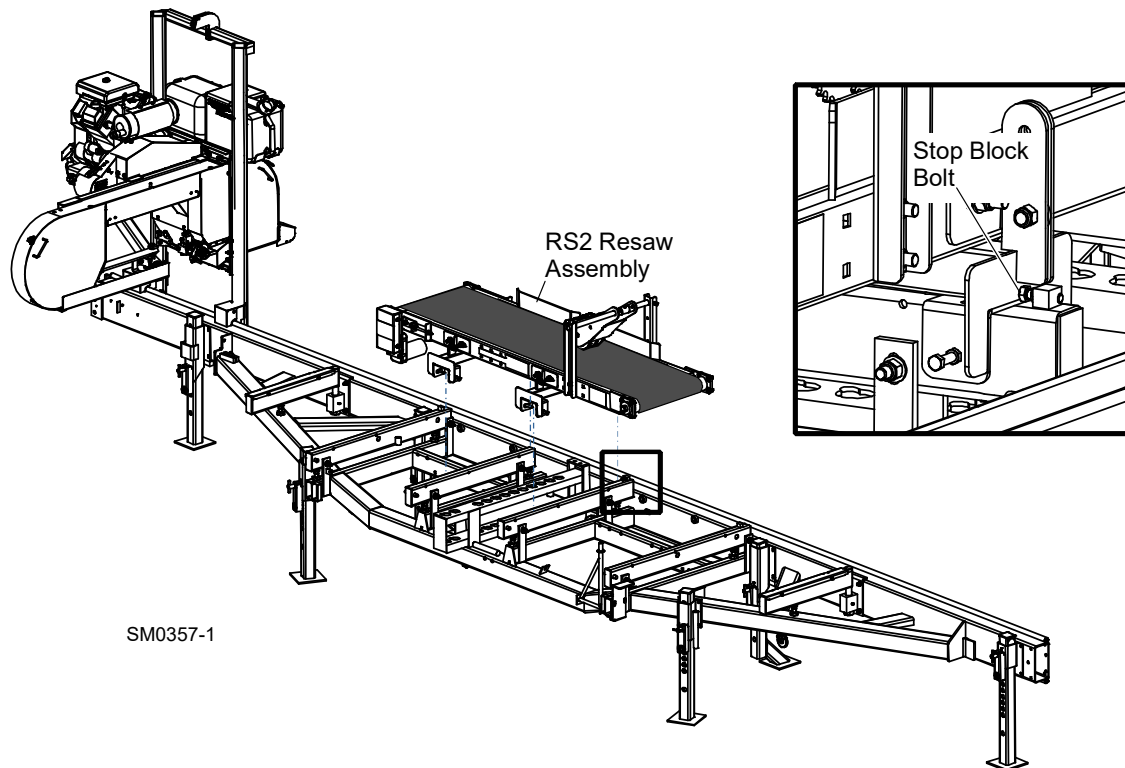


FIG. 1-16

4. Raise the saw head and adjust the blade guide arm out to clear the resaw.
5. Move the saw carriage to position the blade in the opening of the resaw frame.
6. Secure the saw carriage in position with the provided locking clamps.

See Figure 1-17.

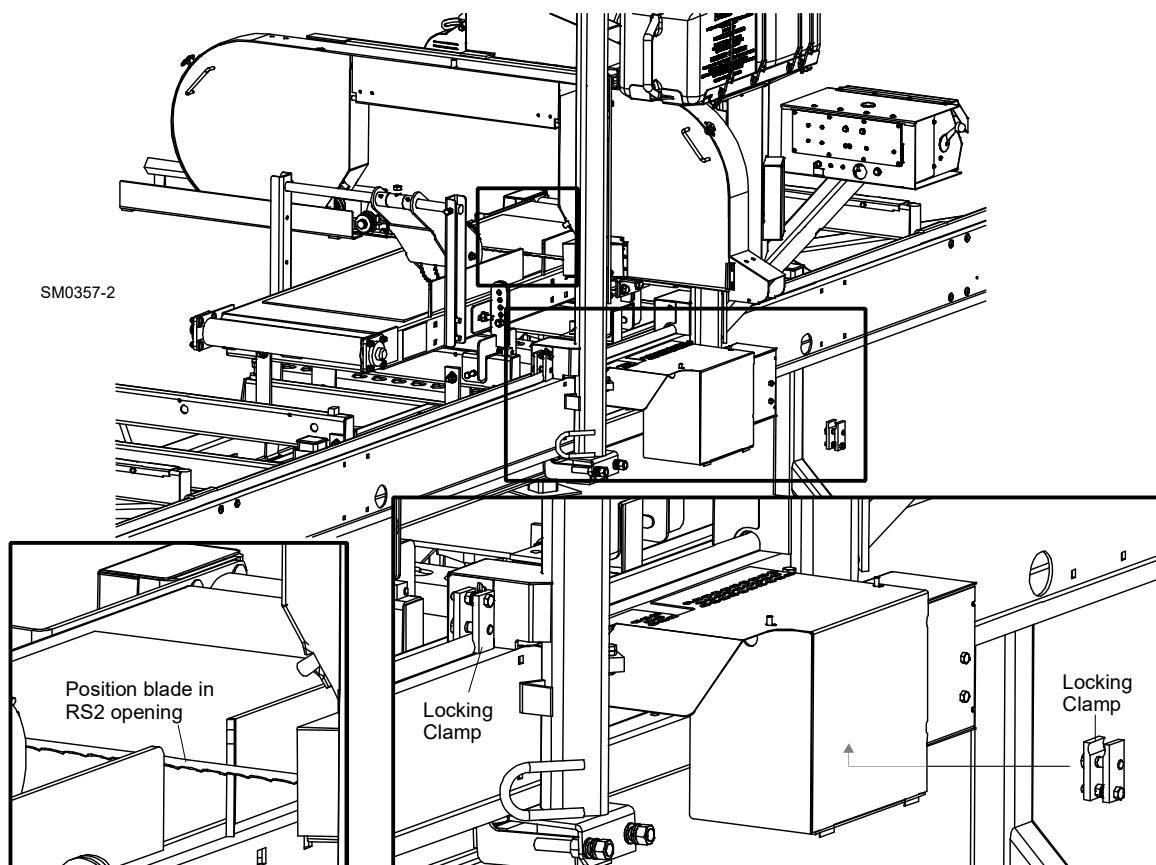


FIG. 1-17

7. Lower the saw head until the blade is an easy to measure distance from the resaw belt.
8. Measure the distance from the bottom of the blade to the belt at each side of the resaw frame.

The two measurements should be the same within 1/32". To adjust, lift the resaw stand up until the resaw belt is parallel to the blade.

9. Tighten all of the mounting bracket bolts.

See Figure 1-18.

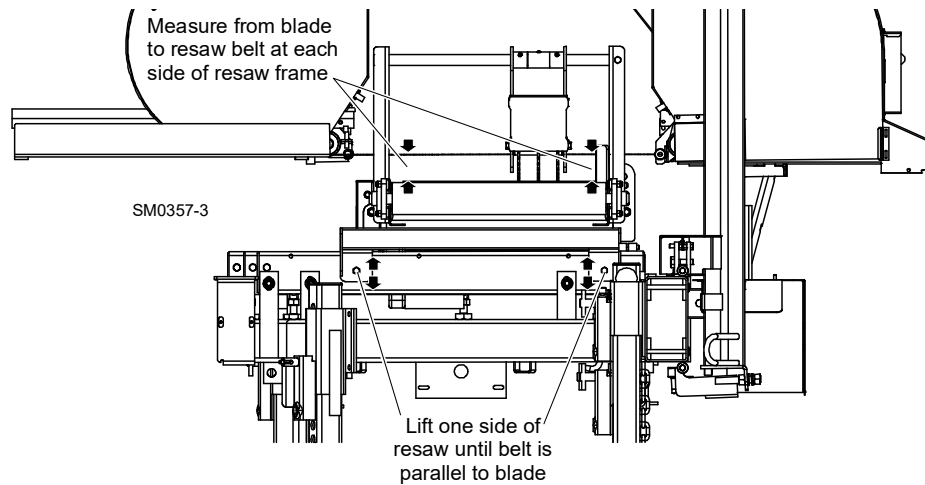


FIG. 1-18

10. Disconnect the control harness from the power feed harness and connect to the resaw motor harness.

IMPORTANT! When installing the resaw to the LT35 sawmill, it is necessary to move the hold down roller to the last set of mounting holes so it clears the debarker when cutting.

See Figure 1-19.

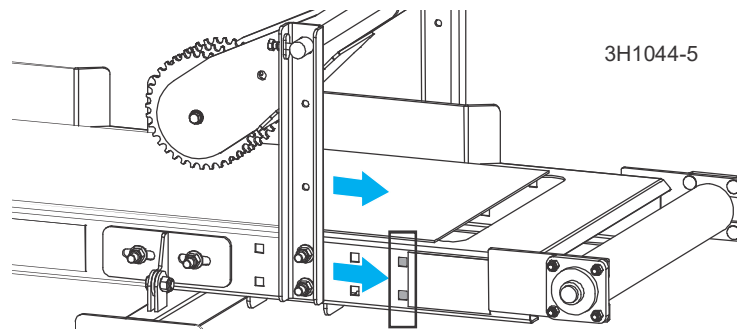


FIG. 1-19 LT35 SAWMILLS ONLY

1.9 Resaw Attachment Installation (LT15)

NOTE: These instructions describe the installation procedure for LT15 model sawmills (equipped with power feed option). For installation instructions for other sawmill models, [See Section 1.8](#).

An optional stand to mount the RS2 resaw to LT15 sawmills is available and highly recommended. The stand lifts the resaw to a convenient height for operation and allows secure mounting to the LT15 bed.

1. Move the saw head to the front of the bed.
2. Position the stand assembly on the LT15 bed so the mounting brackets are positioned on the first bed rail of the second bed section.
3. Push the stand frame against the bed rail stop block, leaving the mounting bracket bolts loose until the resaw is aligned to the blade as described later.
4. Place the resaw on the stand mounting posts and align the mounting holes.
5. Secure at each post with two 3/8-16 x 1" hex head bolts, flat washers and nylon lock nuts.

See Figure 1-20.

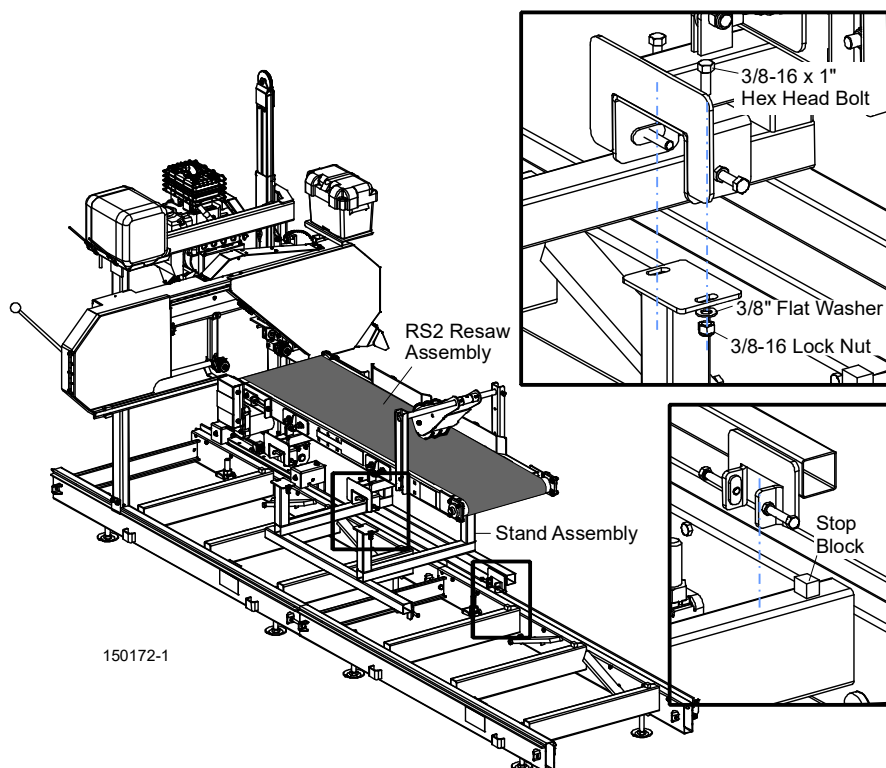


FIG. 1-20

6. Raise the saw head and adjust the blade guide arm out to clear the resaw.
7. Move the saw carriage to position the blade in the opening of the resaw frame.

8. Secure the saw carriage in position by engaging the rear lock pin in the bed frame hole.

See Figure 1-21.

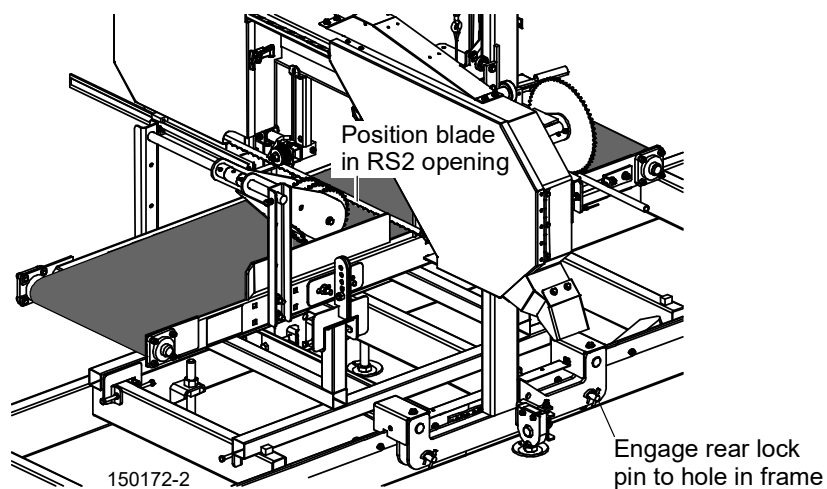


FIG. 1-21

9. Lower the saw head until the blade is an easy to measure distance from the resaw belt.
10. Measure the distance from the bottom of the blade to the belt at each side of the resaw frame.

The two measurements should be the same within $1/32$ ". To adjust, lift the resaw stand up until the resaw belt is parallel to the blade.

11. Tighten all of the mounting bracket bolts.

See Figure 1-22.

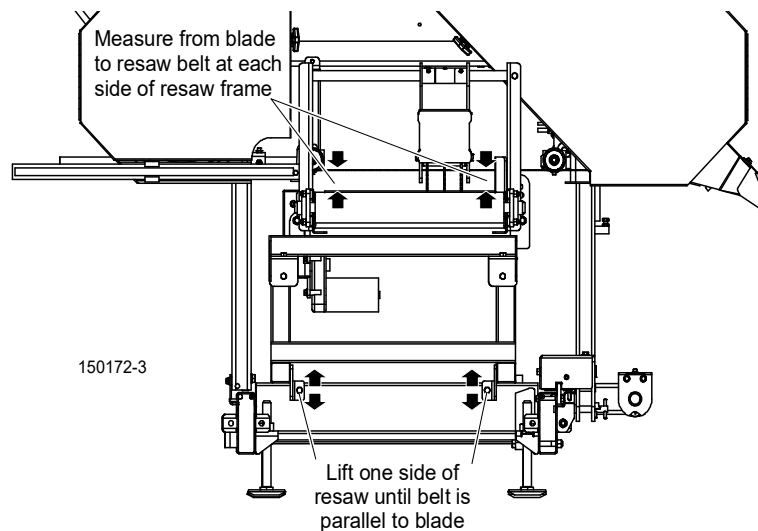


FIG. 1-22

12. Disconnect the control harness from the power feed harness and connect to the resaw motor harness.

1.10 Shingle Belt Installation (Optional)

1. Use the sawmill carriage feed switch and feed rate dial to start the resaw conveyor belt.
2. Stop the belt when the belt seam is on top and easily accessible.
3. Remove the key from the sawmill control key switch.
4. Loosen the belt tensioners on each side of the resaw frame and push the belt roller in to provide slack in the conveyor belt.
5. Remove the seam wire to separate the belt at the seam and remove the conveyor belt from the resaw.
6. Place the shingle belt on the resaw frame and secure the seam with the seam wire.
7. Adjust the belt tensioners on each side of the resaw frame to tension the shingle belt.
8. Install the shingle stop plate to the hold-down uprights with four provided 3/8-16 x 1" hex head bolts, eight flat washers and four nylon lock nuts. Leave mounting hardware loose until plate is adjusted as described later.

See Figure 1-23.

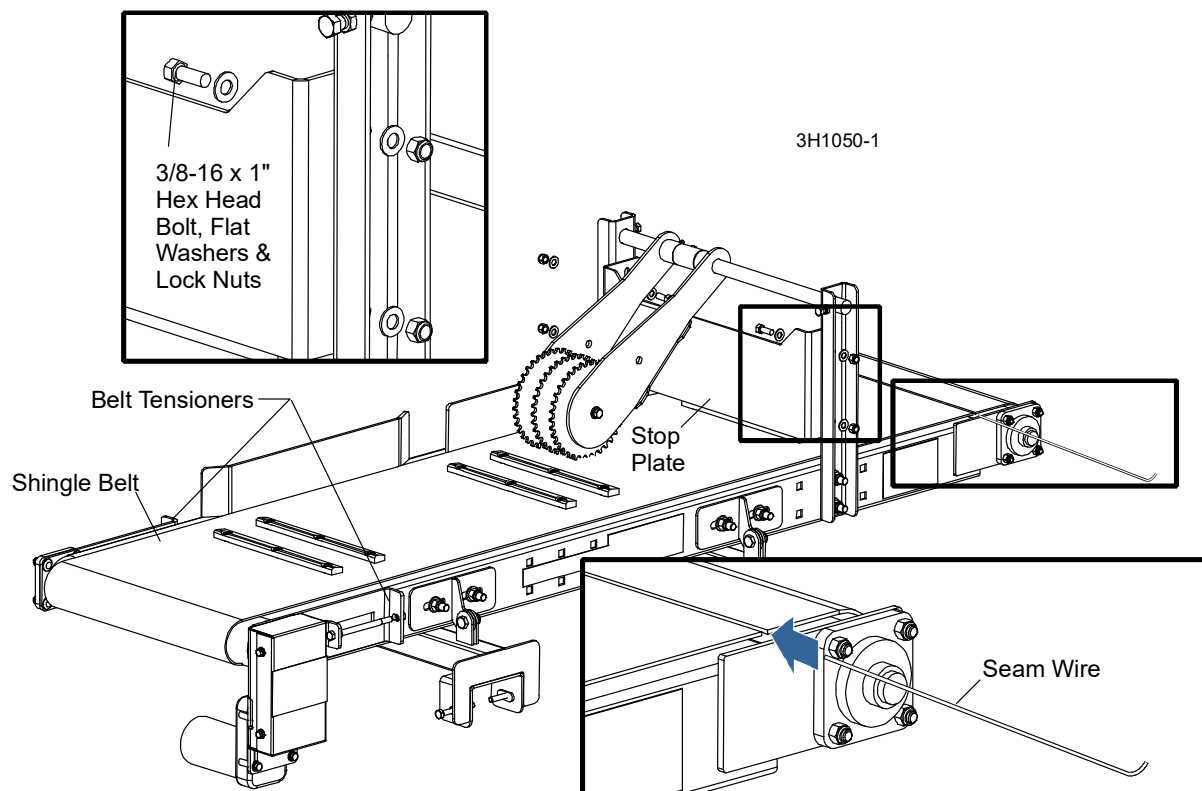


FIG. 1-23

1.11 Resaw Attachment Operation

Resawing Boards/Siding

1. To set the Resaw for tapered sawing (as for siding), remove the tilt adjustment locking bolts and lock nuts located on the side of the Resaw frame. Lift the side of the Resaw until the holes for the desired taper are aligned. Each hole is equal to 2° of taper. Replace the locking bolts and secure with the lock nuts.

See Figure 1-24.

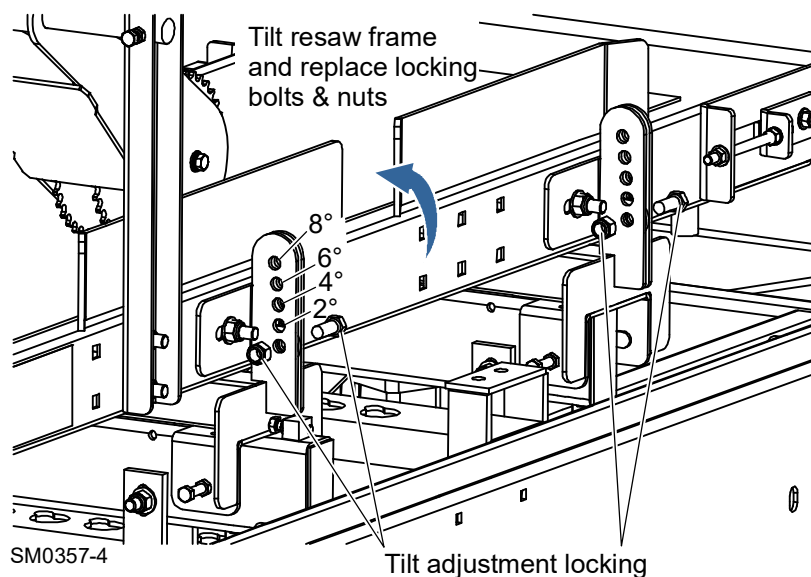


FIG. 1-24

2. Raise or lower the saw head until the blade is set for the thickness you want to saw. Measure from the bottom of the blade to the feed belt.
3. If necessary, loosen the set screw on the hold-down roller pivot and adjust the roller so it is positioned roughly centered on the material to be sawn.



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

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

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

4. Adjust the FEED RATE dial all the way down. Start the engine and engage the blade. Place the Carriage switch in the FORWARD position and adjust the FEED RATE dial until the belt moves at the desired speed.
5. Feed the first board into the Resaw. When the blade starts to cut the board, turn the Feed Rate dial all the way down to stop the feed, return the Carriage switch to NEUTRAL, disengage the blade and pull the board out. Check the thickness of the cut and make any needed adjustments.

NOTE: Feed rate is affected by the species and the width of the board being cut. The sharpness, set of the blade, and the available horsepower of your engine also will affect the feed rate. If the engine continually "bogs" down, or if the quality of the cuts you are making gets continually worse, adjust the feed rate or change the blade.

NOTE: Inspect each board or cant to see if it is cupped or bowed before feeding into the Resaw. Cupped boards should be fed with the cupped edges down. Boards that are bowed through their length should be fed so the ends bow upward.

6. Readjust the Feed Rate dial so the belt moves at the desired speed. Continue feeding boards, one at a time, until resawing is complete. When you are done resawing, disengage the blade. Return the Carriage switch to NEUTRAL and turn the FEED RATE dial all the way down. Stop the engine. Raise the blade out of the Resaw.
7. If you wish to return to normal sawing on the sawmill, disconnect the Resaw motor harness from battery harness. Connect the sawmill feed motor harness to the battery harness. Unclamp the cutting head and move it to the front of the mill. Loosen the mounting bolts at the front and rear bed rails. Remove the Resaw from the bed of the mill.

Resawing Shingles

1. Install the shingle belt and stop plate as described on [page 1-28](#).
2. Use the sawmill carriage feed switch and feed rate dial to start the resaw shingle belt. Stop the belt to position a set of cleats in front of the shingle stop plate. Remove the key from the sawmill control key switch.
3. Place a stack of shingle blocks (two shingles thick, at least 18" and no more than 20" long) on the belt with the front of the blocks sitting on the tapered cleat. The rear end of the blocks should sit flat on the belt.
4. Adjust the shingle stop plate to approximately 1/4" above the bottom shingle block. Tighten the shingle stop plate mounting bolts.

See Figure 1-25.

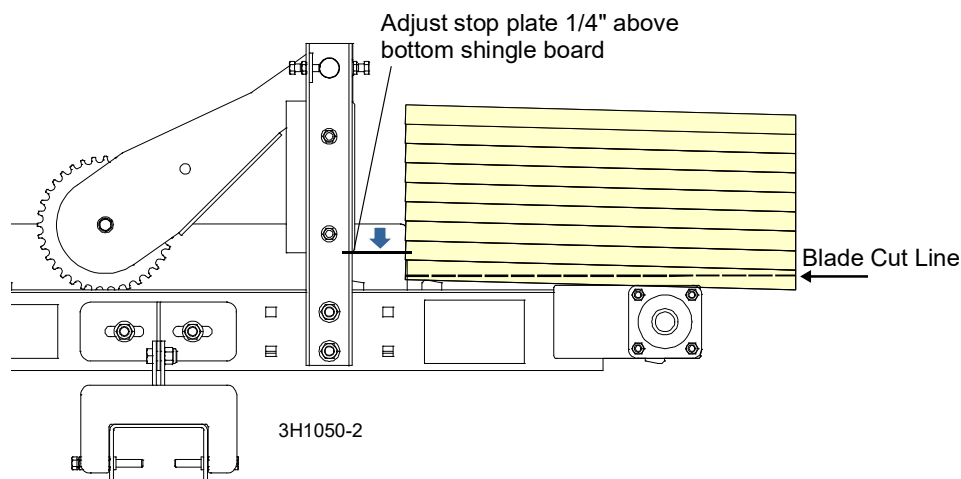


FIG. 1-25

5. Use the up/down switch to position the blade to cut the shingle blocks in half.



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

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

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

6. Adjust the FEED RATE dial all the way down. Start the engine and engage the blade. Place the Carriage switch in the FORWARD position and adjust the FEED RATE dial until the belt moves at the desired speed.
7. Feed the first board into the Resaw. As the belt rotates, the bottom shingle block should pass under the stop plate and into the blade. When the blade starts to cut the board, turn the Feed Rate dial all the way down to stop the feed, return the Carriage switch to NEUTRAL, disengage the blade and pull the board out. Check the thickness of the cut and make any needed adjustments.
8. Place the block on top of the shingle board stack. Engage the blade and start the feed belt. The resaw will feed each shingle block through the blade. Add more shingle blocks to the stack as the stack gets shorter.

1.12 Resaw Attachment Maintenance



WARNING! Before performing service near moving parts such as blades, pulleys, motors, belts and chains, first turn the key switch to the OFF (#0) position and remove the key. If the key is turned on and moving parts activated, serious injury may result.

1. Grease the conveyor belt roller bearings and the hold-down pivot with a NLGI No. 2 grade lithium grease every 1000 hours of operation.
2. If the conveyor belt begins to slip, tighten the belt. Loosen the tensioner locking nuts equally on both sides of the frame. Tighten the adjustment nuts to tighten the belt. Retighten the locking nuts.

See Figure 1-26.

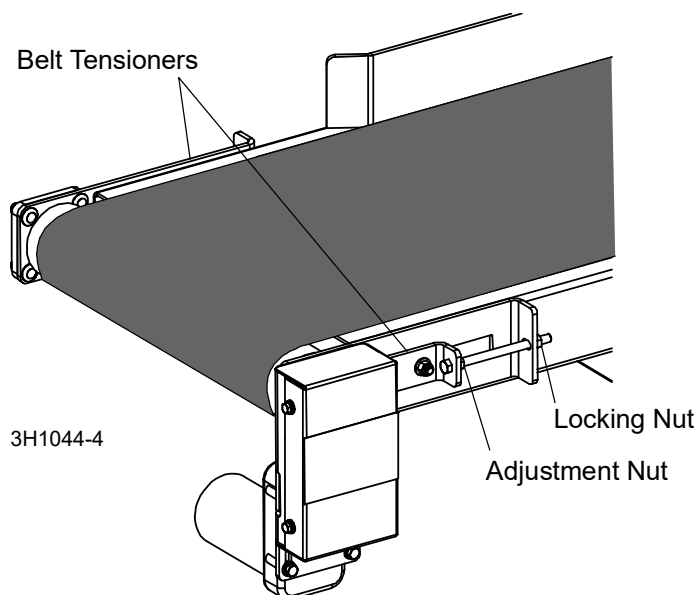


FIG. 1-26

2.1 Resaw Assembly

2-1

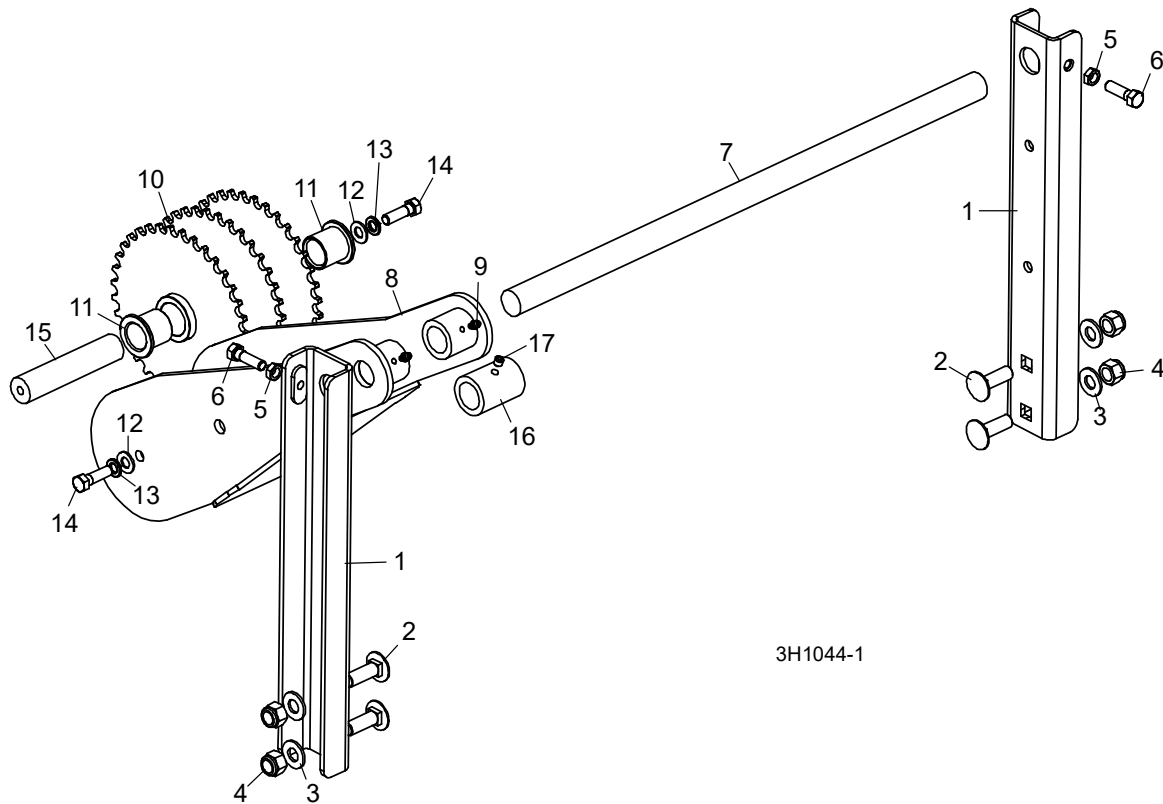
2

Replacement Parts

Resaw Assembly

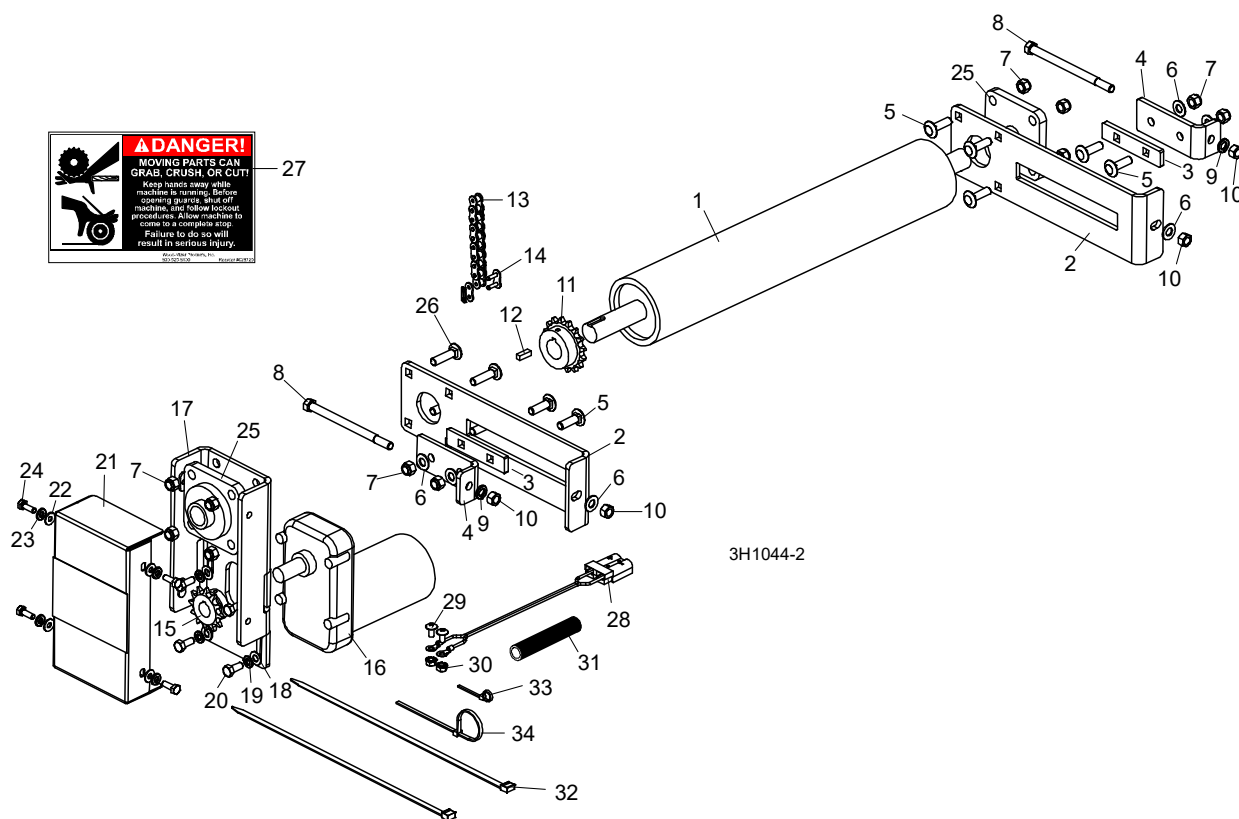
REF	PART #	DESCRIPTION	COMMENTS	QTY.
4	F05007-127	Bolt, 3/8-16 x 1 1/4" Carriage Head Grade 5		8
5	F05010-10	Nut, 3/8-16 Hex Nylon Lock		8
6	007417	Belt, 19" Grip-Top Resaw (See Section 2.6 for optional Shingle Belt)		1
7		Hold-Down Parts (See Section 2.2)		
8		Feed Drive Parts (See Section 2.3)		
9		Resaw Mount Parts (See Section 2.4)		
10	028720	Decal, Moving Parts Danger		2
11	007447	Decal, RS2 Wood-Mizer Logo		1
12		Carriage Lock Clamp Parts (See Section 2.5)		
	008909	Harness Set, RS2 Complete		1
	008906	Harness Kit, Resaw Power Supply Retro		1
13	008903	Harness Assembly, Power Feed Motor Connector	Available in assemblies only.	1
14	008904	Harness Assembly, Power Feed Control to Resaw	Available in assemblies only.	1
15	008908	Harness Assembly, LT15 Power Feed Control to RS2		1
16	F05092-2R	Terminal, 1/4" 10-12Ga Ring		2
17	F05004-3	Screw, #10-24 x 3/8" Phillips Round Head		2
18	F05010-14	Nut, #10-24 Self-Locking Hex		2
19	F05089-1	Tie Wrap, 1/4" x 6"		2
20	F05089-2	Tie Wrap, .100" x 4"		2
21	F05089-5	Tie Wrap, 5/16" x 15"		2
22	R02349	Tubing, 13/16" OD x 5/8" ID Norprene		.5 ft.
23	F05708-15	Terminal, 1/4" 10-12Ga Quick Male FI		2

2.2 Upper Hold-Down Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	007284	CHANNEL WELDMENT, HOLD-DOWN POST		2
2	F05008-150	BOLT, 1/2-13 X 1 1/2" CARRIAGE HEAD		4
3	F05011-2	WASHER, 1/2" SAE FLAT		4
4	F05010-8	NUT, 1/2-13 HEX NYLON LOCK		4
5	F05010-29	NUT, 3/8-16 HEX JAM		2
6	F05007-123	BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 5		2
7	007149	SHAFT, 1" DIA. X 23 1/2" PIVOT		1
	007146	ARM ASSEMBLY, RESAW HOLD-DOWN		1
8	007285	Arm Weldment, Resaw Hold-Down		1
9	P04107	Fitting, 3/16" x 3/16" Straight Grease		2
10	007288	Roller Weldment, Resaw Hold-Down		1
11	P109	Bushing, 1" ID x 1 1/4" OD x 1 1/4" Flanged		2
12	F05011-3	Washer, 3/8" SAE Flat		2
13	F05011-4	Washer, 3/8" Split Lock		2
14	F05007-123	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5		2
15	059402	Shaft, Resaw Hold-Down Roller		1
16	007148	COLLAR, HOLD-DOWN ROLLER LOCKING		1
17	F05006-6	SCREW, 5/16-18 X 5/16" CUP POINT SOCKET SET		1

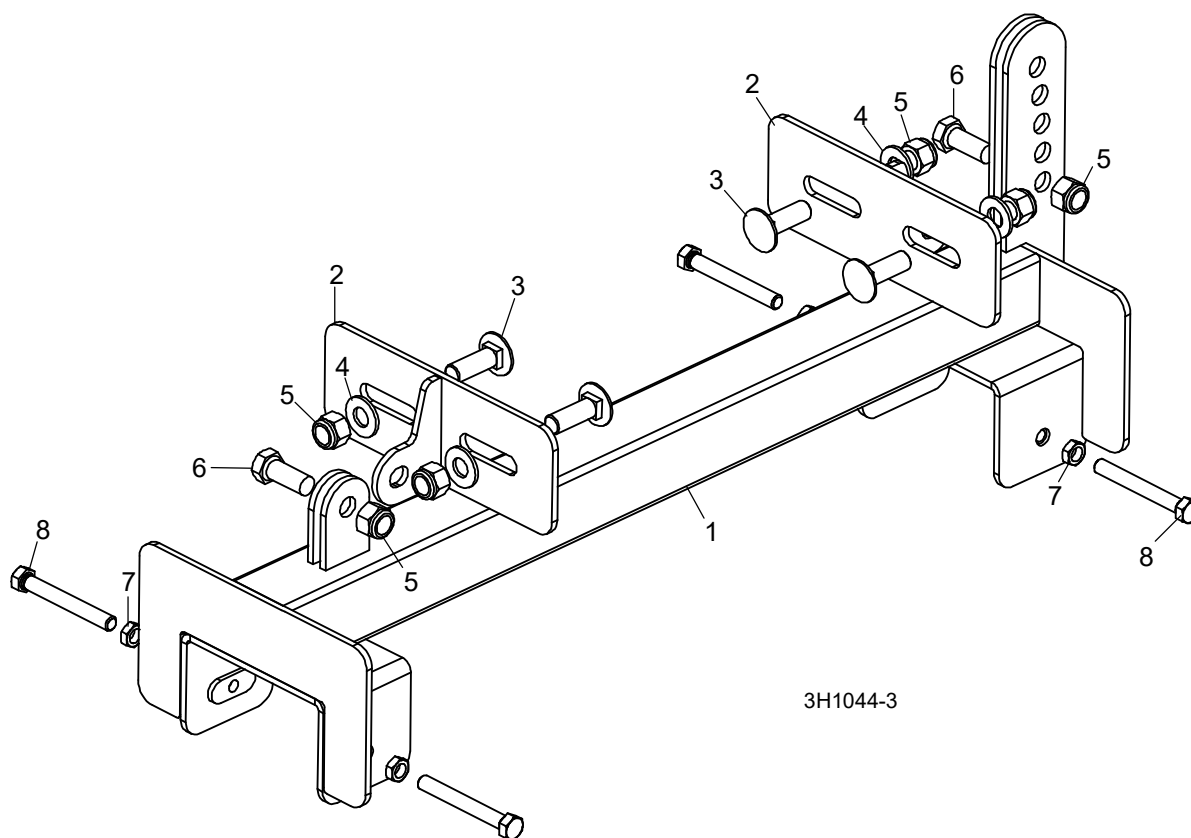
2.3 Feed Drive Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	059358	PULLEY, 3" X 20" LAGGED DRUM		1
2	059356	PLATE, CONVEYOR END ADJUSTMENT		2
3	007139	PLATE, 1/4" X 6/8" X 4" SPACER SLIDE		2
4	007140	PLATE, DRIVE PULLEY SLIDE ADJUSTMENT		2
5	F05007-127	BOLT, 3/8-16 X 1 1/4" CARRIAGE HEAD GRADE 5		8
6	F05011-3	WASHER, 3/8" SAE FLAT		6
7	F05010-10	NUT, 3/8-16 HEX NYLON LOCK		12
8	F05007-34	BOLT, 3/8-16 X 5 1/2" HEX HEAD FULL THREAD		2
9	F05011-4	WASHER, 3/8" SPLIT LOCK		2
10	F05010-1	NUT, 3/8-16 HEX		4
11	007311	SPROCKET, 40B16 X 1" BORE		1
12	S03167	KEY, 1/4" SQUARE X 3/4"		1
13	007446	CHAIN, #40 X 16 1/2"		1
14	P04200	LINK, #40 MASTER		1
15	101795	SPROCKET, 40B12 X 3/4" BORE		1
16	008910	MOTOR ASSEMBLY, RS2 FEED		1
	133256	Gearmotor, Klauber 1/5HP 87RPM 12VDC		1
	F05092-10	Terminal, 1/4 14-16Ga Ring NI Loose		2

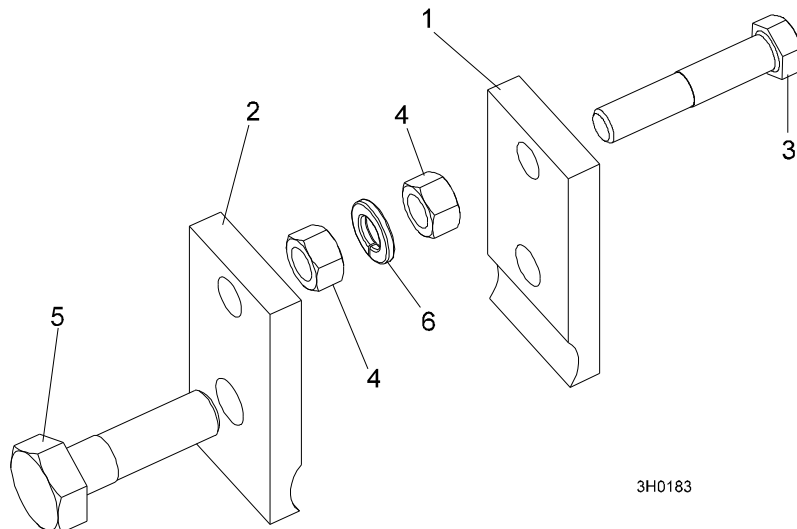
REF	PART #	DESCRIPTION	COMMENTS	QTY.
	133398	Kit, 133256 Gearmotor Brush Replacement		1
17	007424	BRACKET WELDMENT, RS2 MOTOR MOUNT		1
18	F05011-17	WASHER, 5/16" SAE FLAT		4
19	F05011-13	WASHER, 5/16" SPLIT LOCK		4
20	F05006-5	BOLT, 5/16-18 X 3/4" HEX HEAD		4
21	007145	COVER, RS2 FEED MOTOR		1
22	F05011-11	WASHER, 1/4" SAE FLAT		4
23	F05011-14	WASHER, 1/4" SPLIT LOCK		4
24	F05005-1	BOLT, 1/4-20 X 3/4" HEX HEAD FULL THREAD		4
25	014090	BEARING, VF4S-216 FLANGED		2
26	F05007-85	BOLT, 3/8-16 X 1 1/2" CARRIAGE HEAD		4
27	028720	DECAL, MOVING PARTS DANGER		1
28	008902	HARNESS ASSEMBLY, RESAW POWER		1
29	F05005-17	SCREW, 1/4-20 X 3/8" PHILLIPS PAN HEAD		2
30	F05010-9	NUT, 1/4-20 SELF-LOCKING HEX		2
31	R02348	TUBING, 1/2" ID X 5/8" OD NORPRENE		.5 ft.
32	F05089-5	WIRE TIE, 5/16" X 15"		2
33	F05089-6	WIRE TIE, .100" X 4"		1
34	F05089-3	WIRE TIE, 3/16" X 6"		1

2.4 Frame Mount Assembly



REF	PART #	DESCRIPTION	COMMENTS	QTY.
1	059396	MOUNT WELDMENT, RS2 FRAME		2
2	007442	BRACKET WELDMENT, RS2 FRAME PIVOT		4
3	F05008-150	BOLT, 1/2-13 X 1 1/2" CARRIAGE HEAD		8
4	F05011-2	WASHER, 1/2" SAE FLAT		8
5	F05010-8	NUT, 1/2-13 HEX NYLON LOCK		12
6	F05008-37	BOLT, 1/2-13 X 1 1/4" HEX HEAD GRADE 5		4
7	F05010-29	NUT, 3/8-16 HEX JAM		8
8	F05007-1	BOLT, 3/8-16 X 3" HEX HEAD FULL THREAD		8

2.5 Resaw Clamp Assembly

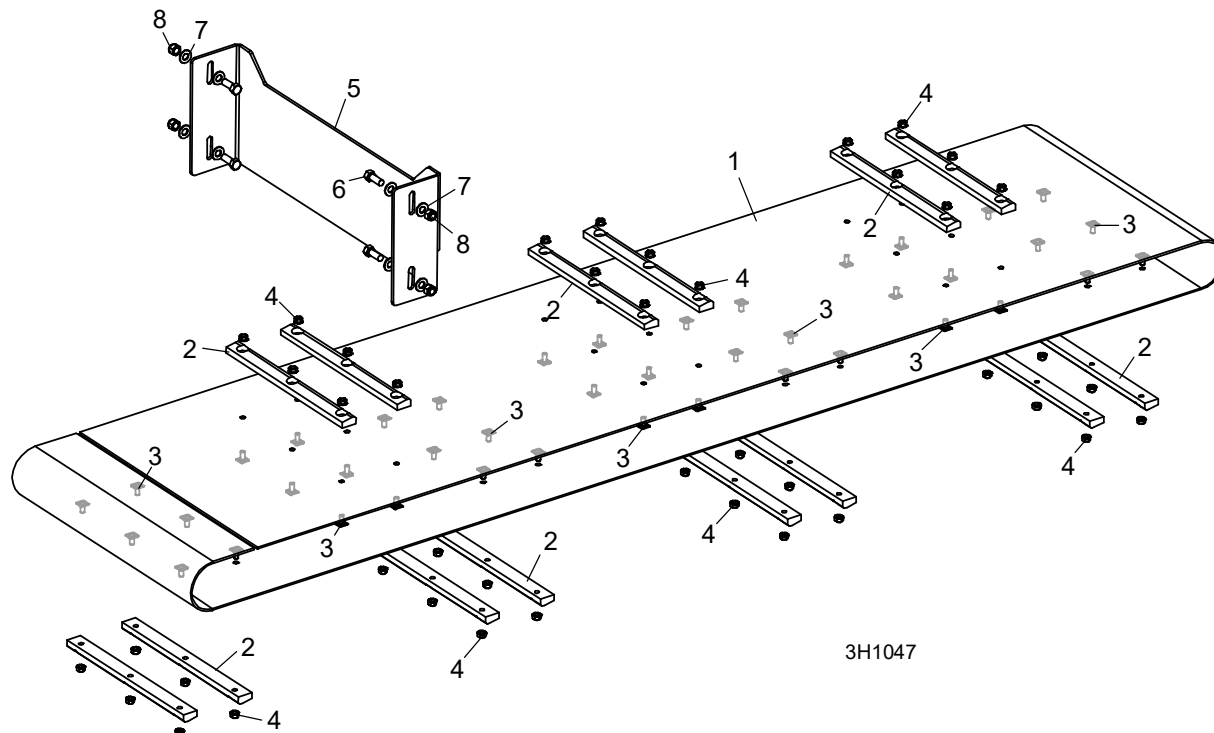


REF	PART #	DESCRIPTION	COMMENTS	QTY.
	A08865	CLAMP ASSEMBLY, SAWMILL CARRIAGE LOCKING		2
1	S08866	Plate, Carriage Locking Clamp Left	Available in assemblies only.	1
2	S08867	Plate, Carriage Locking Clamp Right	Available in assemblies only.	1
3	F05007-16	Bolt, 3/8-16 X 2" Hex Head Full Thread		1
4	F05010-1	Nut, 3/8-16 Hex		2
5	F05008-127	Bolt, 1/2-20x1-3/4 HHC FT Zinc		1
6	F05011-4	Washer, 3/8" Split Lock		1

2 Replacement Parts

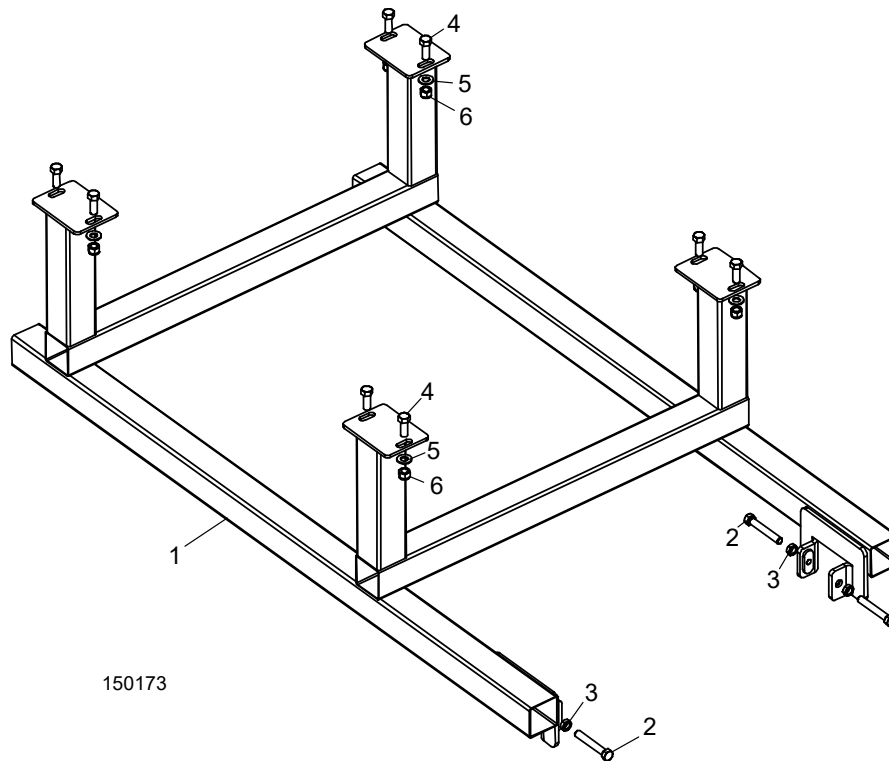
Shingle Belt Assembly (Optional)

2.6 Shingle Belt Assembly (Optional)



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	RS2-SB	BELT ASSEMBLY, RS2 SHINGLE	Smooth side outward	1
1	007318	Belt, 18" Resaw Shingle		1
2	059366	Block, Shingle Catch		14
3	007616	Stud, 1/4-20 x 1/2" Base Plate		42
4	F05010-9	Nut, 1/4-20 Self-Locking Hex		42
5	007277	Plate, Shingle Stop		1
6	F05007-7	Bolt, 3/8-16 x 1" Hex Head		4
7	F05011-3	Washer, 3/8" SAE Flat		8
8	F05010-10	Nut, 3/8-16 Hex Nylon Lock		4

2.7 LT15 Stand Mount



REF	PART #	DESCRIPTION	COMMENTS	QTY.
	RS2-LT15S	STAND ASSEMBLY, RS2 LT15 MOUNT		1
1	007150	Stand Weldment, RS2 LT15 Mount		1
2	F05007-157	Bolt, 3/8-16 x 2 1/2" Hex Head Full Thread		4
3	F05010-29	Nut, 3/8-16 Hex Jam		4
4	F05007-7	Bolt, 3/8-16 x 1" Hex Head		8
5	F05011-3	Washer, 3/8" SAE Flat		8
6	F05010-10	Nut, 3/8-16 Hex Nylon Lock		8

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