

## IMPORTANT

Failure to comply with instructions in this book may invalidate the guarantee



Instruction Manual For

# *RR1000*

## *HEAVY-DUTY BAND RESAW*

For Replacement Parts, Tools and Accessories,  
Contact:

**WADKIN CLEVELAND**

(A DIVISION OF WADKIN PLC)

NORTH LIVERTON INDUSTRIAL ESTATE, LOFTUS,  
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Tel: (0287) 40177  
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BOOK NO.

## IMPORTANT

It is our policy and that of our suppliers to review constantly the design and capacity of our products. With this in mind we would remind our customers that whilst the dimensions and performance data contained herein are current at the time of going to press, it is possible, that, due to the incorporation of latest developments to enhance performance, dimensions and supplies may vary from those illustrated.

RR 1000

PLEASE INSERT SERIAL NUMBER OF MACHINE

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For Replacement parts, Tool and Accessories

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# HEALTH & SAFETY

## SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

Wadkin plc supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the users responsibility to see that the following rules are complied with to ensure safety at work:

1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No. 41, "Safety in the use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin plc.
3. Only personnel trained in the safe use of a machine should operate it.
4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

Safety is our watchword but the user must comply with the above rules in his own interest. We would be pleased to advise on the safe use of our products.



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(Burdm G).

## 2.2 SAFETY

CAREFULLY READ INSTRUCTION MANUAL WITH PARTICULAR REFERENCE TO THE FOLLOWING INSTRUCTIONS:-

1. SLINGING, i.e. SAFE LIFTING LIMITS FOR SLINGS ETC.
2. INSTALLATION, i.e. SAFE WORKING AREA OF MACHINE AND FOUNDATION PLAN.
3. WIRING DETAILS, i.e. WIRING DIAGRAM AND INSTRUCTIONS FOR SAFE WIRING OF MACHINE.
4. MACHINE CONTROLS AND OPERATING INSTRUCTIONS.
5. SELECT CORRECT SPEED FOR FEEDING EQUIPMENT AND ENSURE BLADES ARE SECURELY LOCKED IN POSITION.
6. SET ALL GUARDS CORRECTLY TO COVER CUTTING EQUIPMENT.
7. NOTE START/STOP CONTROL POSITION AND ISOLATOR SWITCH POSITION BEFORE OPERATING MACHINE.
8. USE FEEDING DEVICES WHERE POSSIBLE.
9. REFER TO HEALTH AND SAFETY AT WORK BOOKLET No 41 (IN U.K.) FOR SAFETY IN THE USE OF WOODWORKING MACHINERY.
10. UNDER CERTAIN HEAVY DUTY OPERATIONS, THIS MACHINE MAY PRODUCE NOISE LEVELS IN EXCESS OF THE LIMIT LAID DOWN IN REGULATION 44 OF THE WOODWORKING MACHINES REGULATIONS 1974. SOUNDPROOFING IS AVAILABLE UPON REQUEST WHICH, UNDER I.S.O. TEST CONDITIONS, WILL GIVE NOISE LEVELS BELOW THIS LIMIT.

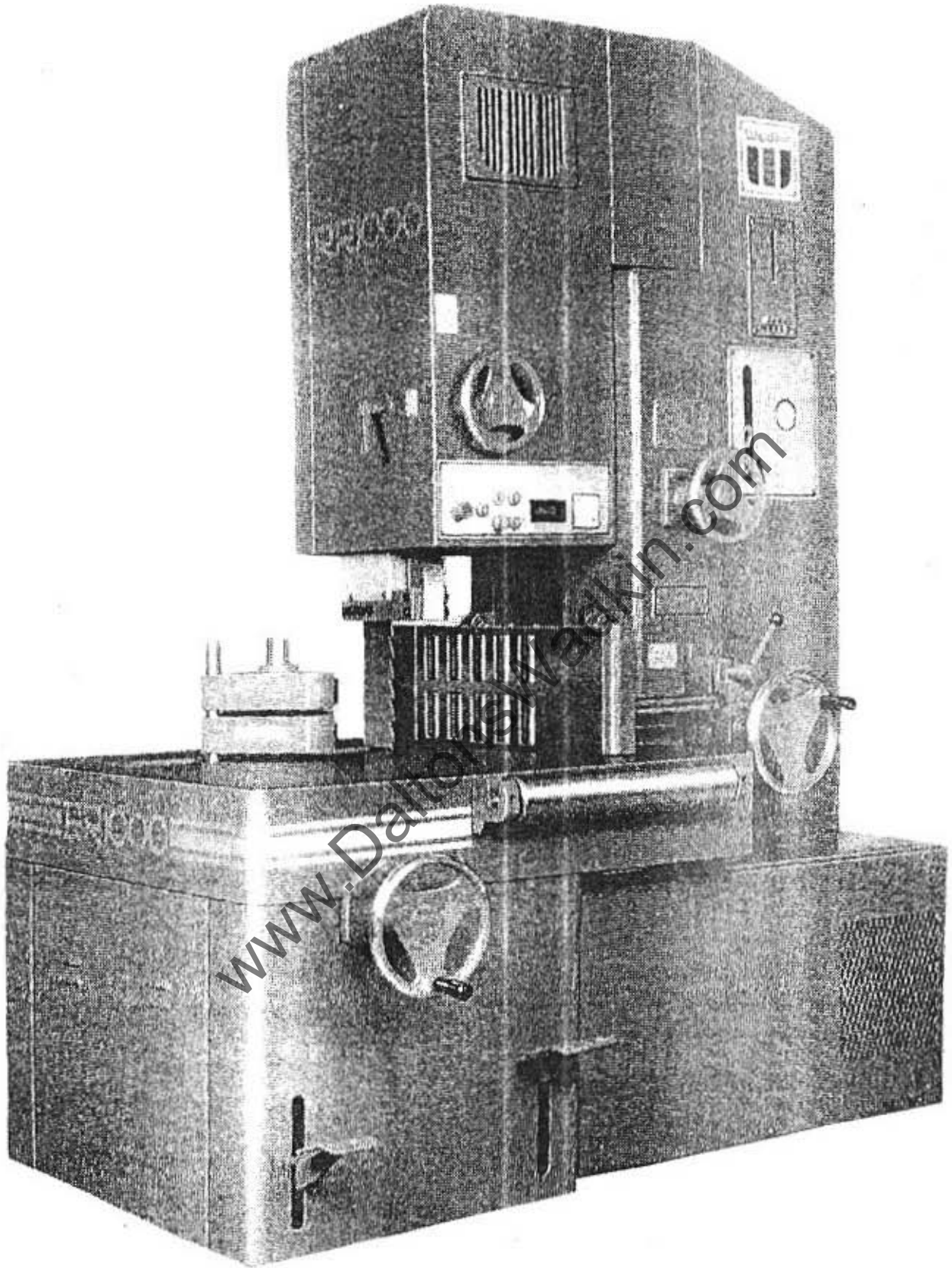
SHOULD THE MACHINE BE SPECIFIED WITHOUT SOUNDPROOFING THE CUSTOMER'S ATTENTION IS DRAWN TO THE FACT THAT IT IS HIS RESPONSIBILITY TO ENSURE THAT THE NOISE LEVEL DOES NOT EXCEED THIS LIMIT.

2.2.1 CAUTION !

1. READ AND UNDERSTAND OPERATOR'S MANUAL BEFORE OPERATING MACHINE.
2. ALWAYS DISCONNECT POWER AND LOCK OFF MAIN ISOLATOR BEFORE SETTING, MAINTAINING, SERVICING OR CLEANING MACHINE.  
DO NOT ATTEMPT TO CLEAN OR OIL MACHINE WHILST IN MOTION.
3. KEEP ALL GUARDS, COVERS AND DOORS IN PLACE WHEN MACHINE IS RUNNING. REPLACE CORRECTLY AFTER SETTING UP MACHINE.
4. DO NOT PLACE HANDS BETWEEN TIMBER AND FEED ROLLERS OR TABLE ETC.

THE MACHINE IS EQUIPPED WITH GUARDS AND SAFETY DEVICES FOR OPERATOR AND MACHINE SAFETY.

CHECK THAT THE GUARDS AND SAFETY DEVICES ARE OPERATIONAL BEFORE STARTING MACHINE.



**3.0 TECHNICAL SPECIFICATIONS.**

Wheel diameter	1000mm	39in
Depth under guide	400mm	16in
Fence opening	310mm	12in
Feed opening	400mm	16in
Sawblade width (A)	100mm	4in
Sawblade width (B)	125mm	5in
Table height	800mm	31½in
Blade speed	2300m/min	7500ft/min
Feed speed, infinitely variable	8-40m/min	26-130ft/min
-optional	7-33m/min	23-108ft/min
-optional	15-75m/min	49-246ft/min
Saw motor	-standard 18.5kW	25HP
	-optional 22/25kW	30/35HP
Feed motor	0.75Kw	1HP
Machine height (floor to top)	2320mm	7ft 6in
Full machine height	2600mm	8ft 6in
Machine width	1835mm	6ft
Machine length (front to back)	1185mm	4ft

RR1000.

TOOL KIT.

SPANNERS (single ended).

2 of 8mm  
2 of 10mm  
2 of 13mm  
2 of 24mm

SPANNERS (double ended).

2 of 17mm / 19mm  
2 of 22mm / 27mm

ALLEN KEYS.

2 of 2mm  
2 of 3mm  
2 of 4mm  
2 of 5mm  
2 of 6mm  
2 of 8mm  
2 of 10mm  
2 of 14mm

MISCELLANEOUS.

2 Grease guns.

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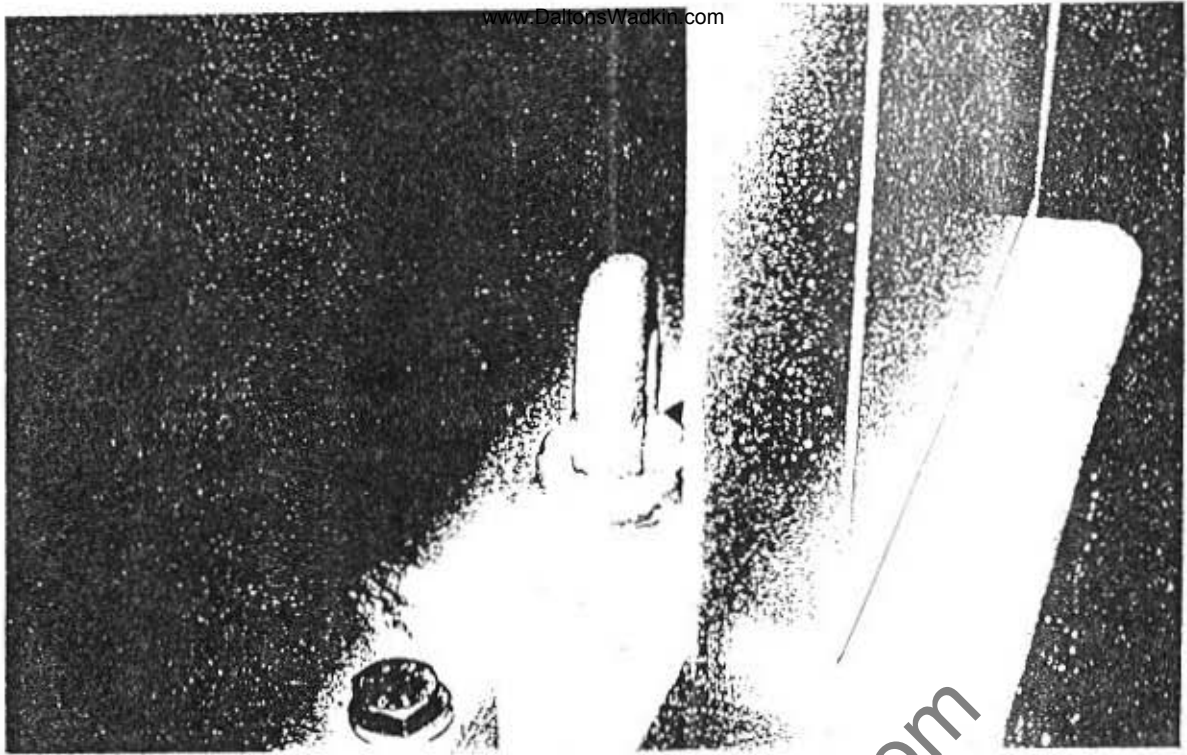


FIG 1

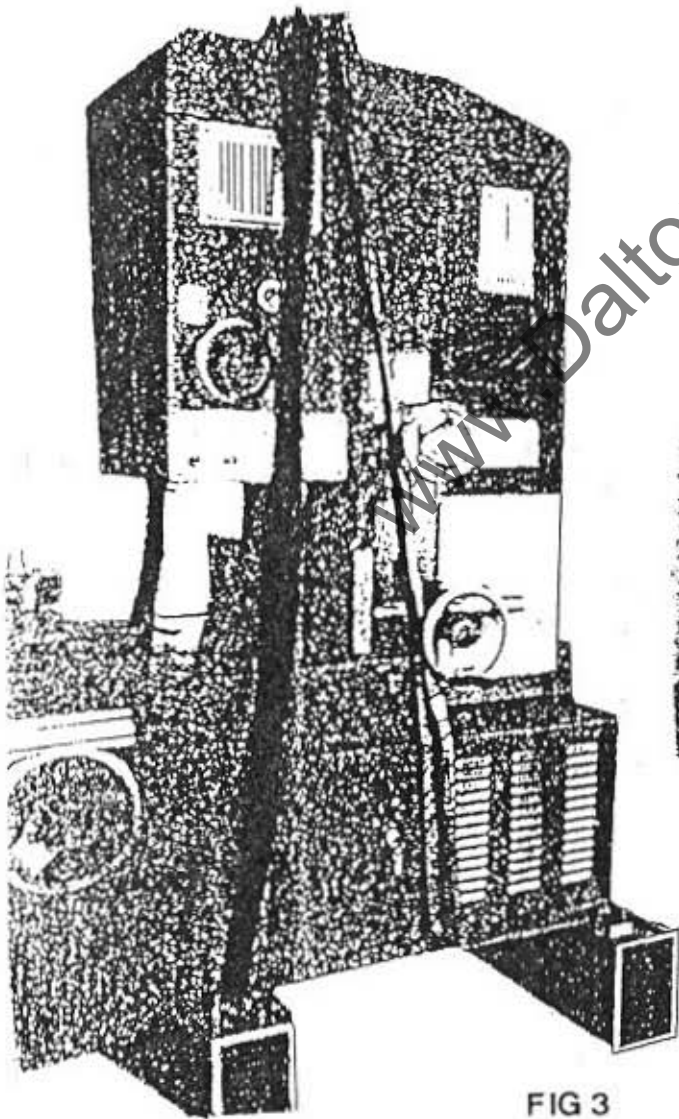


FIG 3

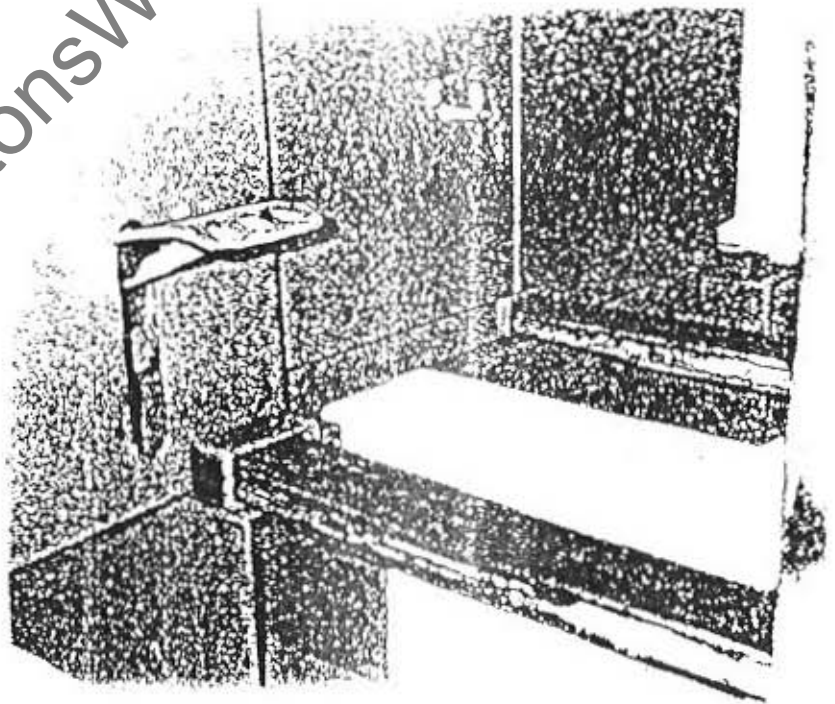


FIG 2

#### 4.2 SLINGING / LIFTING

Always use a sling within the safe loading of machine weight.

Approx net weight of machine. 1500kg

Approx gross weight of machine. 1750Kg

Always attach slings to lifting point (Fig.1) or use forklift points within the mainframe (Fig.2) or sling as shown in diagram (Fig.3.) to ensure damage will not be caused to the machine during the lifting/slinging operation.

#### IMPORTANT

DO NOT WALK OR STAND UNDER THE MACHINE DURING SLINGING OPERATION.

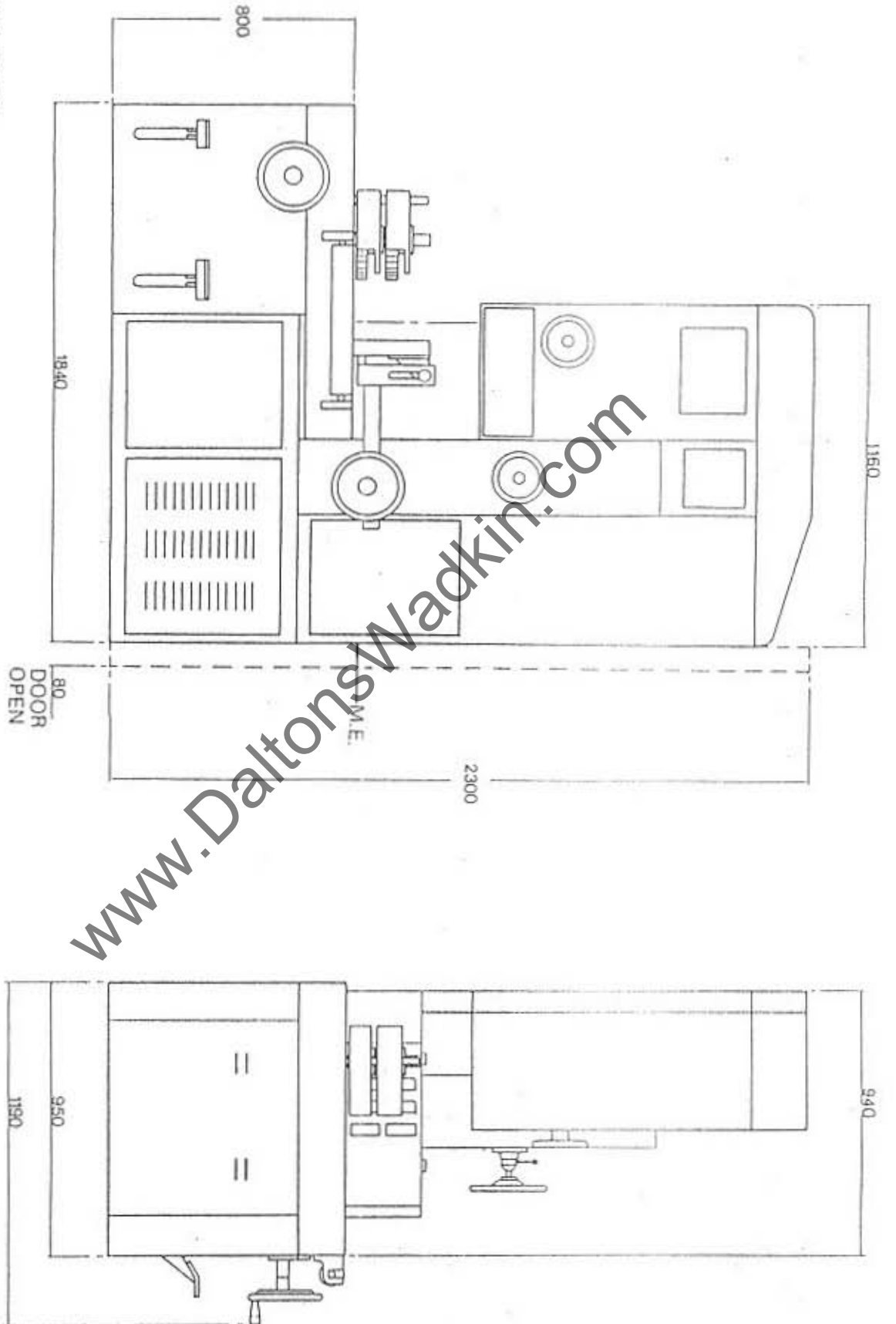
#### 4.3 FOUNDATION

Ensure:-

1. Floor is level.
2. Pit is prepared to suit (Fig. 4 & 5).

Mark to suit 4 M12 rawl bolts around the side of the pit. Bolts are not supplied with the machine, but can be supplied at an additional cost. Locate the machine through the bolts into the holes provided in the base of the machine.

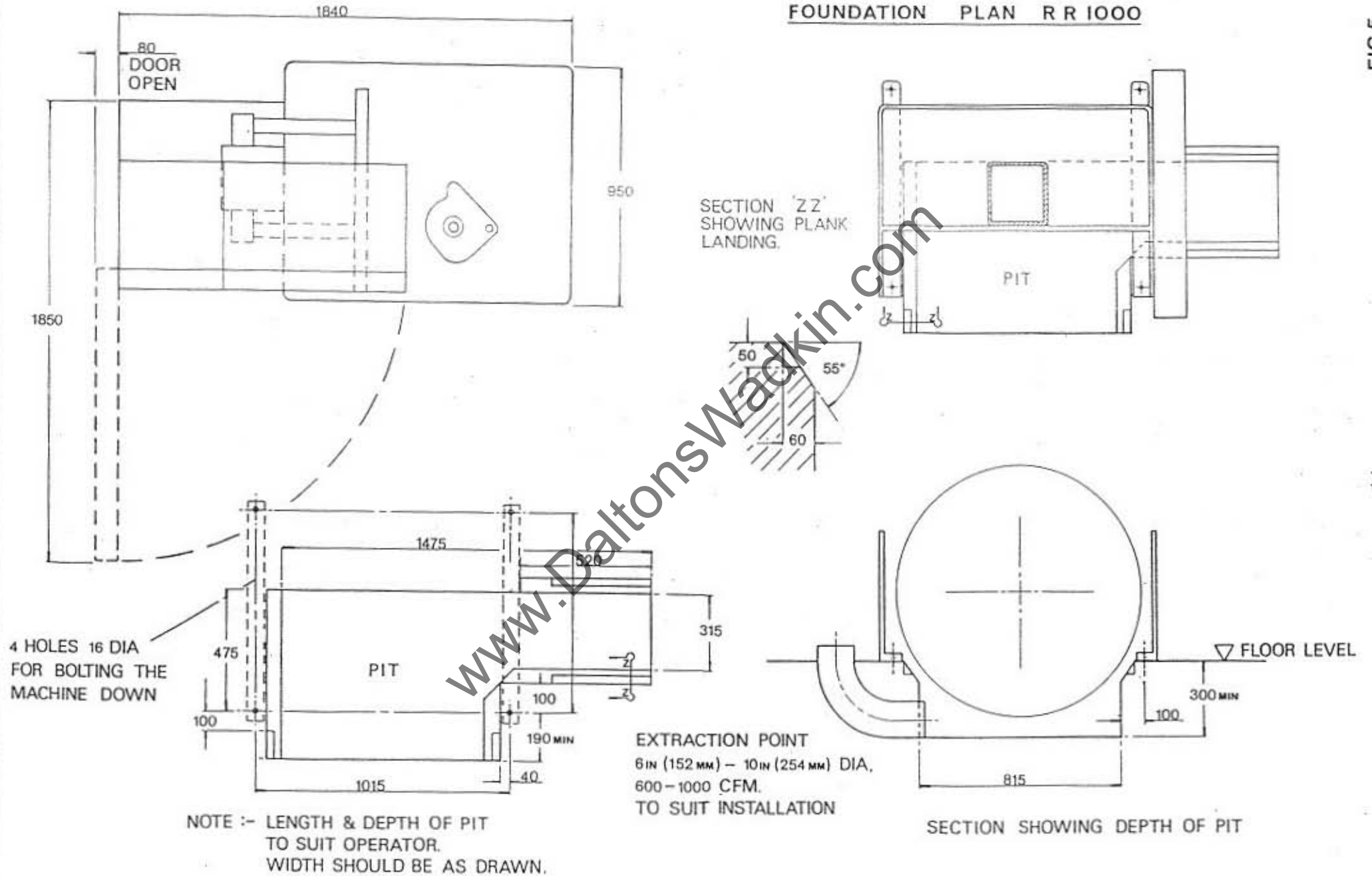
M.E. - MAINS ENTRY.  
CONNECT TO L<sub>1</sub>-L<sub>2</sub>-L<sub>3</sub> + EARTH. OR (1-3-5).  
TO REVERSE DIRECTION, INTERCHANGE ANY ONE OF TWO PHASES.



FOUNDATION PLAN R R 1000

# FOUNDATION PLAN R R 1000

FIG 5



11

### 4.3 INSTALLATION

The machine should be so placed that the traffic of men and materials to and from it fits smoothly into the general scheme of traffic. The machine should be so placed that it will not be necessary for the operator to stand in or near an aisle as to cause a hazard. Note the size of the machine when planning installation (Fig.4). The minimum clearance on each working side of the machine should be at least 1000mm greater than the length of the largest material worked on the machine.

The machine should be placed on a secure base of concrete on prepared foundations as per drawing (Fig.5)

Round pocket holes (16 dia) can be left for securing bolts to be grouted in when the machine is finally positioned.

#### 4.3.1 FINAL POSITIONING

The machine should now be levelled up by placing slate or metal packings at the corners. Adjust packing as required. Use a spirit level on the table to ensure that the table is in square. Check all levels once more and then run grout into the pocket holes to hold the bolts.

Finally remove the protective coating from bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

DO NOT ATTEMPT TO TIGHTEN BOLTS UNTIL GROUTING HAS THOROUGHLY HARDENED.

### 4.4 ASSEMBLY OF MACHINE.

Normally, the machine will be delivered with the bottom wheel and drive belts removed. The saw wheel should be mounted on the machine once it has been positioned. the machine is provided with five pulley belts (REF. SPA1500 wedge belts) which should be hung loosely over the bottom wheel in the grooves of the hub. The wheel is then fitted onto, the bottom wheel spindle, at the same time working the drive belts onto the motor pulley. finally, secure the wheel into position with the M16 bolt and wheel washer. (Fig.6.)

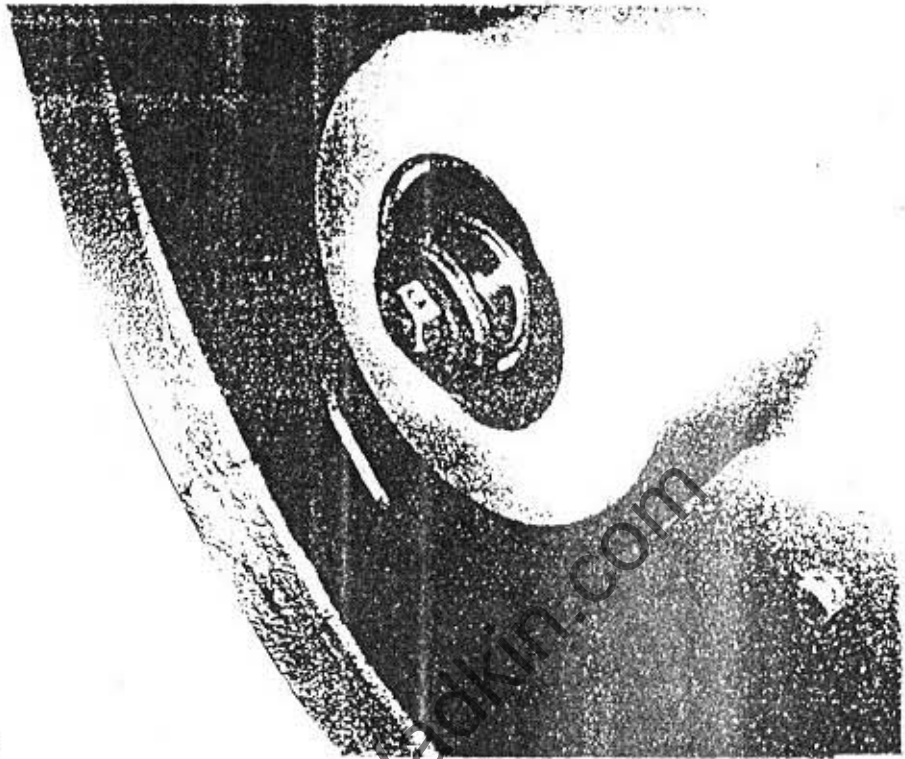
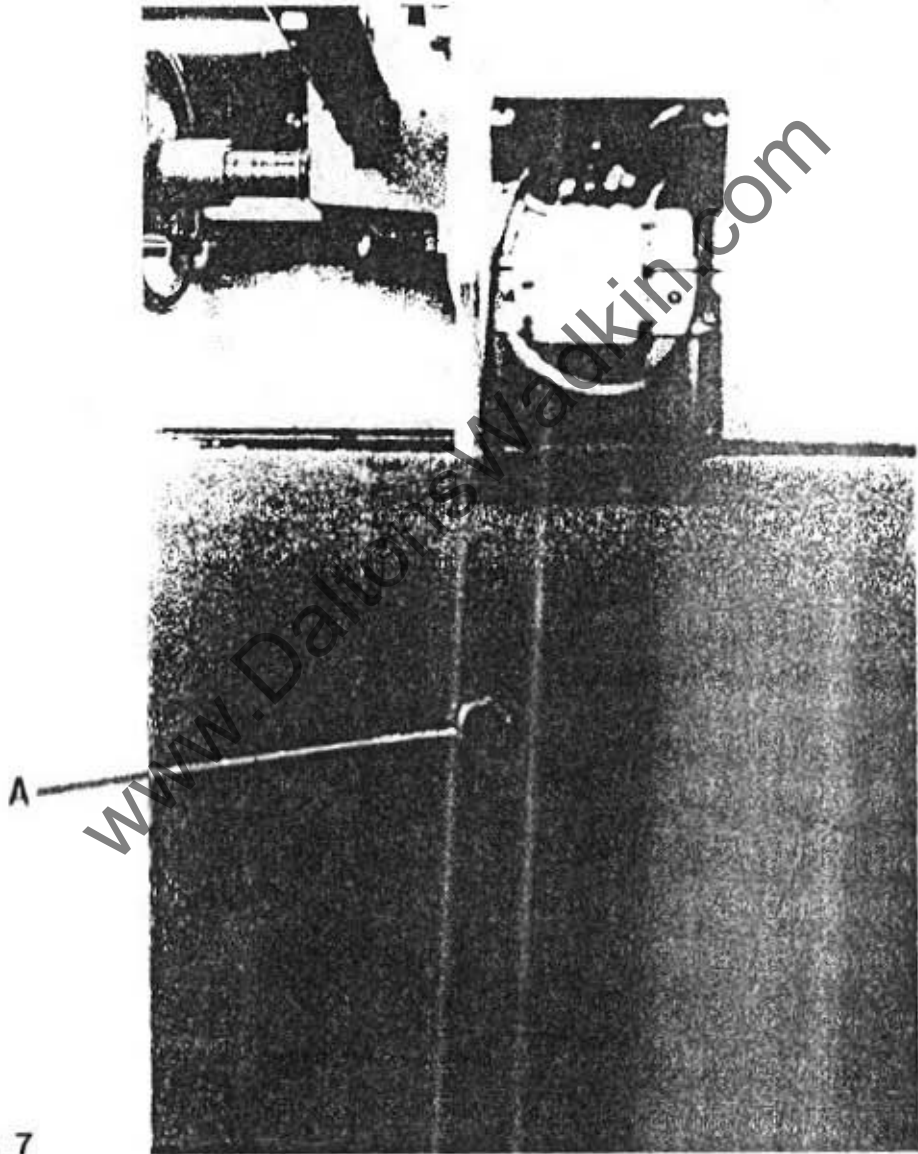


FIG 6





#### 4.4.1 BELT TENSION

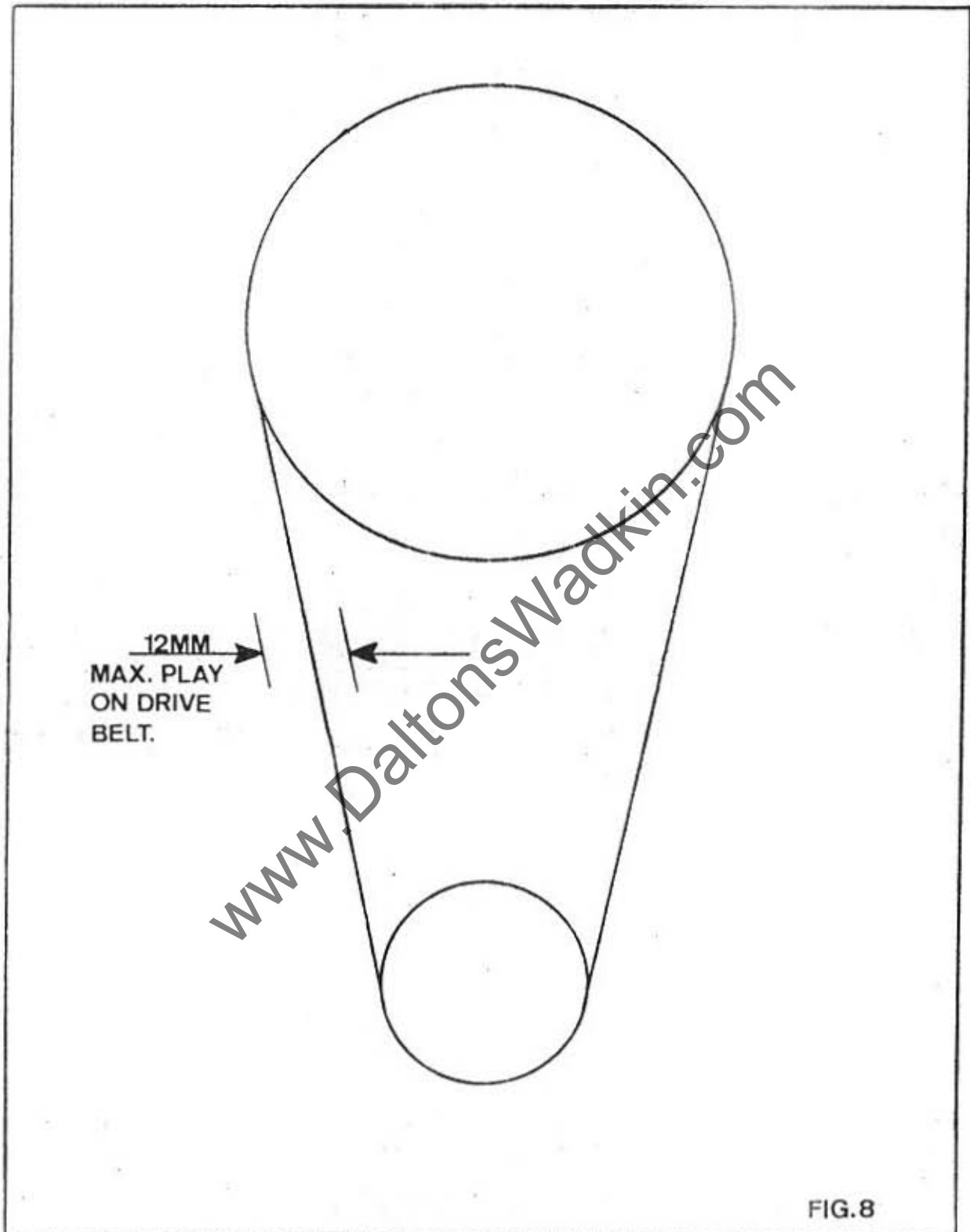
Incorrect tension is the major cause of premature belt failure. Some of its effects are as follows:-

- 1) Under tensioning results in incorrect driven speed caused by slipping. This also causes screeching on start up. This can be corrected by increasing the tension via adjusting bolt ('A' Fig.7).
- 2) Over tensioning can be more serious. Apart from obvious damage to the belts, it can cause overheating, damage or burnout of the motor front end bearings. This problem is usually preceded by excessive stretch of the belt.

#### BELT TENSION ADJUSTMENT

- 1) Isolate the machine electrically.
- 2) Open the machine door.
- 3) With the M16 bolt head ('A' Fig.7) rotate clockwise to tighten and anticlockwise to release the belt tension.
- 4) Check belt tension and allow 10-12mm of play (Fig.8).
- 5) DO NOT OVER-TENSION BELT.





CONTROL  
VALVE

FIG 9

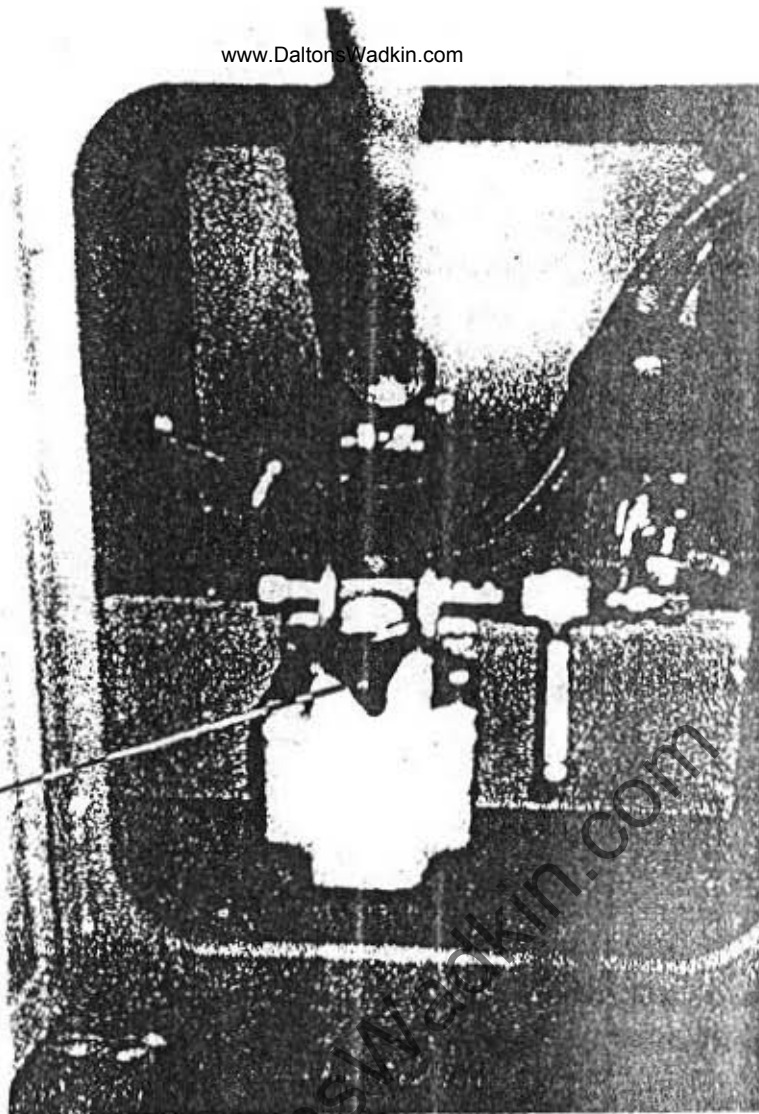


FIG 10



#### 4.4.2 FITTING OF THE BLADE

- 1) Take out the table insert (Pg.30 Fig 23).
- 2) Open the door fully.
- 3) Release the pressure from the top slide control valve (Fig.9).
- 4) Allow the saw to be positioned on the top and bottom wheels and slot the saw through into the guides.

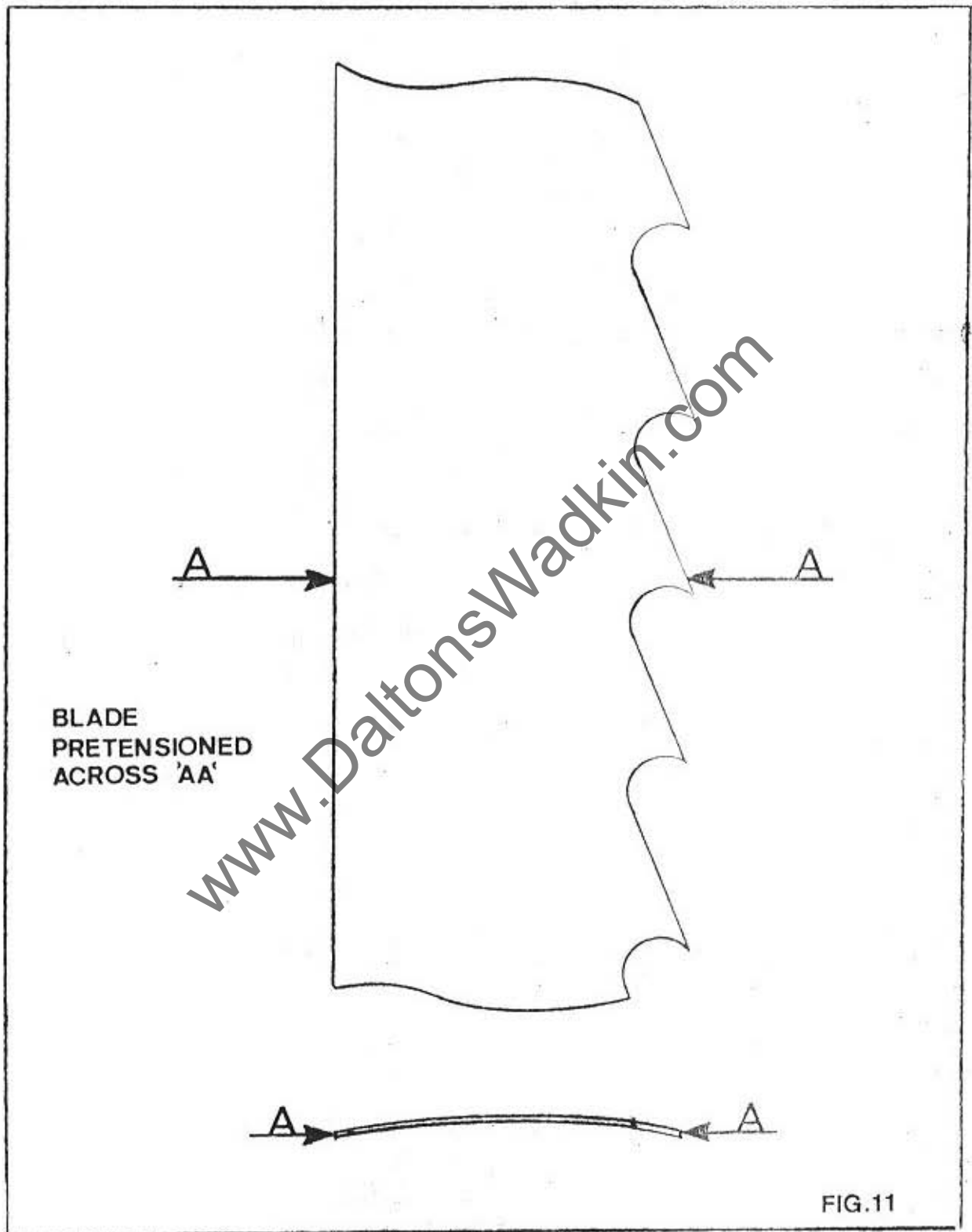
**NOTE:**

- A. The saw guards are fixed and should not be removed.
- B. The saw guides are not set and should be adjusted up to the blade, 0.1mm clear of the blade. (Fig.10).

#### 4.4.3 THE RE-SAW BLADE

For the best result it is recommended to use blades of 'UDDEHOLM SWEDISH STEEL' to the following specification:-

- 1) 19 gauge (1.016mm thick) x 4 or 5 inches (100 or 125mm) wide x 1 3/4 (44mm) inch pitch swage or stellite tipped.
- 2) Approximate length of blade 19 feet 10 inches (6042mm).
- 3) Blade should be pretensioned across width see (Fig.11.)
- 4) The blades should be SWAGE TOOTH for SOFT WOOD or STELLITE TIPPED for HARDWOODS.
- 5) Service and doctor re-saw blades regularly.
- 6) Blades should not be folded in tight radii where the weld occurs.



#### 4.4.4 IMPORTANT RE-SAW BLADE MAINTENANCE

Failure to maintain re-saw blades will result in inaccurate ripping and shortened blade life.

It is important that the blades are regularly maintained, ie re-sharpened and re-tensioned by a saw doctor, and that the tension is released from the saw when not in use.

It is usual practice for a re-saw blade to require maintenance after 4 hours running, however, the frequency at which maintenance will be required will depend to some extent on the following factors:-

- 1) Correct type blade for ripping stock (i.e. soft or hard wood, swage or stellite tipped blades).
- 2) Correct feed speeds relative to depth of stock.
- 3) Correct tension applied to saw.

The following chart will assist you in fault finding.

FAULT	CAUSE	REMEDY
Blades unstable.	Tension run out of blade.	Return to saw doctor for re-tensioning.
	Build up of resin on wheels or blade.	Clean wheels & blade and check wheel & blade brushes.
Inaccurate ripping.	Dull blade.	Re-sharpen blade.
	Insufficient tension applied to saw.	Check saw tension gauge.
	Guide set incorrectly.	Re-set top & bottom saw guides.
Blades fracturing.	Tension run out of blade.	Return blades to saw doctor for re-tensioning.
	Overloading of saw.	Check feed speeds.
	Over running saw blade.	Check running time.
	Dirty blades and wheels.	Clean wheels, blade and check brushes.
	Sawdust trapping between bottom wheel and blade.	Check condition and position of chip deflector plate.

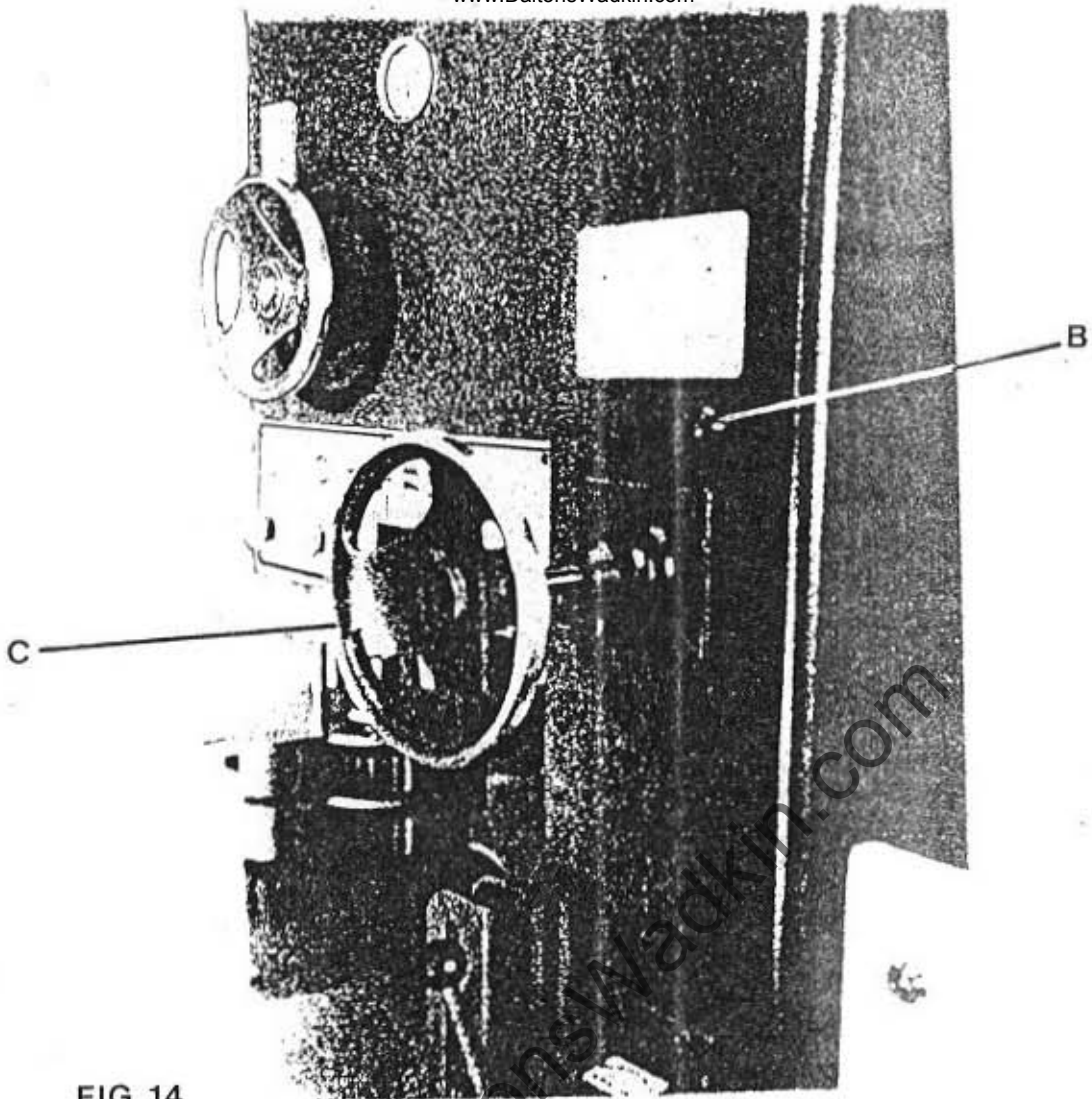


FIG 14

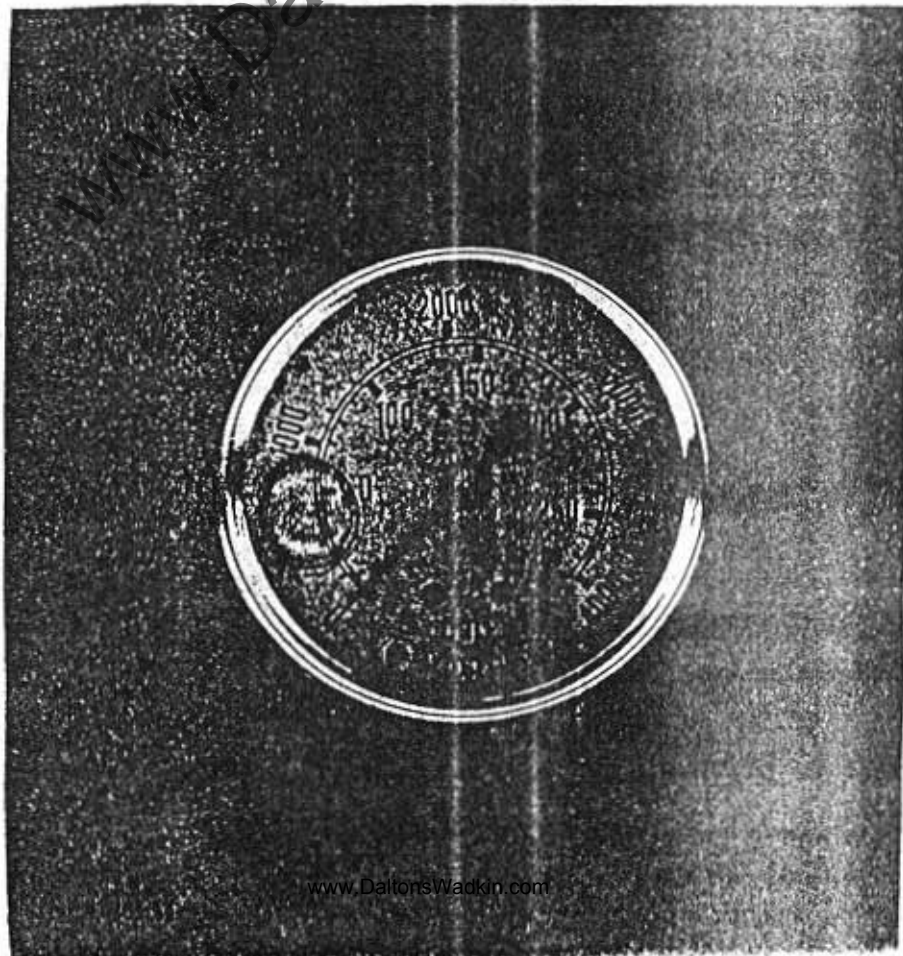


FIG 12

#### 4.4.6 SAWBLADE TENSION

Tension the saw via the hydraulic pump unit (*Fig. 9*). Refer to the gauge (*Fig. 12*). for the correct pressure selection to suit the work to be undertaken.

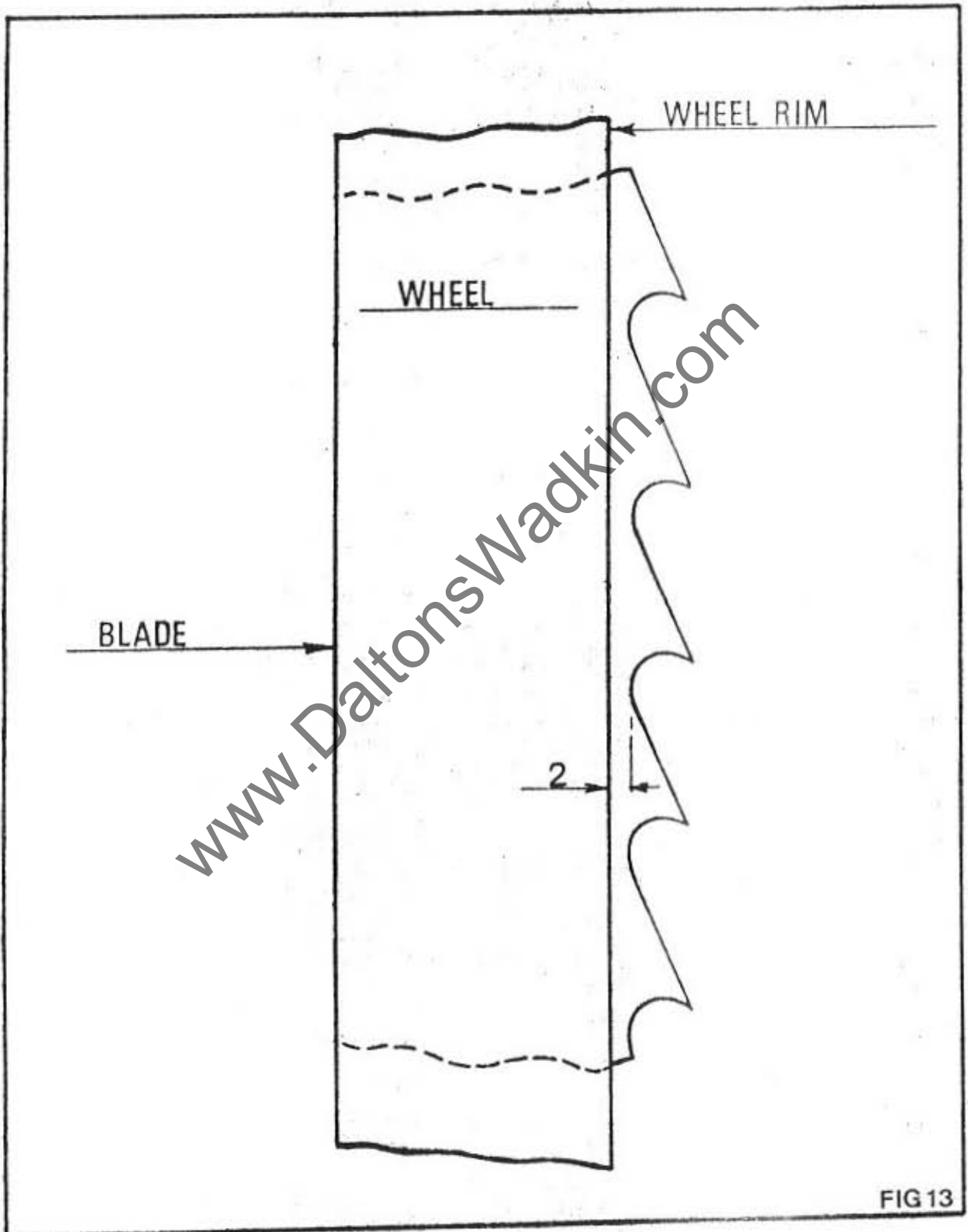
#### 4.4.7 SAWBLADE TRACKING

Track the blade by rotating the top wheel, by hand, in a clockwise direction. The root of the saw tooth should project past the rim of the wheel by approx 2mm. (*Fig 13*) Should the blade require tracking, loosen the handle ('B' *Fig. 14.*) and turn the handwheel 'C' until the saw is tracked correctly.

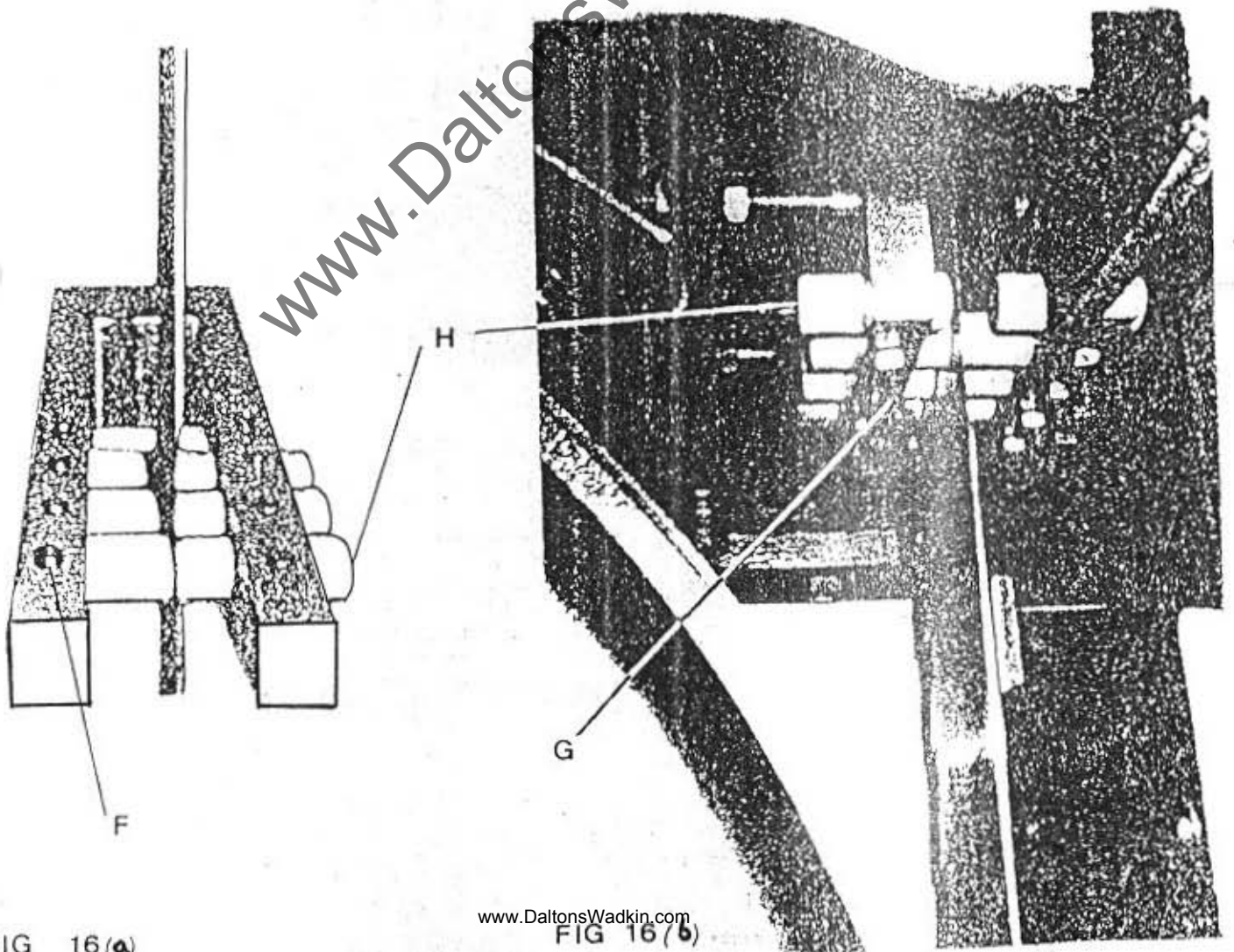
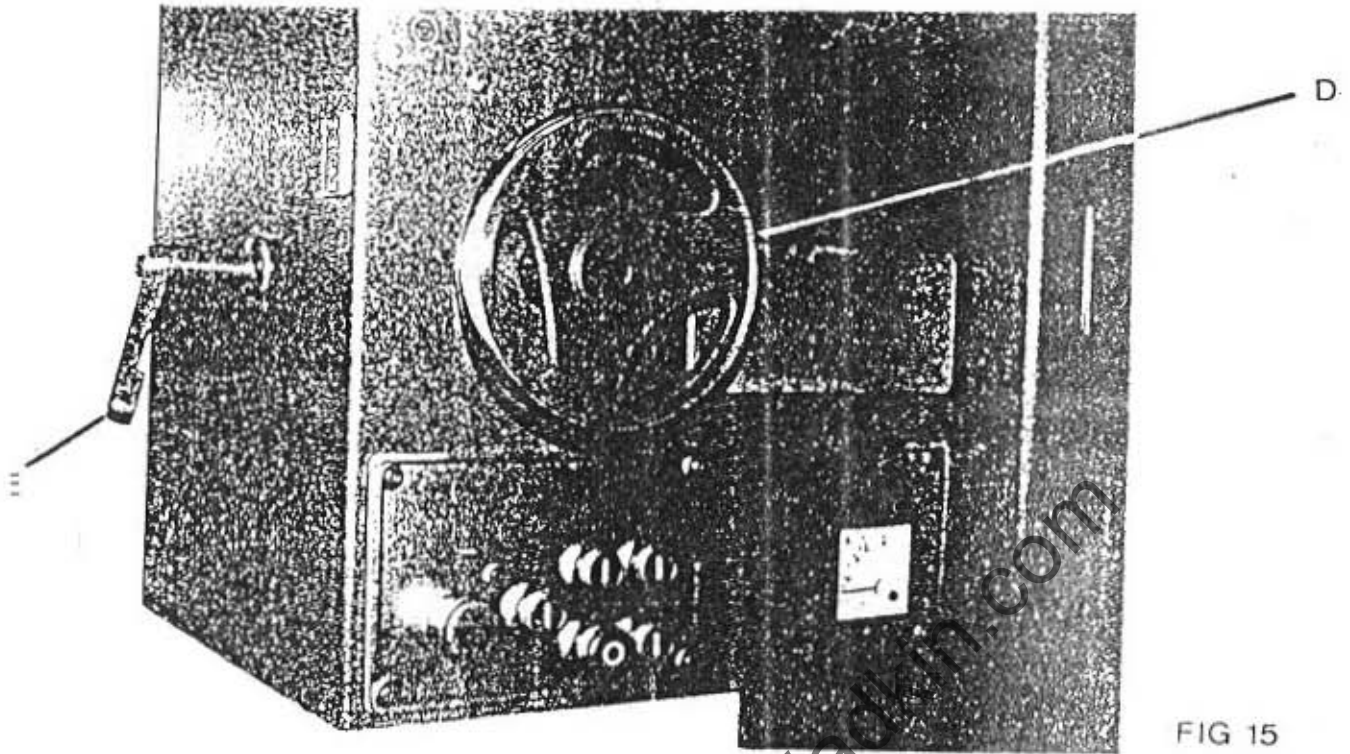
Note, handle 'B' must be retightend to lock the tracking position.

#### IMPORTANT

DO NOT TRACK THE BLADE WHILST THE MOTOR IS RUNNING.







#### 4.4.7 SETTING OF THE SAWBLADE GUIDES

The top saw guard / guide unit is vertically adjustable by a handwheel ('D' Fig.15) and locked in the desired position by locking handle ('E' Fig.15.)

BEFORE PROCEEDING TO SET TOP GUIDE, ENSURE:-

- 1) Top guide is locked in position.
- 2) Machine is isolated electrically.
- 3) Blade is correctly tensioned and tracked.

PROCEED TO SET TOP AND BOTTOM GUIDES AS FOLLOWS:-

- 1) Slacken all M8 grub screws (top guide) ('F' Fig.16a) and the M8 hexagonal bolts (bottom guide) ('G' Fig.16b).
- 2) Slide the guide elements ('H' Figs 16) away from the blade.
- 3) Proceed to adjust each guide element individually to within 0.1mm of the blade, (take care not to deflect blade from its natural line), then lock in position with M8 grub screws / M8 hex bolts.
- 4) Rotate the blade by hand to ensure that the blade runs freely in the guides.

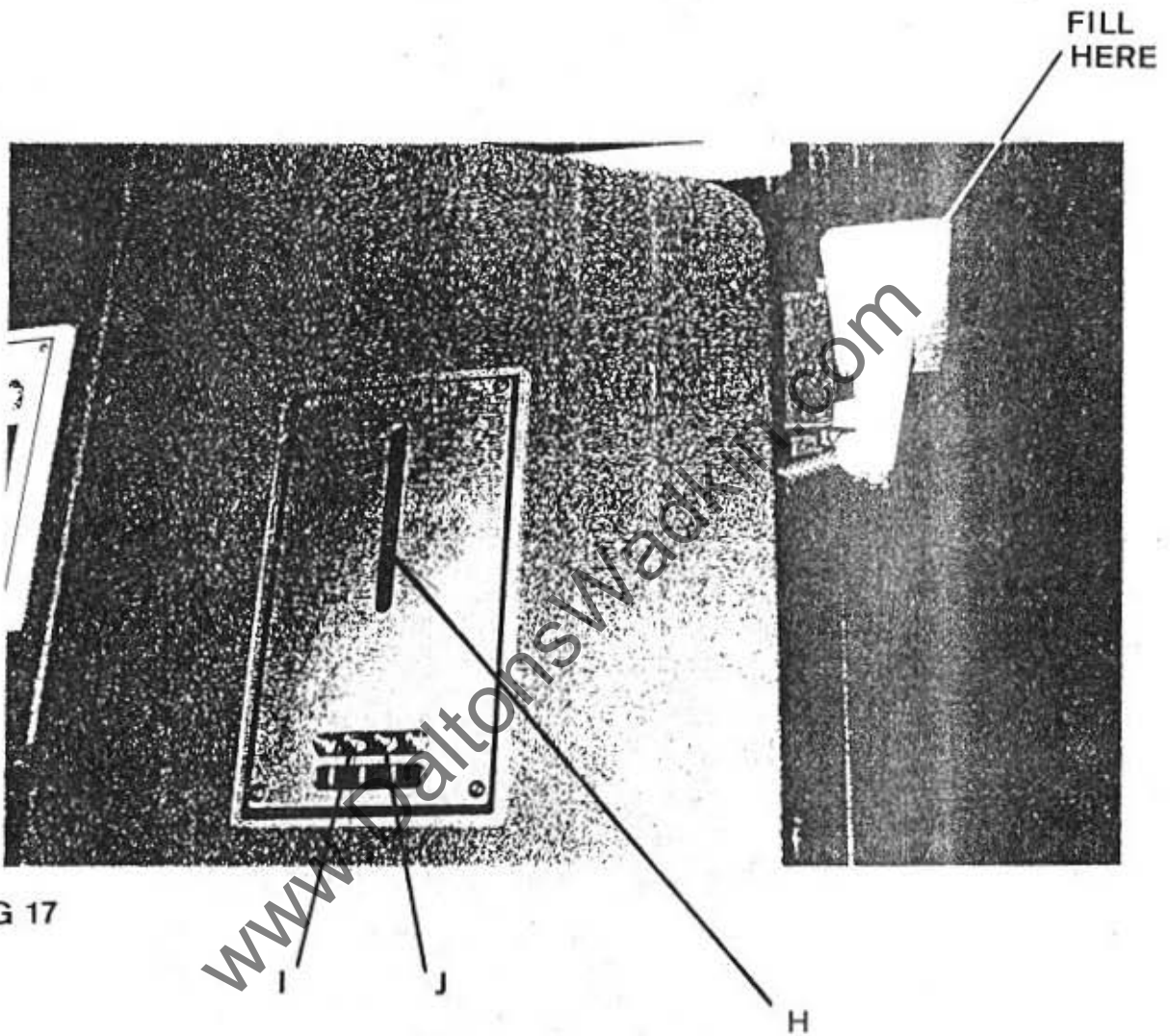
#### 4.4.8 DRIP FEED UNIT FOR CLEANING WHEEL & BLADE BY BRUSHES AND FELT PADS

This machine is fitted with either hand operated drip feed unit control or an automatic solenoid type unit. The latter becomes operable when the saw motor is switched on. The oiler bottle is filled from outside the machine (Fig.17). Check the oiler level gauge when filling (Fig.17 'H'). The oiler flow is adjusted by two screws ('I' & 'J' Fig.17). The flow should be 1 drop per second approx. The two outer screws can be used to run pipes to other areas where lubrication is considered necessary.

The purpose of the oiler unit is to keep the wheels and blade clean. The mixture of fluid (i.e. Diesel, Parafin, Oil) required will vary depending on the stock being sawn. A general guide is listed below.

- A) Dry, resin-free material - generally no fluid required.
- B) Average material - 1-1 diesel or parafin and oil.
- C) Dry, resinous material - 2-1 diesel or parafin and oil.
- D) Wet material - 1-2 diesel or parafin and oil.

NOTE:- Turn off fluid feed when not in use.



#### 4.4.9 TOP / BOTTOM WHEEL BRUSHES

(Fig 18 / 19 ).

These should be in constant contact with the wheels. Adjustment is made by two M8 bolts (Fig.18. & Fig.19 ). When the brushes are worn out they should be replaced immediately.

#### 4.4.10 FELT PAD

Lubrication is provided to both felt pads either side of the blade. These should be kept constantly moist and never allowed to dry out. Resinous build up on these pads should be removed upon blade renewal. The two pads should be in continuous contact with the blade. (Fig.20).

#### 4.4.11 BRASS / PLASTIC WHEEL SCRAPERS

These should be set 0.1mm clear of the wheel. They should be regularly checked and adjusted to prevent resinous build up on the tyre. The scraper unit can be easily adjusted by loosening 2 M8 nuts. (Fig.21)

#### 4.4.12 CHIP DEFLECTOR PLATE.

(Fig.22).

The chip deflector plate should always be positioned to away from touching the blade (0.1mm gap). This minimises the amount of dust deflecting between the blade and the wheel thus increasing the blade life.

The chip deflector plate should be pulled out of the way when removing the blade and when setting the guides. Reposition only when all the setting up has been completed. (Fig.22) . The chip deflector is held in place by a M10 hexagonal bolt.

#### 4.4.13 TABLE INSERT

The table insert (Fig.23). is repacable and should be removed when changing blades. The insert readily lifts out by removing off the two pins.

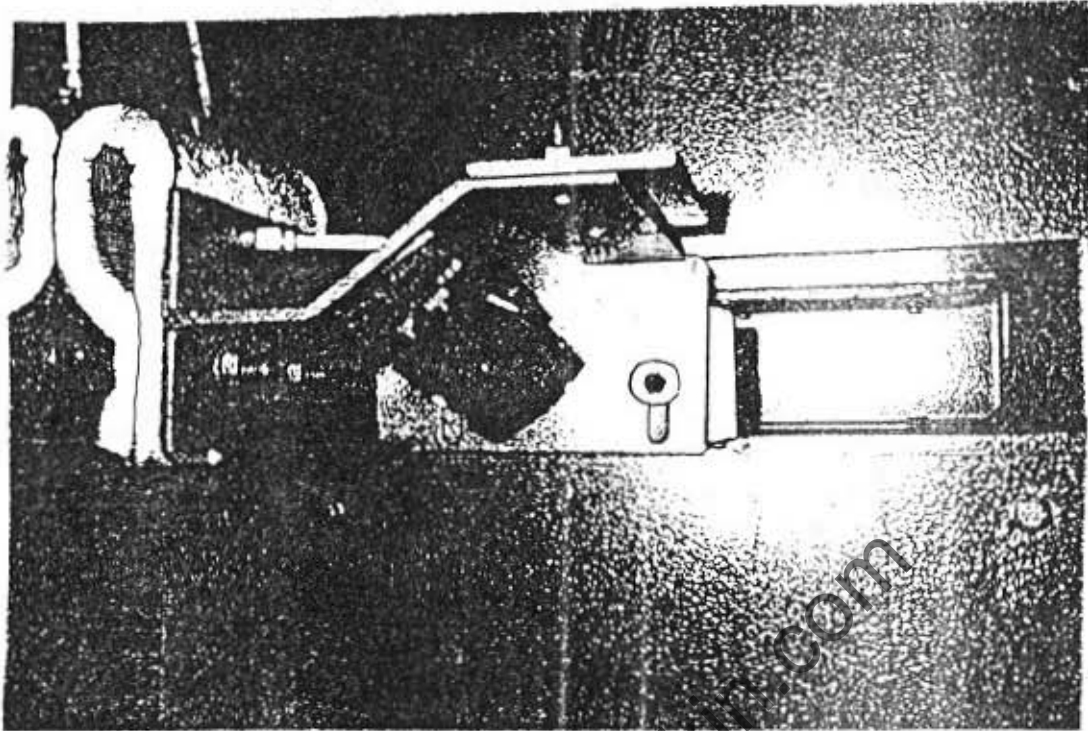


FIG 18

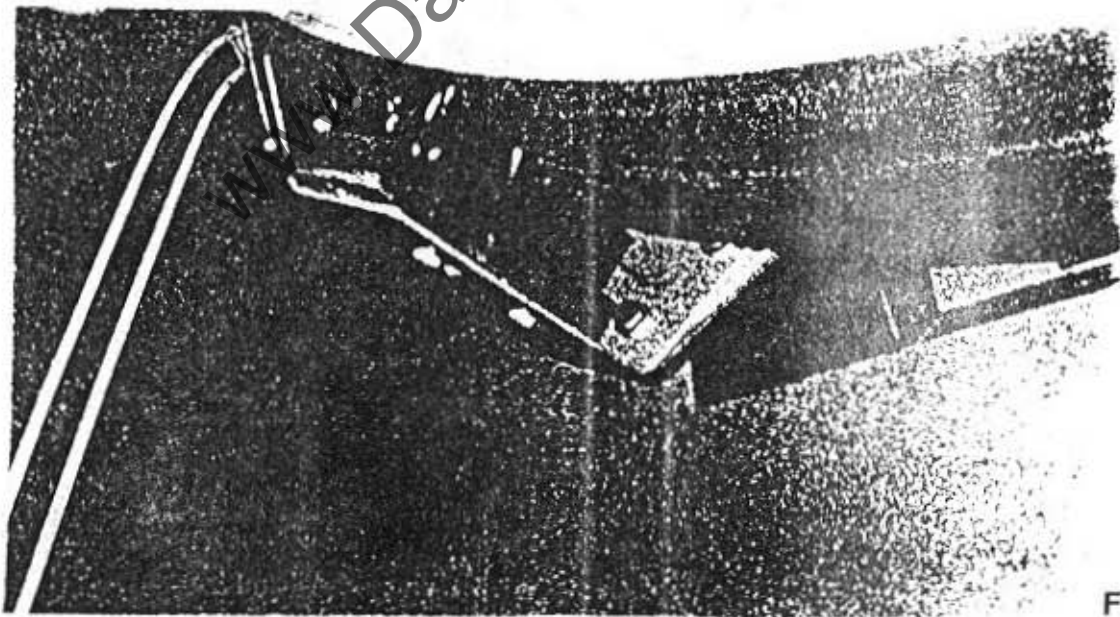


FIG 19



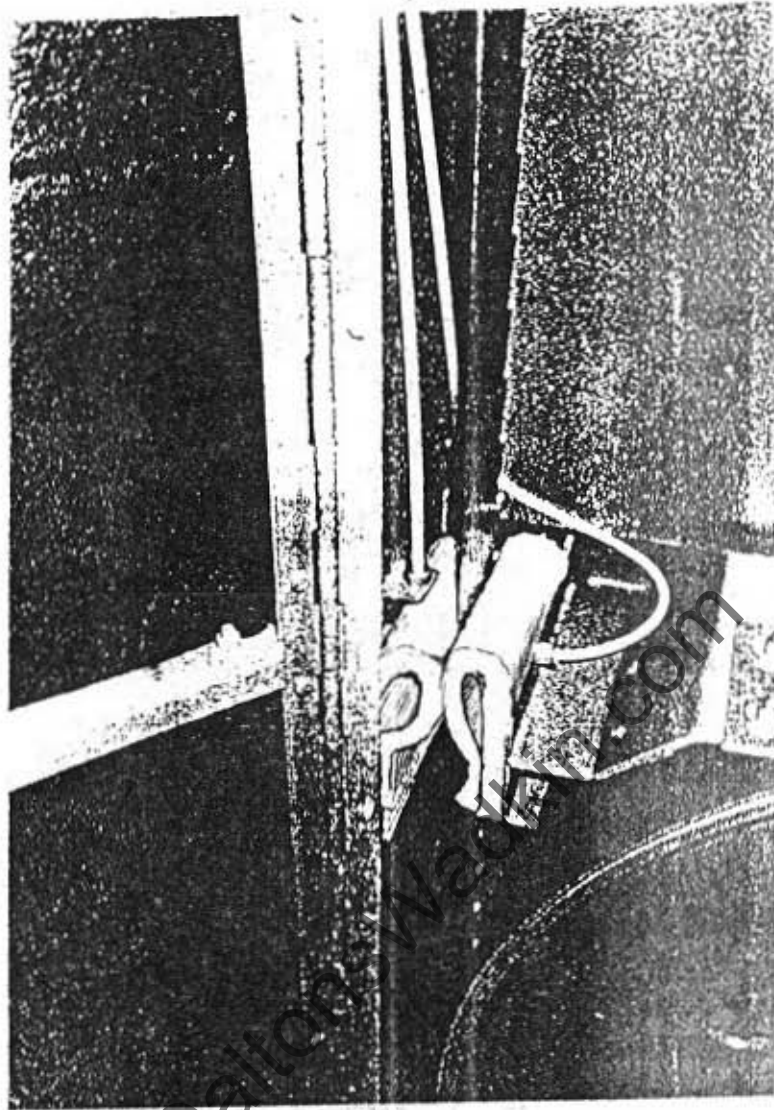


FIG 20

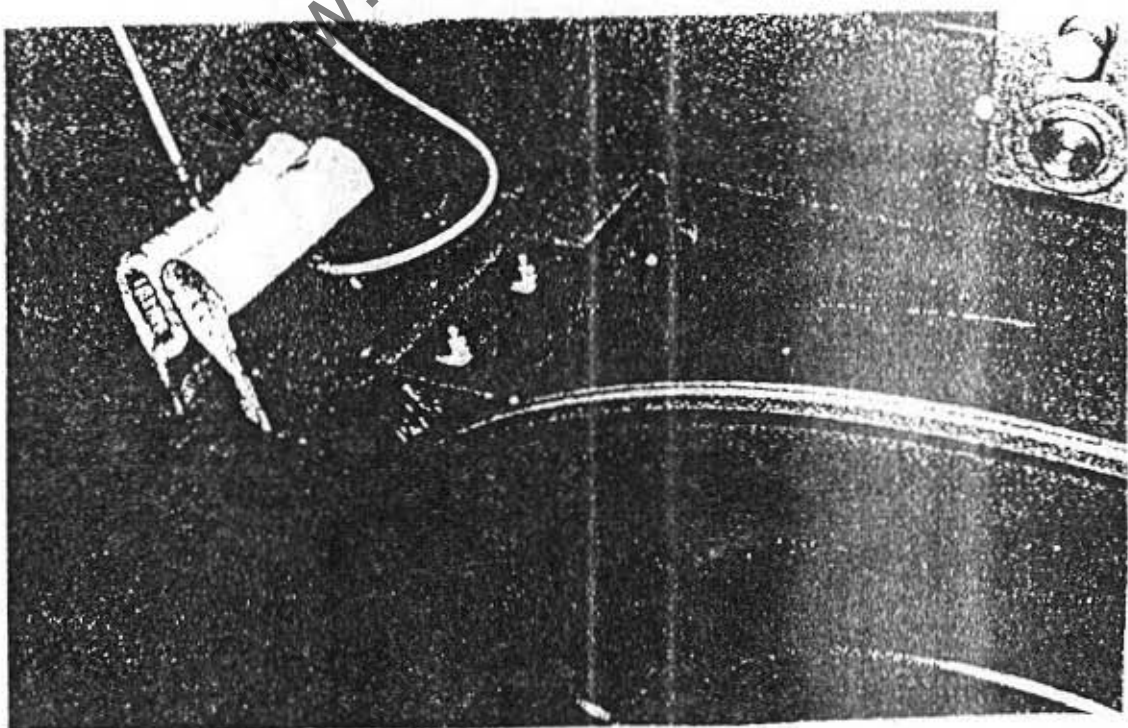


FIG 21

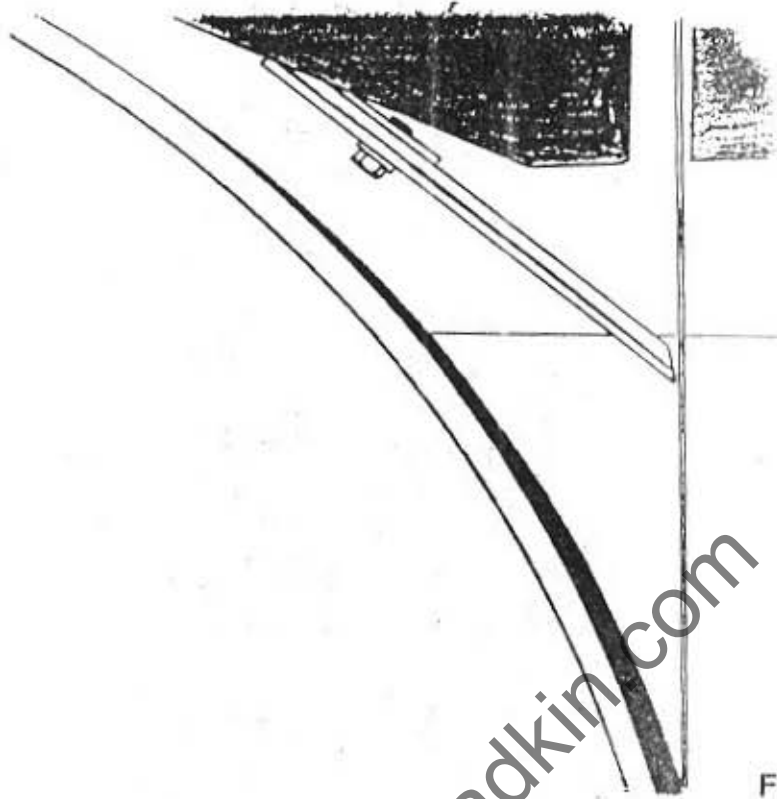


FIG 22

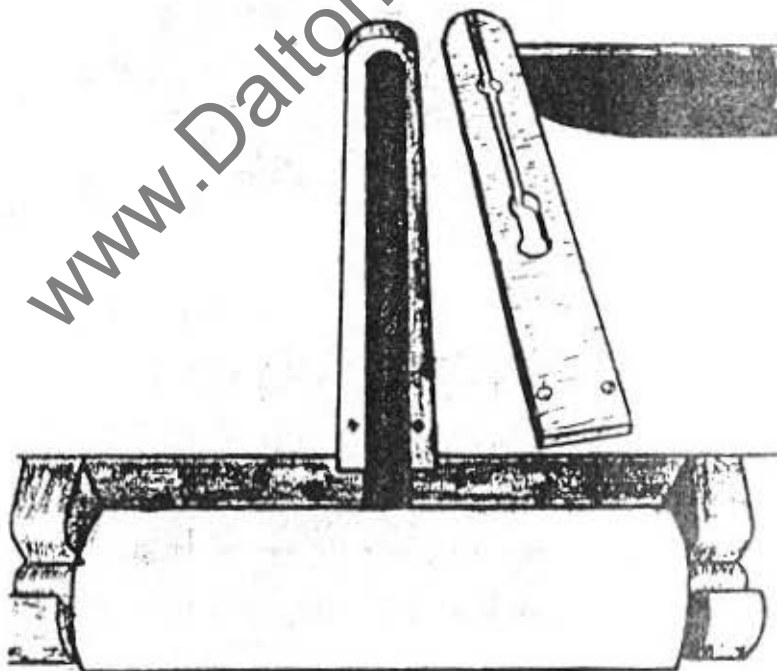


FIG 23

#### 4.5 ELECTRICAL WIRING DETAILS

All work carried out on site must be done by a competent electrician. For full details see wiring diagrams (Fig.24 & Fig.25). The machine is wired to a terminal box mounted onto the mainframe. The mains entry cable should be positioned with regards to IEE recommendations.

Points to note when connecting power supply:

- 1) Check voltage, phase and frequency corresponds to electrical plate fitted on the machine.
- 2) It is important that the correct cable is used to give the correct voltage to the starter as running on a low voltage will damage the motor.
- 3) Check the main line fuses are the correct capacity. (See fuse list, page No 32) .
- 4) Connect line leads L1, L2, L3 + EARTH (+ NEUTRAL where applicable Fig. 24.)
- 5) Check all connections are sound.

To be checked.

#### IMPORTANT

- 6) Do not rewire any other connections other than mains entry to reverse the direction of the motor. The machine is set up to function properly when the main motor runs in the correct direction.

To reverse the direction of the main motor, interchange any one of the two phases.



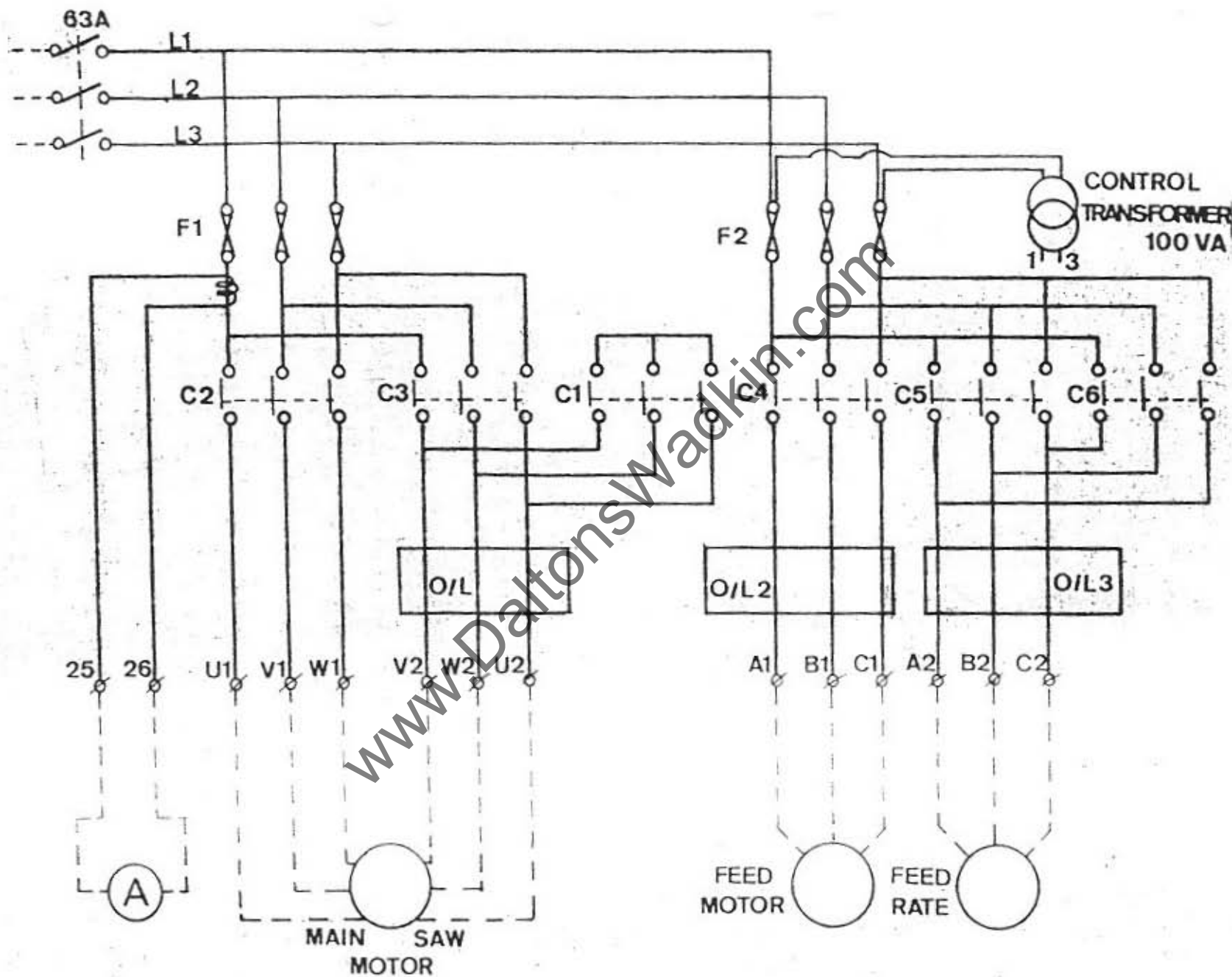
RR1000 fuse list.

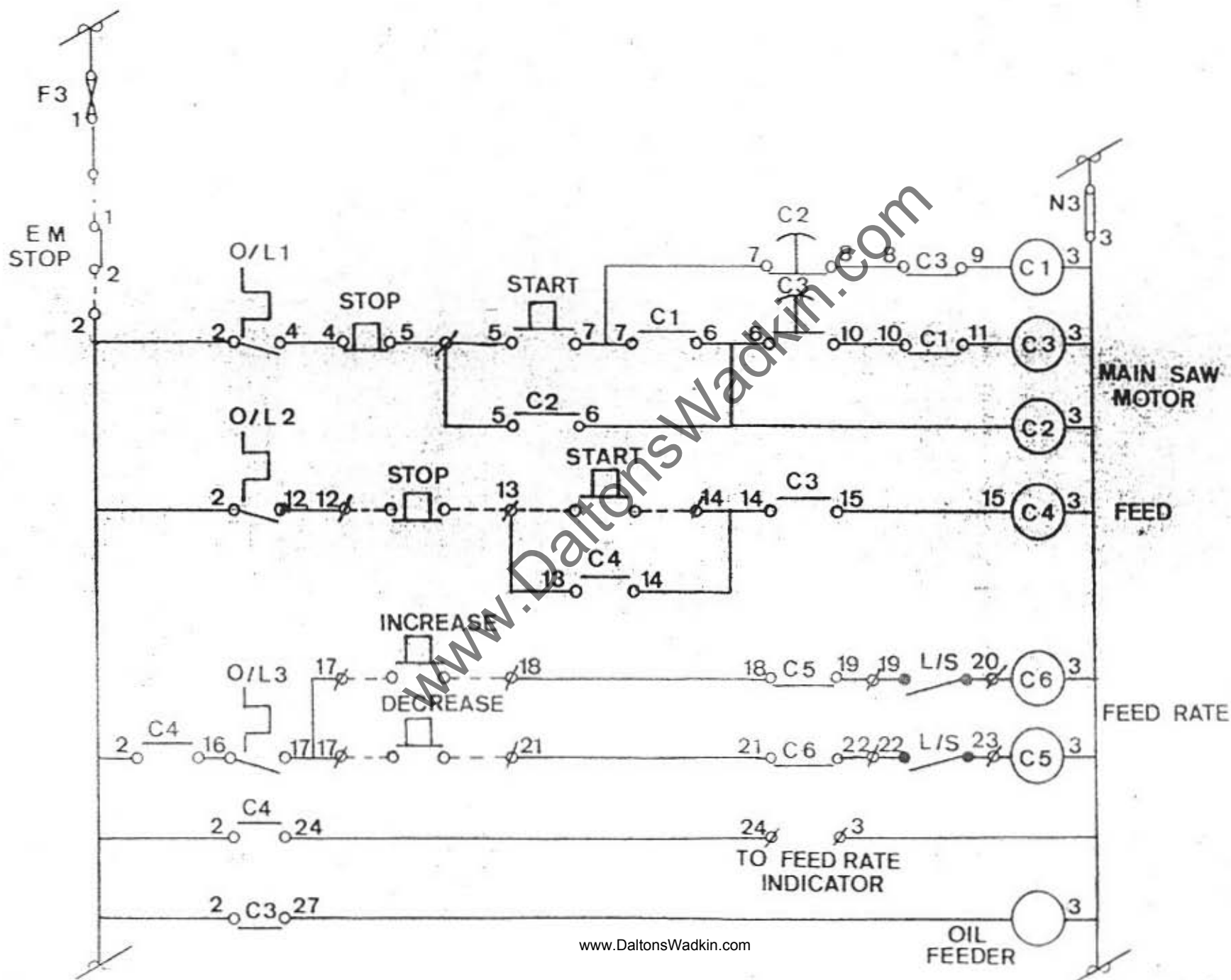
3 fuses at 50 Amp MAIN MOTOR.

3 fuses at 10 Amp FEEDER MOTOR.

1 fuse at 2 Amp and a nutral link for output to transformer.

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#### 4.6 EXTRACTION

The machine must be connected to a suitable extraction system.

NOTE: Provision must be made for an exhaust duct to be incorporated into the pit. ( *Fig.5*). This should ideally be positioned under the bottom wheel.

#### 5.0 MECHANICAL CONTROLS

##### 5.1.1 GUIDE POST RISE & FALL

Handwheel 'D' & 'E' (*Fig.15. Pg24*)

Handwheel 'D' raises and lowers the guide post.

Handwheel 'E' locks the guide post into position.

##### 5.1.2 BLADE TRACKING

Handwheel 'B' & 'C' (*Fig.14.*)

Handwheel 'C' tracks the blade forward and backward.

Handwheel 'B' locks the tracking in position.

##### 5.1.3 FENCE CONTROL & LOCK

Handwheel 'L' & 'M' (*Fig.26*).

Handwheel 'L' controls the fence position.

Handwheel 'M' locks off both fence bars simultaneously.

##### 5.1.4 CANTING FENCE LOCK

Fence lock nuts M16 ('N' *Fig.26*). slacken off the canting fence. When the fence is at the required angle lock off.

NOTE: The fence should be canted with the lock ('M' *Fig.26*) ON

##### 5.1.5 CROSS TRAVERSE MOVEMENT OF FEED ROLLERS BY HANDWHEEL

Handwheel ('O' *Fig.27*). controls the cross traverse positioning of the feeder unit relative to the stock.

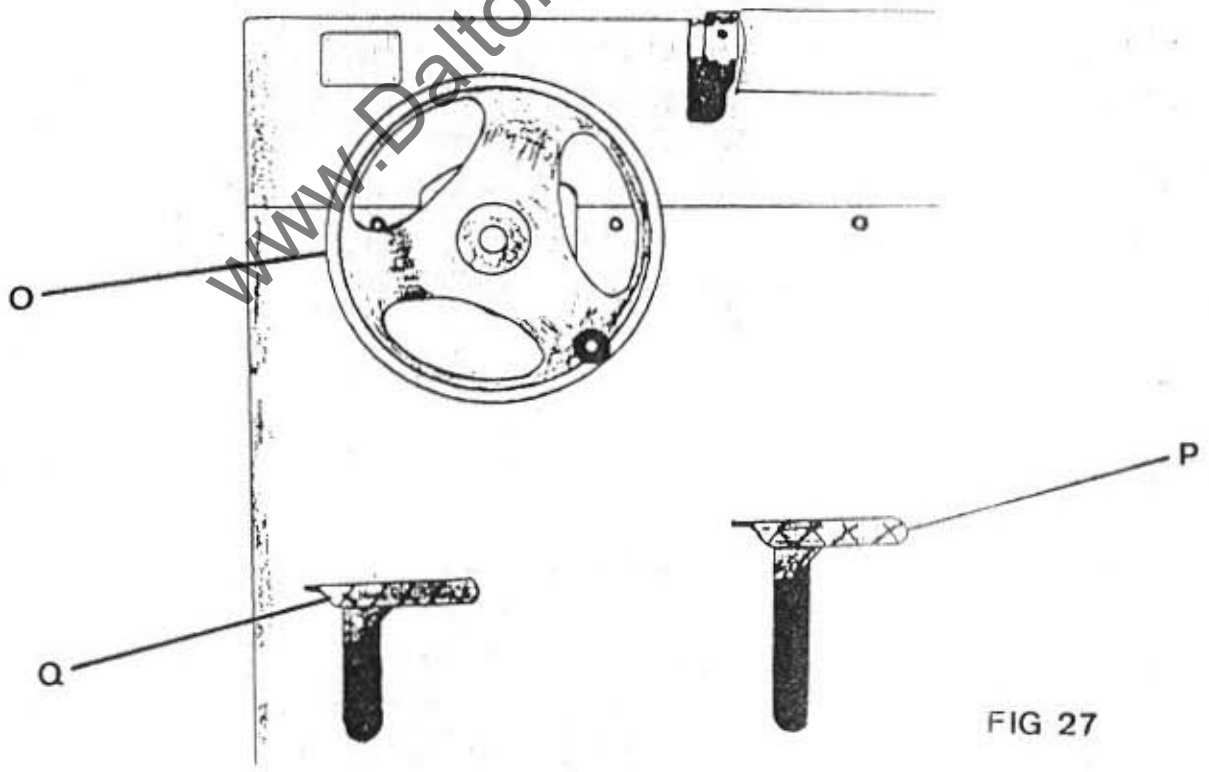
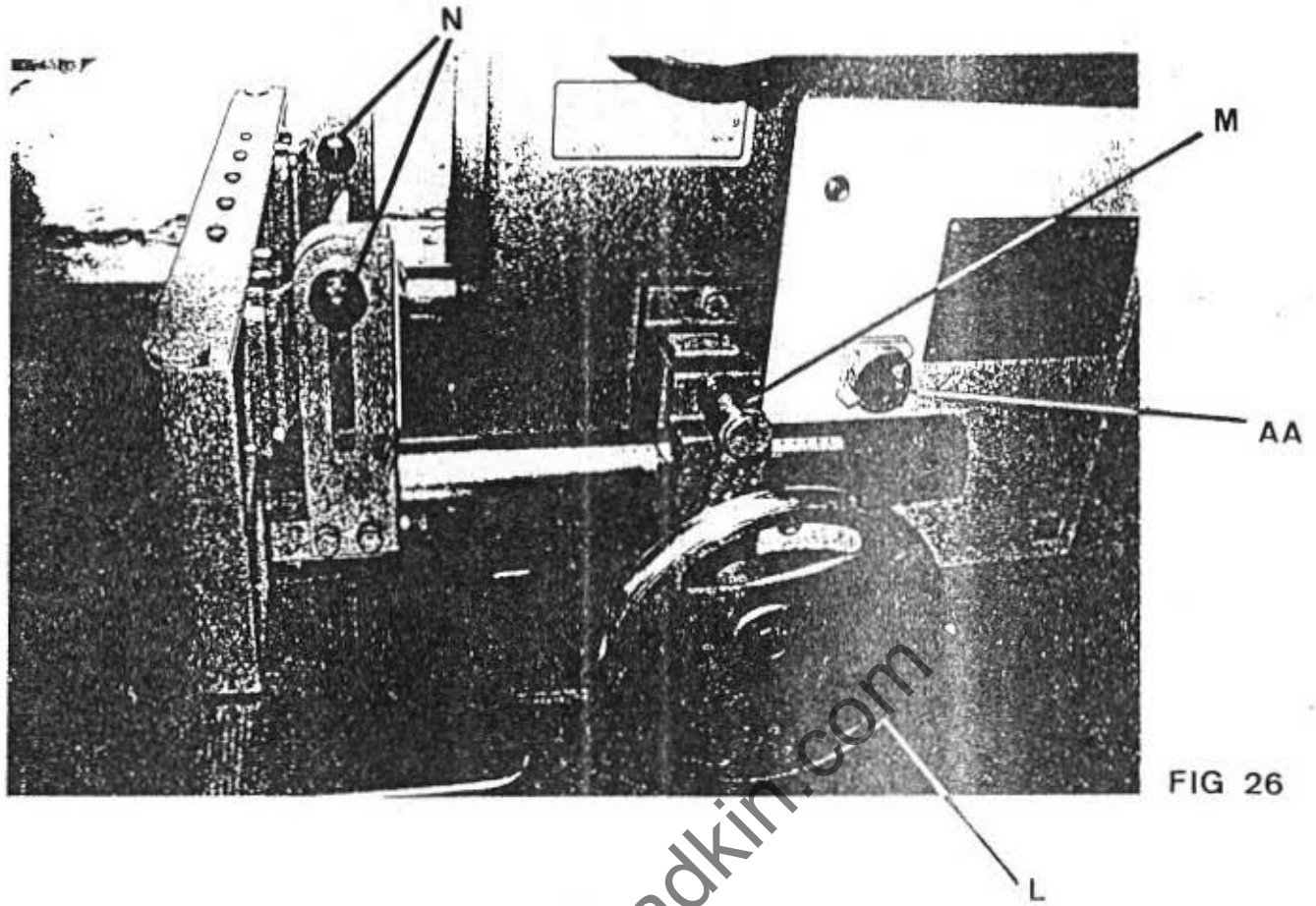
##### 5.1.6 CROSS TRAVERSE MOVEMENT OF FEED ROLLERS BY FOOT PEDAL

Feeder arm foot pedal ('P' *Fig.27*). controls the feeder lead which pivots the feed rollers away from the stock when feeding onto the blade.

##### 5.1.7 BRAKE PEDAL

Brake pedal ('Q' *Fig.27*). is depressed to stop the wheel.

NOTE: Always press main motor 'Stop Button' before depressing footbrake unless an electrically interlocked footbrake is fitted. The electrically interlocked footbrake pedal cuts power to the machine when the pedal is depressed.



#### 5.1.8 FEED UNIT

This unique feeder unit has many features:-

- 1) Variable drive unit (*Fig.28*). gives feed speeds ranging from 7 m/min to 40 m/min.

The speed is adjusted by handwheel ('R' *Fig.28*). A dial is fitted to indicate the feed speed.

DO NOT ADJUST FEEDER SPEED WHILST DRIVE UNIT IS STATIONARY.

On the International Model the feed speed is controlled automatically by means of a servo unit. (*Fig.34*). Controls 'S' & 'T'.

- 2) Feed rollers ('U' *Fig.30*). are mounted on a swinging arm ('V' *Fig.30*). to cater for up to 4 inches (100mm) variance in stock width.

Foot pedal ('P' *Fig.27*). is used to control the arm swing when feeding variable stock widths. Handwheel ('O' *Fig.27*). is used to position the feeder unit relative to the stock size being cut, taking into account the swing of the feeder arm.

This affords:-

- A) Fast and easy positioning of the fence.
- B) Random feeding of varying stock widths.
- C) Re-feeding wide stock when producing narrow boards.
- D) Feeding tapered stock and waney edge boards.

The feeder to fence capacity is 28 inches (715mm).

- 3) The feeder requires no lock to keep it in position.

**I M P O R T A N T:** ALWAYS CHECK THAT THE SWINGING ARM IS NOT IN THE WAY OF THE BLADE AFTER REPOSITIONING THE FEEDER.

- 4) An information plate is fitted as a guide to feed speeds relative to stock depth to be sawn. However, the feed speed selected should take into consideration the type of stock and condition of the blade.
- 5) Varying pressures of the swing arm unit can be accommodated by repositioning or removing the springs (*Fig.29*). Six springs are set on the lower setting. This should be sufficient for most timbers generally cut.



FIG 28

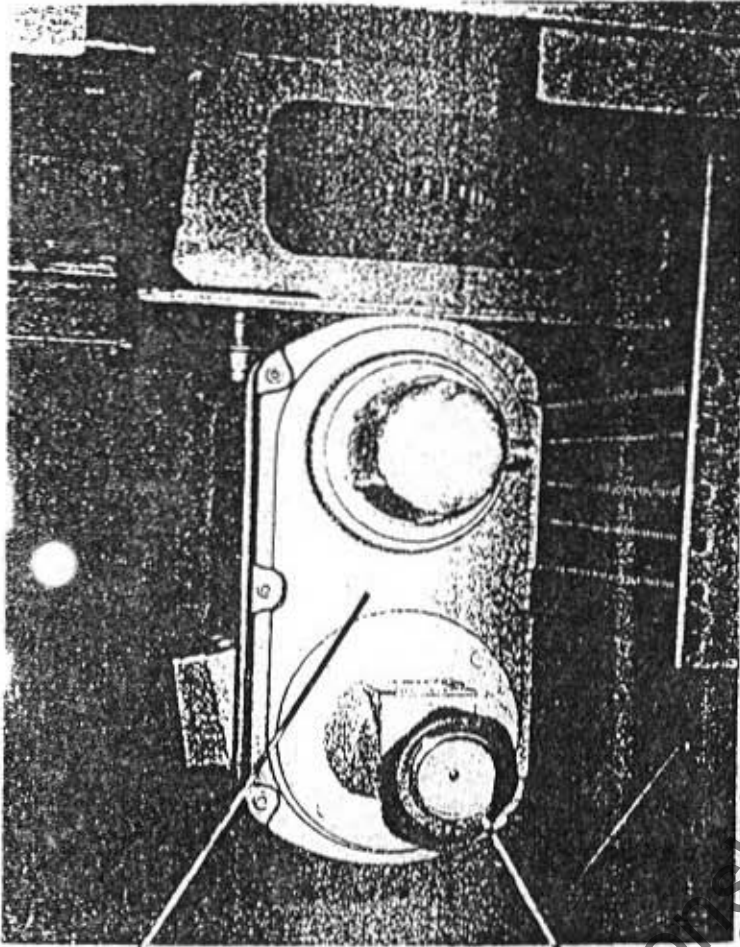


FIG 29

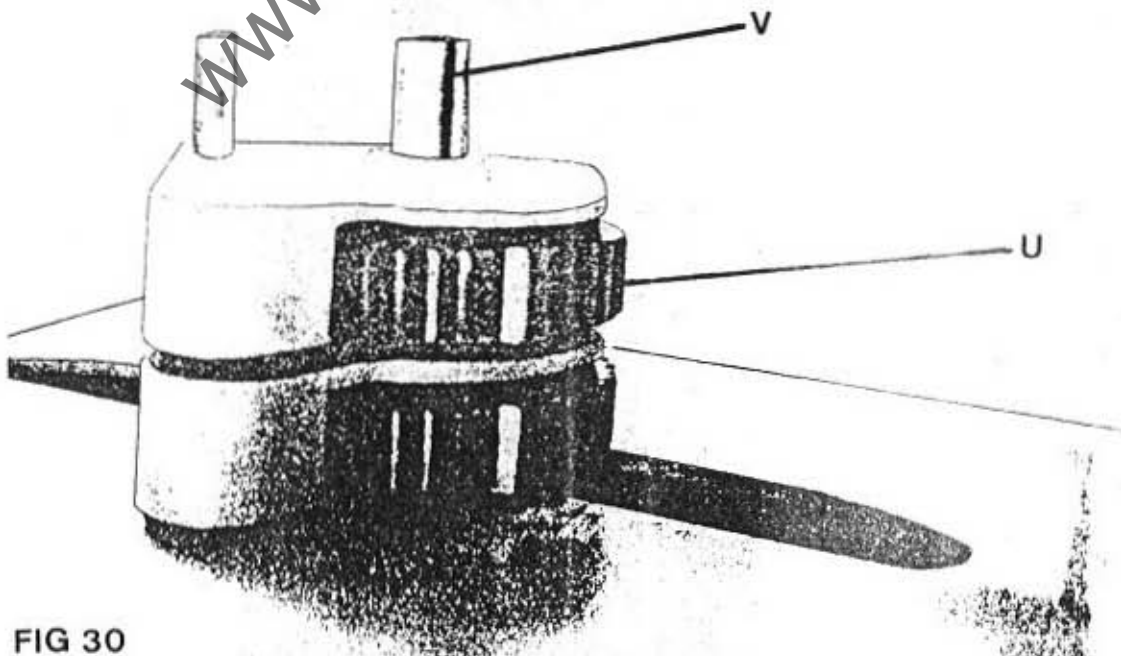
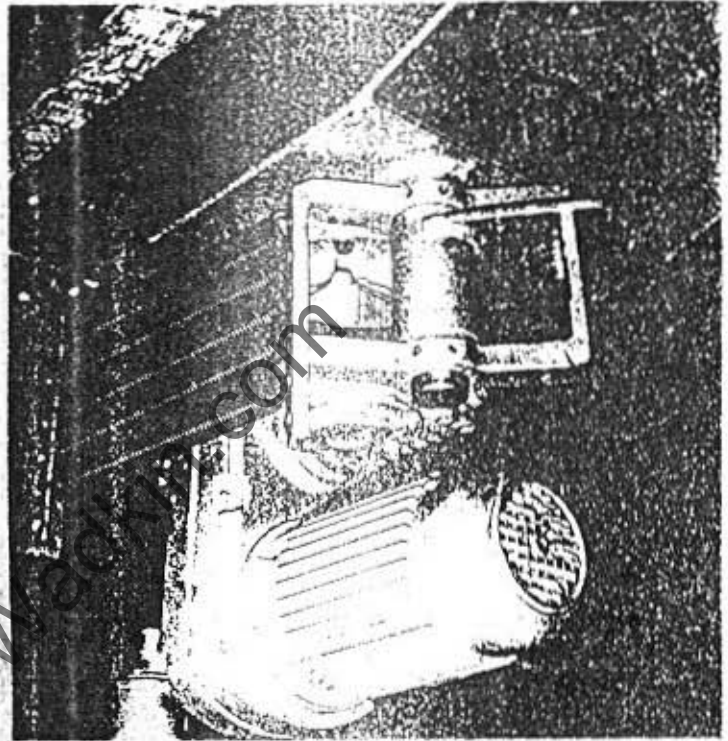


FIG 30

### 5.19 ROLLER BED CANTING FENCE

The unit has a blade to fence capacity of 310mm (12 1/2 inches). It is adjusted by handwheel ('L' Fig.26) then locked into position by lock ('M' Fig.26). The unit has a scale and adjustable pointer ('X' Fig.33) for setting the fence to desired stock level. The pointer can be reset by releasing the M8 grub screw ('Y' Fig.33) and adjusting the pointer to required position then lock up the screw.

The rollers run on oilite bushes and require no lubrication. The fence extension can be removed by unbolting two M12 hexagonal head bolts (Fig.31).

The canting fence is standard and will cant up to 45 degrees. To adjust, follow the following instructions:-

- A) Bring the fence away from the blade.
- B) Lock up the fence with the lock handle.
- C) Slacken the 2 M16 nuts ('N' Fig.26).
- D) Ease the fence to the required angle.
- E) Lock off the fence with the 2 M16 nuts.
- F) Wind the fence to the required position.
- G) Remove one of the feed rollers and guards (Fig.30).
- H) Set the remaining feed roller and guard to a suitable position to cut angle of stock (Fig.32).



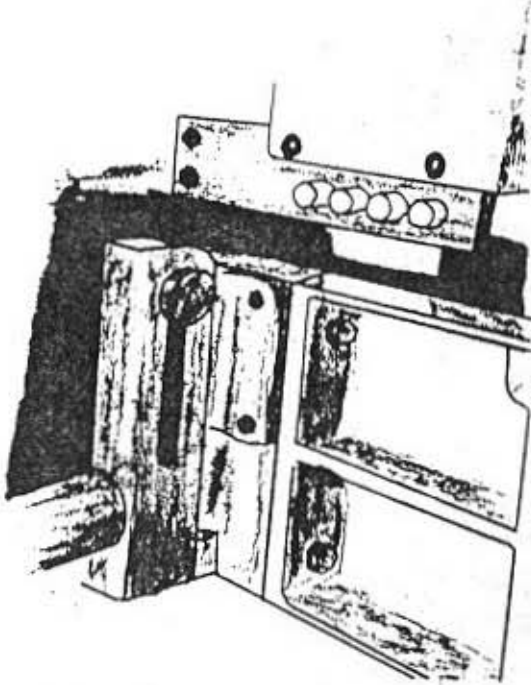


FIG 31

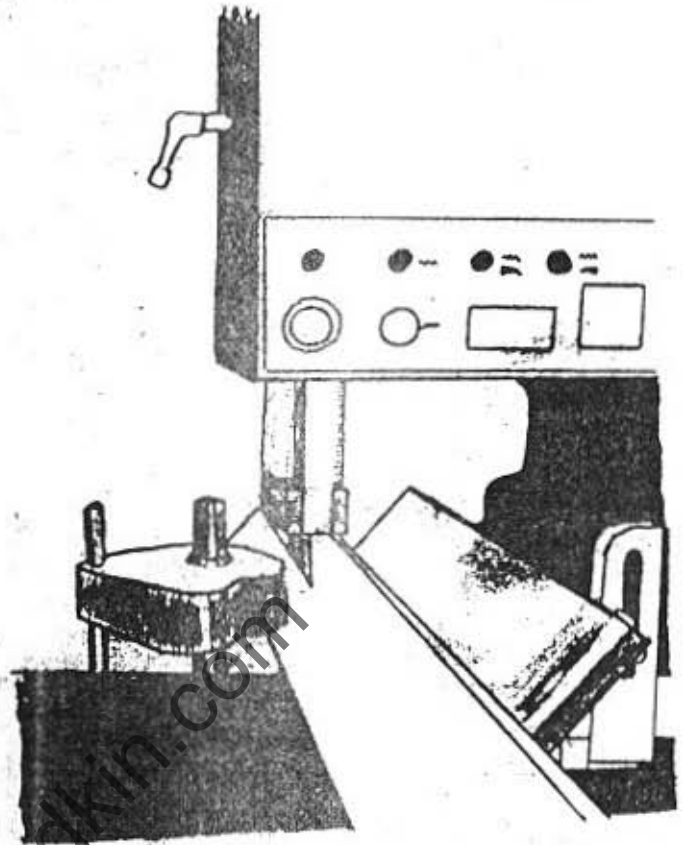


FIG 32

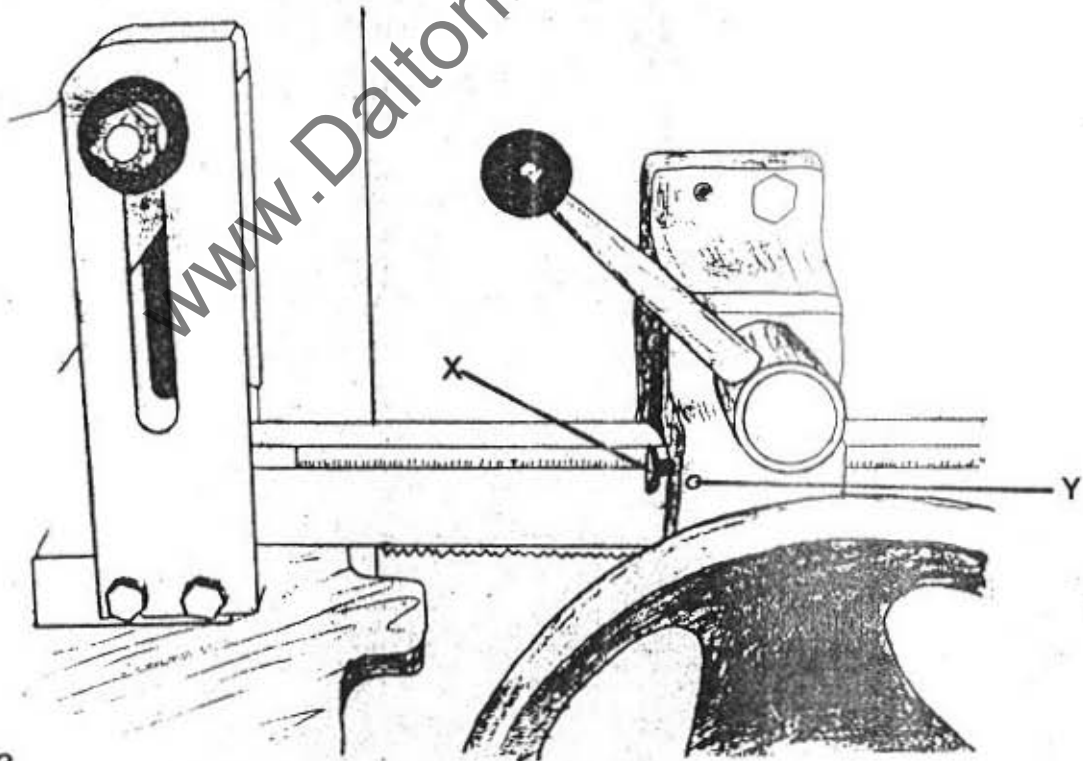


FIG 33

## ELECTRICAL CONTROLS

- 1) The isolator ('AA' Fig.26) . is shown in the 'ON' position. The isolator should be switched to the 'OFF' position before making any adjustment to the machine, carrying out any maintenance or whilst changing blades. The machine can not be started with the pump door open.  
~~OR~~ OR MAIN DOOR OPEN
- 2) The stop / start buttons ('BB' & 'CC' Fig.34). control the saw motor and will not function unless the isolator is switched on.
- 3) The stop / start buttons ('DD' & 'EE' Fig.34) . control the feed speed motor and will not operate unless the saw motor is running.  
NOTE: After the saw motor is switched on 10-15 seconds will elapse before the feed control will function, this allows time for the main motor to switch automatically from star to delta winding.
- 4) Should either motor trip out there are 3 reset buttons provided on the contactor. The starter box (Fig.26). has fuses provided and these should be checked on a regular basis. If the machine trips out frequently the cause should be investigated and the fuse ratings checked.
- 5) Control Panel master stop ('CC'.Fig.34). when pressed will stop all electrical functions. To reset pull out the red stop button.
- 6) Servo feed speed control (where fitted)  
Button 'S' (Fig.34). will increase the feed speed  
Button 'T' (Fig.34). will decrease the feed speed  
This does not operate until the feeder unit is engaged.
- 7) Digital feed rate readout (Fig 34.)(where fitted) displays either metric (M/Min) or imperial (Ft/Min) depending on which is specified.
- 8) Ammeter (Fig.34.where fitted) will give indication of current absorption by the blade. The feed speed should be decreased if the current exceeds 25-30 amps until a suitable level is once more achieved. In general, a reading of 40-50 amps indicates the re-saw blade requires changing.

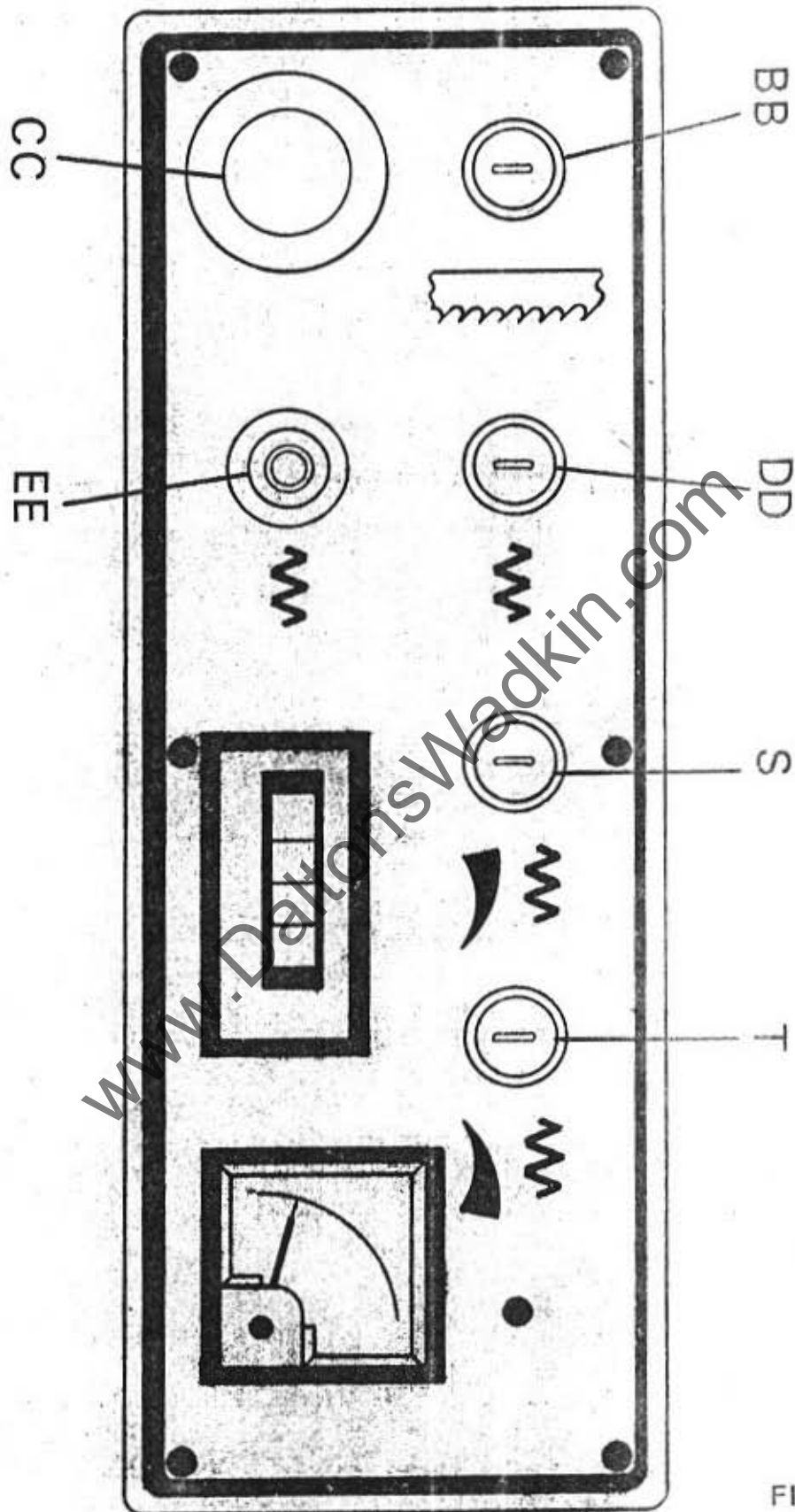


FIG 34