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GA

THROUGH FEED

PLANER / MOULDER

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ILLUSTRATED PARTS LIST No 2039

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Through Feed Four Side

Planing and Moulding Machine

Model GA

ILLUSTRATED PARTS LIST

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Wadkin Limited
Green Lane Road, Leicester
LE5 4PF

Telephone 0044(0)116 2769111
Fax 0044(0)116 2742310

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ILLUSTRATED PARTS LIST

1	Short 0nfeed table
2	Straightening infeed table
3	Bottom head vertical adjustment
4	Second bottom head outboard bearing
5	Bottom and top head horizontal adjustment
6	Top head vertical adjustment
7	Top head outboard bearing
8	Top head flapper type chipbreaker
9	Top head receding chipbreaker
10	Pneumatic chipbreaker top head
11	Manual lock for top head outboard bearing
12	Manual lock for top head outboard bearing (with side guide)
13	Top head pad pressure
14	Fence and near side head adjustment
15	Near side head chipbreaker and side presure
16	Main drive and gearboxes
17	Gearbox couplings
18	Drive from gearboxes to feed rolls
19	Drive shafts for beam rise and fall
20	Drive to bottom feed rolls
21	Beam rise and fall gearbox
22	Top roller pressure unit
23	Top pressure mounting
24	Single side roller pressure
25	Outfeed bed roll
26	Flange mounted feed roll
27	Shaft mounted feed roll
28	Standard vertical spindle
29	Standard horizontal spindle
30	High precision horizontal spindle

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31 Universal head adjusting mechanism
32 Unit 'G' splitting head – spindle (V belt drive)
33 Unit 'G' splitting head – spindle (timing belt drive)
34 Unit 'G' splitting head – outboard bearing
35 Unit 'G' splitting head – vertical adjustment
36 Unit 'G' splitting head – horizontal adjustment
37 Unit 'G' splitting head – top pad pressure and riving knives
38 Unit 'G' splitting head – anti-kick back fingers
39 Unit 'G' splitting head – chain tensioner to horizontal spindle
40 Intermediate feed roll
41 Push feed system
42 Infeed nip driven roller system
43 XE E-unit (outboard bearing top head)
XE E-unit (top head pad pressure)
XE E-unit (top head chipbreaker)
XE E-unit (outboard bearing second bottom head)
XE E-unit (second bottom head jointer)
XE E-unit (top head jointer)

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1. SHORT INFEED TABLE

Ref No.	Description	No Off.
1	Vertical slide	1
2	Pointer	1
3	Bearing block	1
4	Rise and fall screw	1
5	Clamping pad	1
6	Rise and fall nut	1
7	Slide strip	1
8	Short infeed frame	1
9	Ratchet spanner	1
10	Bristol handle M10	1
11	Grease nipple	2
12	Collar	1
13	Taper pin	1
14	'INA' thrust washer ref. AS 1730	3
15	'INA' thrust bearing ref. AXK 1730	2
16	'INA' shaft washer ref. WA 81103	1
17	Bronze brush 20mm O/D x 16mm I/D x 25mm long	1
18	Hexagon setscrew M10 x 60mm long	2
19	Hexagon socket capscrew M10 x 25mm long	2
20	Hexagon socket capscrew M10 x 55mm long	4
21	Scale (imperial or metric)	1

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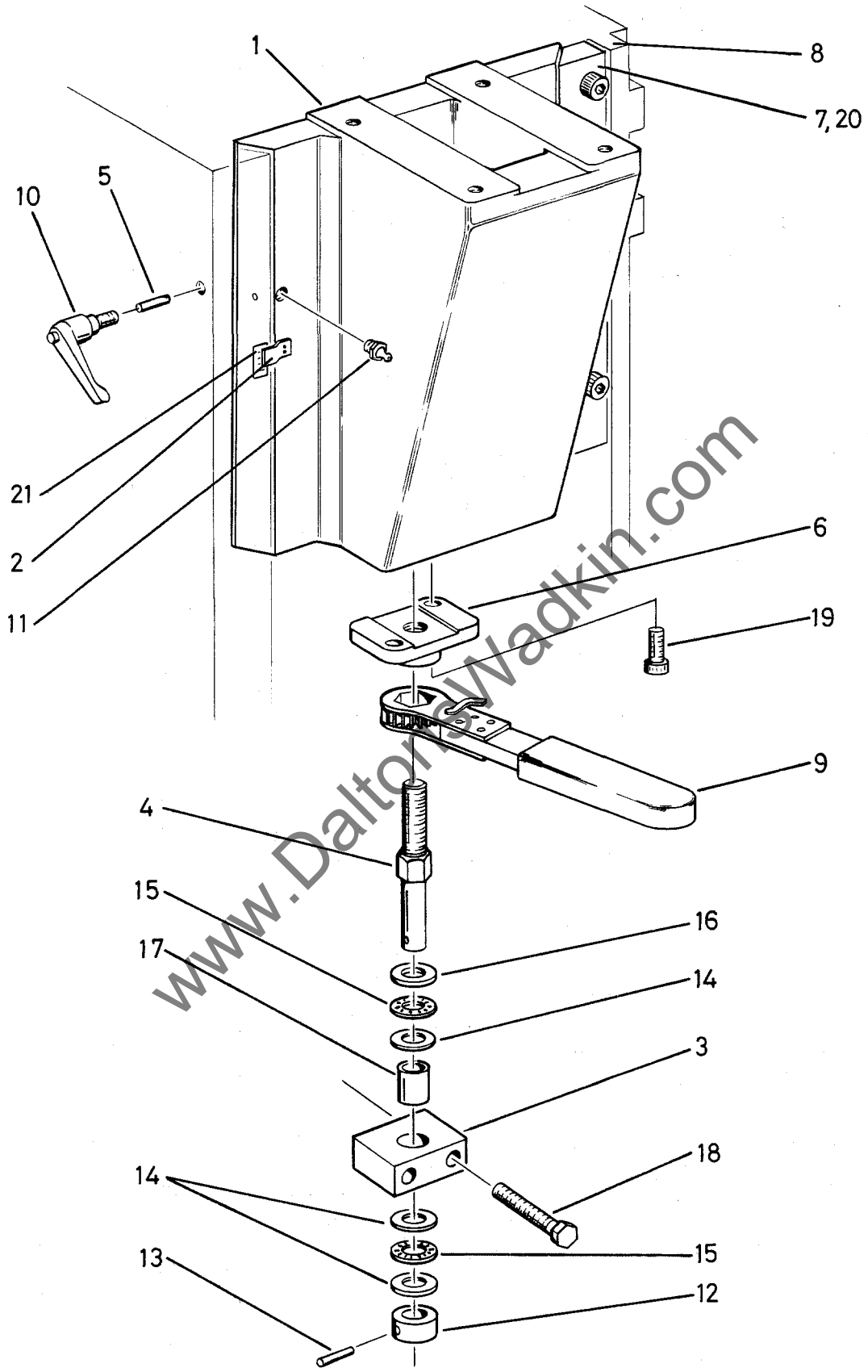


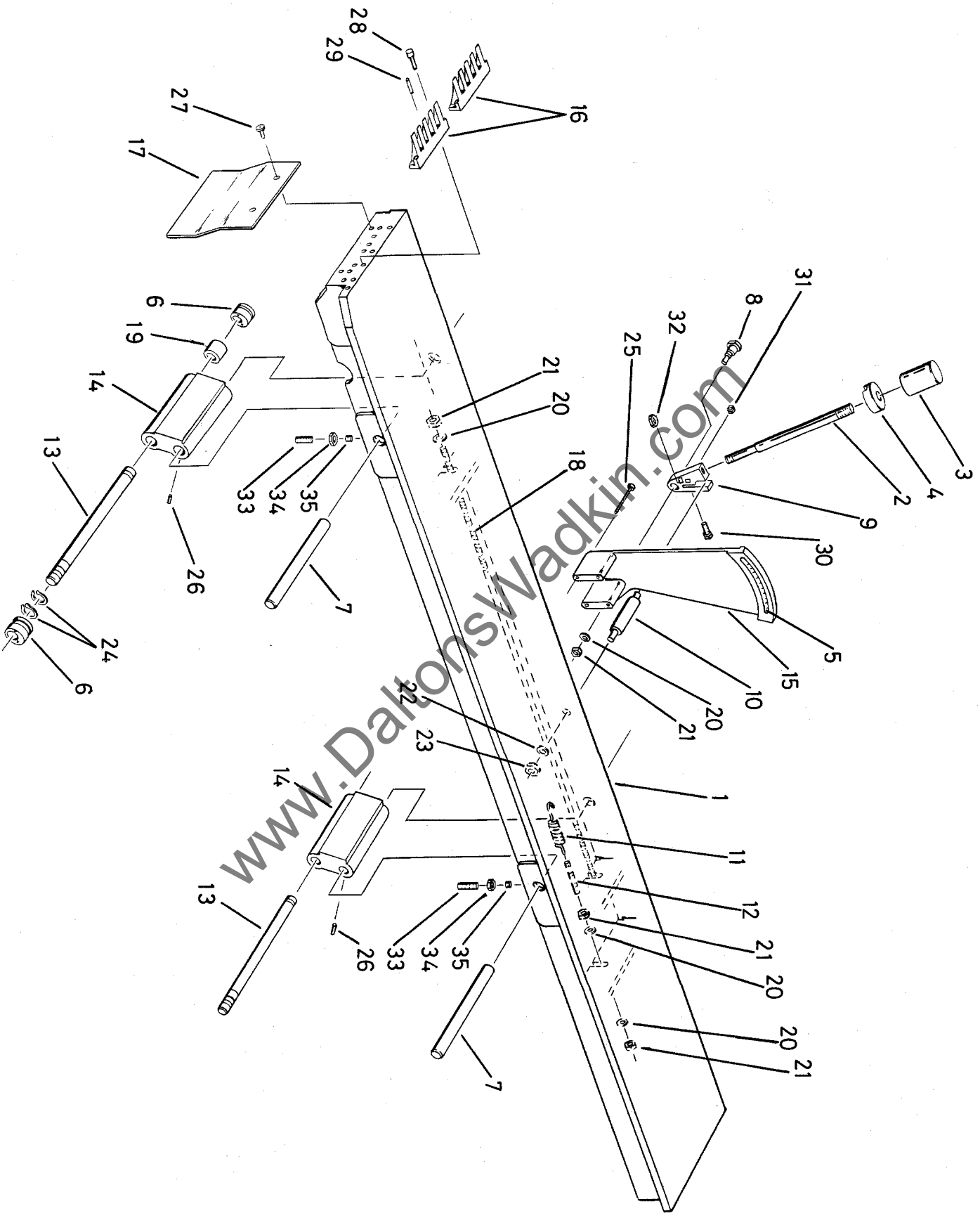
FIG 1 SHORT INFEED TABLE

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2 STRAIGHTENING INFEED TABLE

Ref No.	Description	No Off.
1	Infeed table	1
2	Lever for table height adjustment	1
3	Locking handle	1
4	Locking ring	1
5	Adjustment scale	1
6	Eccentric brush	2
7	Pivot pin for table	2
8	Pivot pin for adjusting lever	1
9	Lever block	1
10	Positioning stud for table	1
11	Spring	1
12	Spring tension stud	1
13	Lower pivot pin for table	2
14	Pivot link for table	1
15	Mounting bracket for adjusting lever	1
16	Nose for table	2
17	Chip deflector	1
18	Straightening rod	2
19	Spacer	1
20	Plain washer M12	7
21	Hexagon nut M12	7
22	Plain washer M16	1
23	Hexagon nut M16	1
24	External circlip WR25	2
25	Hexagon socket capscrew M8 x 70mm long	4
26	Hexagon socket grub screw M6 x 12mm long	4
27	Hexagon socket countersunk M6 x 10mm long	2
28	Hexagon socket capscrew M6 x 25mm long	8
29	Tension pin 4mm dia.	4
30	Hexagon socket capscrew M8 x 30mm long	1
31	Hexagon nut M8	1
32	Hexagon nut M10	1
33	Hexagon socket grubscrew M8 x 20mm long	4
34	Hexagon locknut M8	4
35	Nylon insert	4

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FIG 2 STRAIGHTENING INFEED TABLE

3. BOTTOM HEAD VERTICAL ADJUSTMENT

Ref No.	Description	No Off.
1	Bevel box for bottom head adjustment	1
2	Bracket for cross shaft bearing	1
	Cross shaft for bottom head rise and fall	1
4	Square end shaft extension	1
5	End cap for rise and fall bevel box	1
6	Screw for bottom head rise and fall	1
7	Bevel gear for rise and fall	1
8	Bevel gear for rise and fall	1
9	Cover for bevel box	1
10	Sealing ring	1
11	Key 8mm x 7mm x 20mm	1
12	'INA' shaft washer ref WA 81105	2
13	'INA' thrust washer ref AS 2542	2
14	'INA' thrust bearing ref AXK 2542	2
15	Plain washer M16	1
16	Hexagon lock nut M16	2
17	Taper pin	1
18	Siko position indicator 0902 I 2mm	1
19	Key 5mm x 5mm x 20mm	1
20	Collar dia. 20mm bore	1
21	Hexagon socket grubscrew M6 x 6mm long	1
22	'INA' thrust washer ref AS 2035	4
23	'INA' thrust bearing ref AXK 2035	2
24	External circlip dia. 16mm	1
25	Hexagon socket capscrew M4 x 10mm long	3
26	Hexagon socket capscrew M6 x 20mm long	3
27	Bush 25mm O/D x 20mm I/D x 25mm long	1
28	Bush 30mm O/D x 25mm I/D x 25mm long	1
29	Bush 25mm O/D x 20mm I/D x 15mm long	2
30	Hexagon socket capscrew M6 x 75mm long	4

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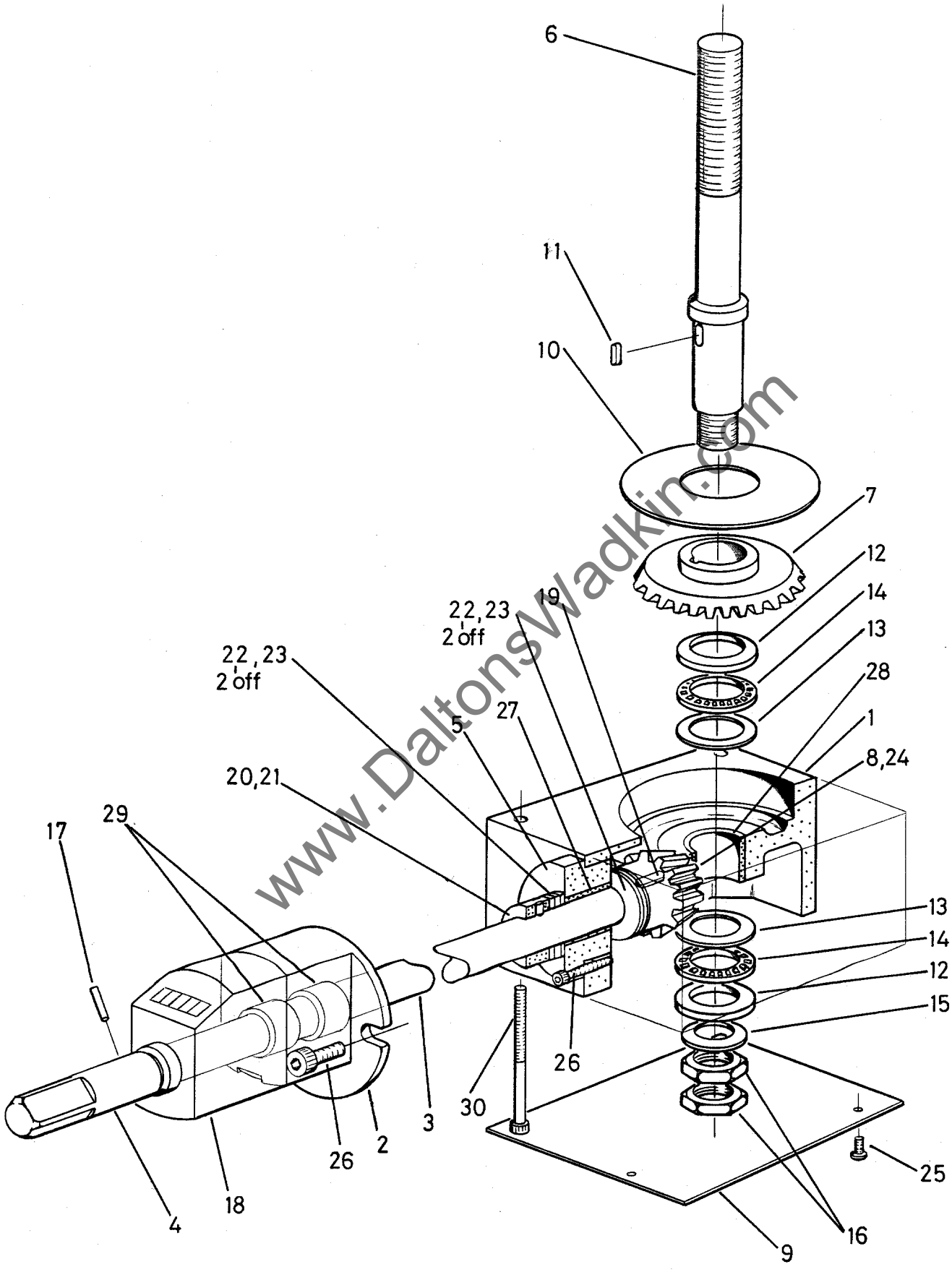


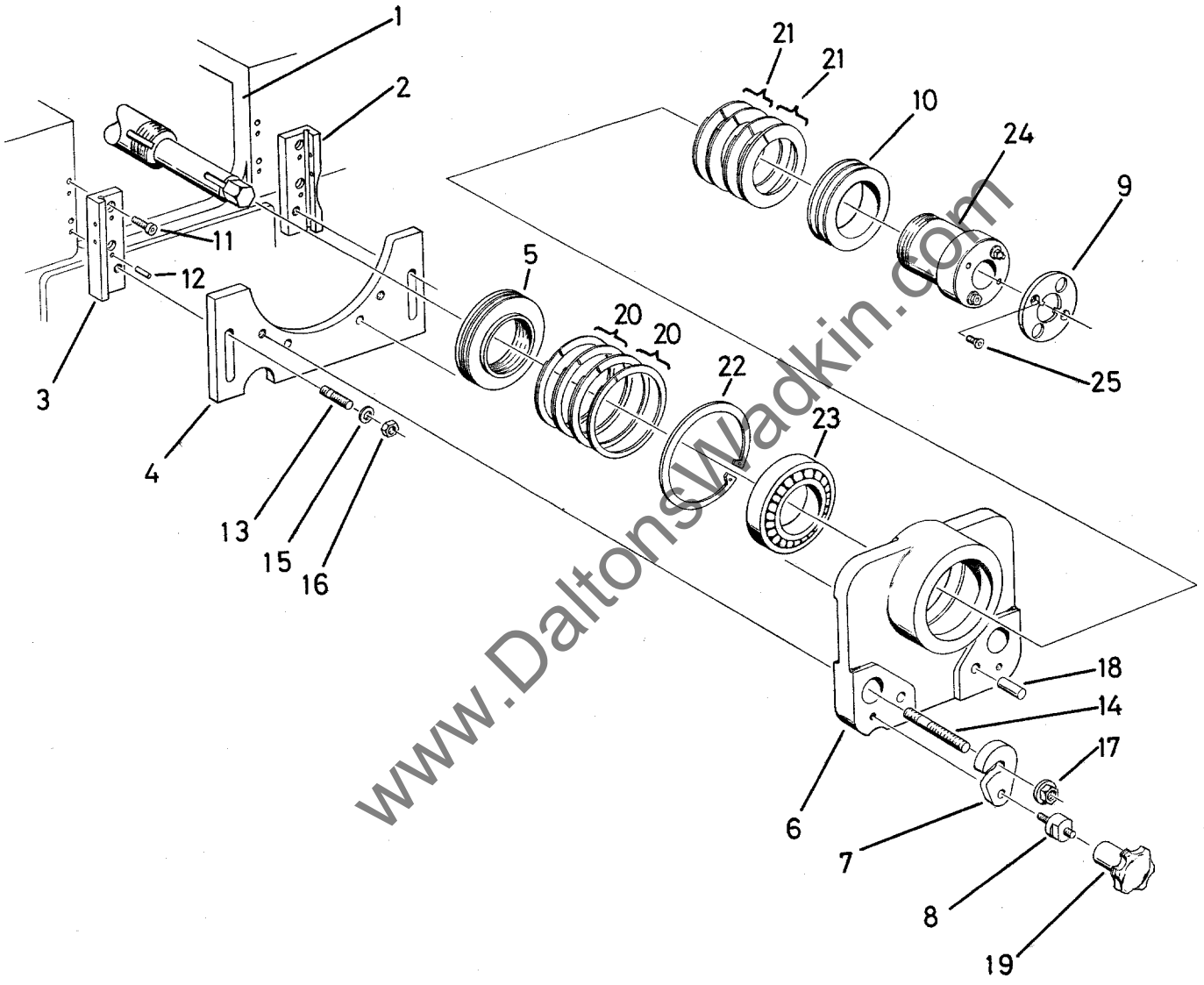
FIG 3 BOTTOM HEAD VERTICAL ADJUSTMENT

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4 2ND BOTTOM HEAD OUTBOARD BEARING

Ref No.	Description	No Off.
1	Main frame	-
2	Slide block	1
3	Slide block	1
4	Mounting plate for outboard	1
5	Locknut	1
6	Housing for outboard bearing	1
7	'C' washer	2
8	Shoulder screw	2
9	End plate	1
10	Sealing bush	1
11	Hexagon socket capscrew M8 x 16mm long	4
12	Tension pin 6mm dia. x 24mm long	4
13	Stud M12 x 45mm long	2
14	Stud M12 x 80mm long	2
15	Plain washer M12	2
16	Nut M12	2
17	Collar nut M12	2
18	Dowel	2
19	Handwheel	2
20	Laminar sealing ring (two rings per set)	2
21	Laminar sealing ring (two rings per set)	2
22	Internal circlip 100mm dia.	1
23	'RHP' Bearing ref. 6211-TB-EP7	1
24	'ETP' sleeve	1
25	Hexagon socket countersunk screw M5 x 12mm long	2
26	Cover	1
27	Magnetic catch	1
28	Hexagon head setscrew M6 x 12mm long	2
29	Plain washer M6	2

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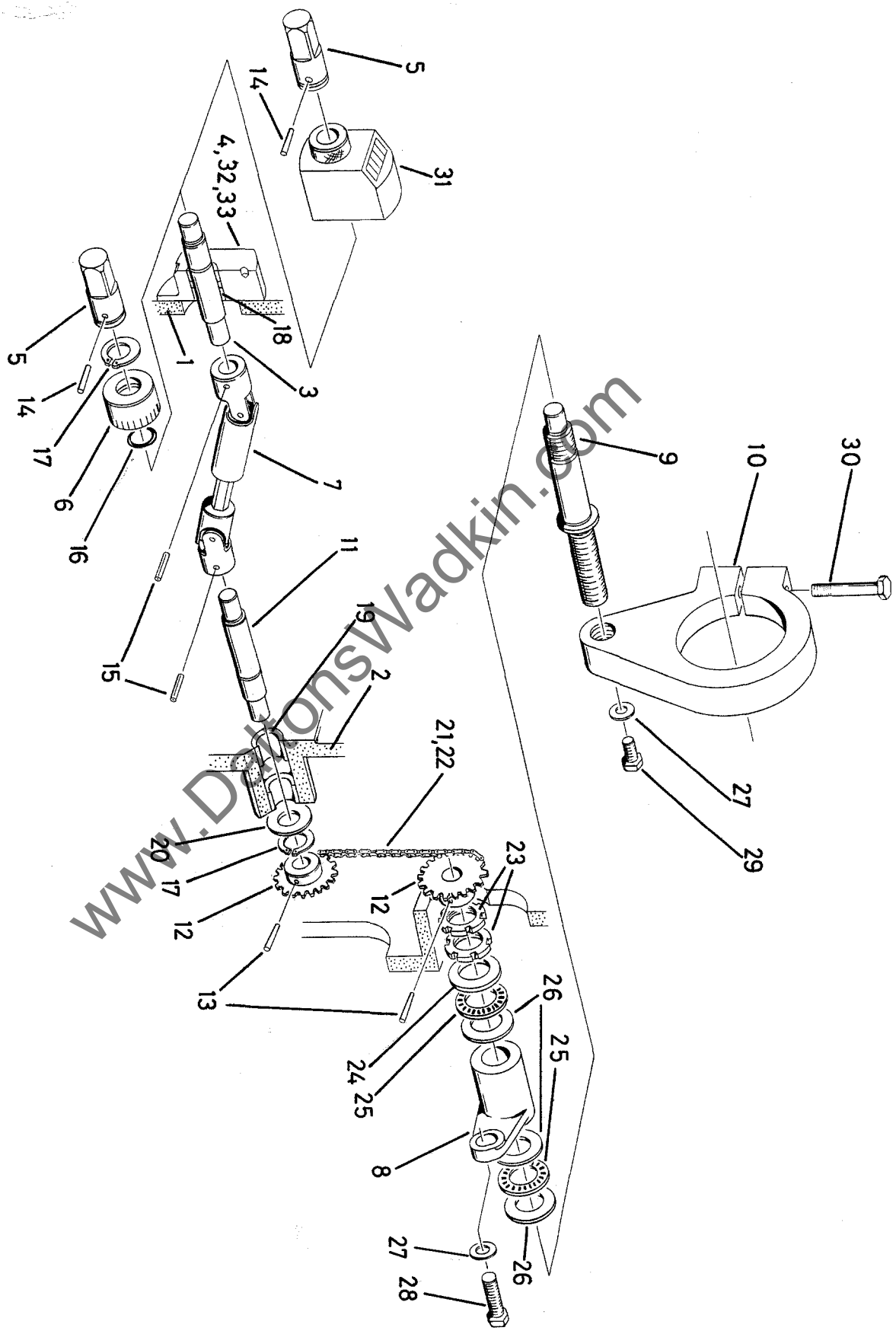
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FIG 4 2ND BOTTOM HEAD OUTBOARD BEARING

5. BOTTOM AND TOP HEAD HORIZONTAL ADJUSTMENT

Ref No.	Description	No Off.
1	Main frame	-
2	Head slide	-
3	Indicator shaft	1
4	Housing for shaft bearing	1
5	Square end shaft extension	1
6	Calibrated dial	1
7	Universal drive shaft	1
8	Bearing bracket	1
9	Horizontal adjustment screw	1
10	Horizontal adjustment nut	1
11	Horizontal adjustment shaft	1
12	Sprocket	2
13	Taper pin No. 4	2
14	Taper pin No. 1	1
15	Tension pin 6mm dia. x 32mm long	2
16	'GACO' 'O' ring ref. RM 0196-24	1
17	External circlip 20mm dia.	2
18	Bronze bush 25mm O/D x 20mm I/D x15mm long	2
19	Bronze bush 25mm O/D x 20mmI/D x 25mm long	2
20	Plain washer M20	1
21	'Renold' chain ref. No.111046	1
22	Chain connecting link	1
23	Chamfered notch nut M24 x 1.5	2
24	'INA' shaft washer ref. WS2542	1
25	'INA' thrust bearing ref. AXK 2542	2
26	'INA' thrust washer ref. AS 2542	3
27	Plain washer M10	3
28	Hexagon head setscrew M10 x 30mm long	2
29	Hexagon head setscrew M10 x 15mm long	1
30	Hexagon head setscrew M10 x 70mm long	1
31	Digital indicator	1
32	Hexagon socket capscrew M8 x 20mm long	2
33	Plain washer M8	2

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FIG 5 BOTTOM AND TOP HEAD HORIZONTAL ADJUSTMENT

6. TOP HEAD VERTICAL ADJUSTMENT

Ref No.	Description	No Off.
1	Socket head capscrew M12 x 30mm long	4
2	Plain washer M16	1
3	Slide strip	1
4	Top head vertical slide	1
5	Vertical rise and fall screw	1
6	Nut for rise and fall screw	1
7	Hexagon head setscrew M8 x 25mm long	2
8	Top cover	1
9	Hexagon socket capscrew M6 x 8mm long	4
10	Bevel gear	1
11	Worm gear	1
12	Bearing 'SKF' 6204 RS	2
13	Dog clutch	1
14	External circlip 16mm dia.	2
15	Bronze bush 20mm O/D x 16mm I/D x 16mm long	2
16	Tension pin 6mm dia. x 32mm long	1
17	Gearbox/clutch housing	1
18	Clutch spacer washer	2
19	External circlip 30mm dia.	2
20	Thrust washer 'INA' ref AS 2542	2
21	Thrust bearing 'INA' ref AXK 2542	2
22	Shaft washer 'INA' ref WS 2542	2
23	Locknut M16	2
24	Bronze bush 30mm O/D x 25mm I/D x 20mm long	1
25	Hexagon socket grubscrew M6 x 10mm long	1
26	Clutch location arm	1
27	Clutch adjusting shaft	1
28	Spring for spindle lock	1
29	Steel ball 10mm dia.	1
30	Locking handle M10 x 25mm male	1
31	Parallel key 8mm x 7mm x 14mm long	1
32	Bronze bush 35mm O/D x 30mm I/D x 20mm long	1
33	Bevel gear	1
34	Parallel key 5mm x 5mm x 20mm long	1
35	Main frame	1
36	Bearing bracket	1
37	Bronze bush 25mm O/D x 20mm I/D x 15mm long	2
38	'Siko' digital readout 0902E 2mm	1
39	Hexagon socket capscrew M6 x 20mm long	2
40	Plain washer M6	2
41	Square end shaft extension	1
42	Taper pin no. 1	1
43	Compression spring	1
44	External circlip 25mm dia.	1

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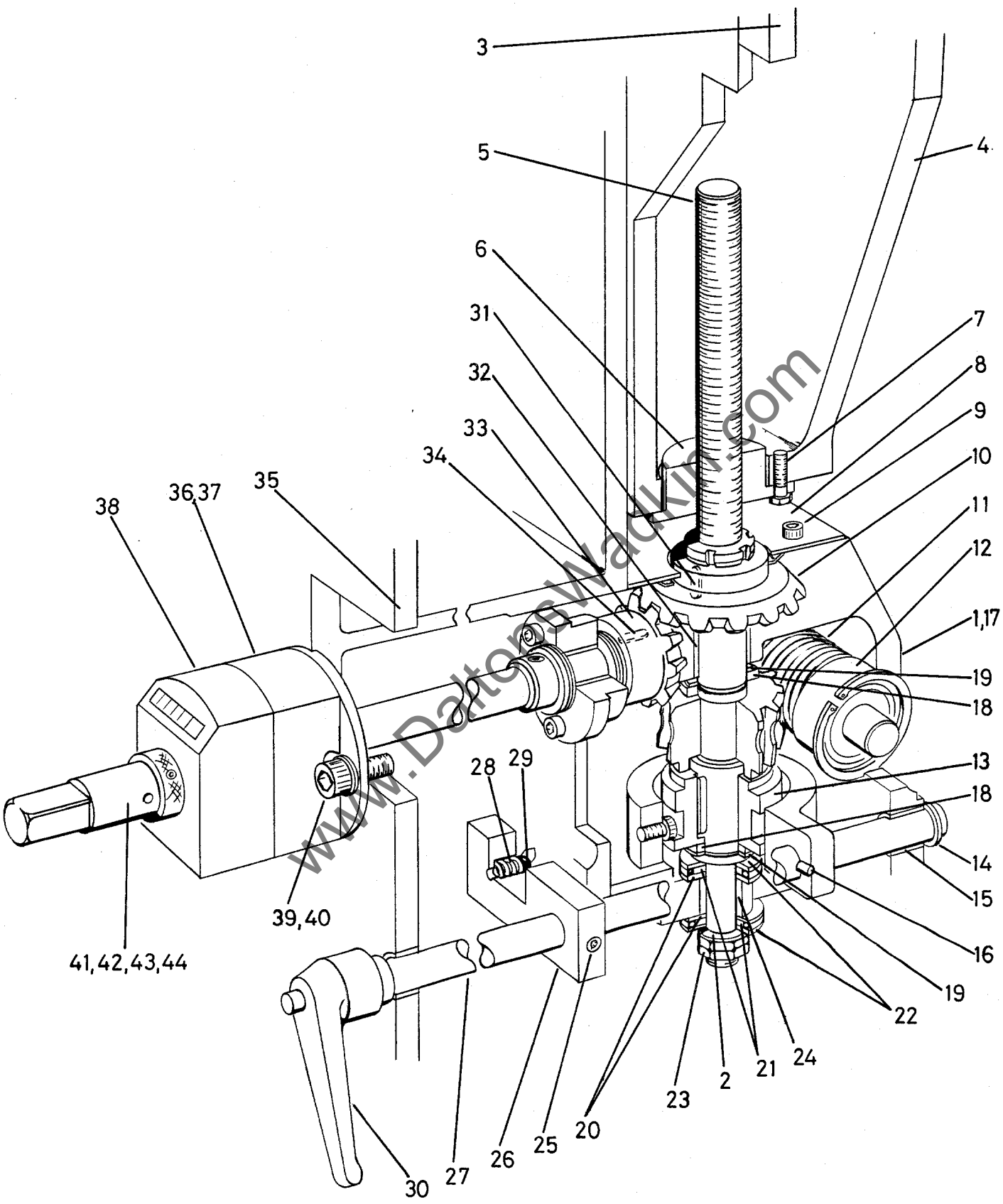


FIG 6 TOP HEAD VERTICAL ADJUSTMENT

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6. TOP HEAD VERTICAL ADJUSTMENT (cont)

Ref No.	Description	No Off.
45	Notch nut M24 x 1.5p	1
46	Clutch yoke	1
47	Adjusting shaft	1
48	Hexagon socket capscrew M6 x 10mm long	2
49	Bottom cover	1
50	Parallel key 8mm x 7mm x 32mm long	1
51	Worm wheel	1
52	Bronze bush 25mm O/D x 20mm I/D x 25mm long	1
53	Thrust bearing 'INA' ref AXK 2035	2
54	Thrust washer 'INA' ref AS 2035	4
55	End cap	1
56	Hexagon socket capscrew M6 x 20mm long	3
57	Internal circlip 47mm dia.	2
58	Collar 32mm O/D x 20mm I/D x 14mm	1
59	Hexagon socket grub screw M6 x 6mm long	1
60	Hexagon socket capscrew M8 x 16mm long	4
61	Disc spring washer	1
62	Wormbox cover	1

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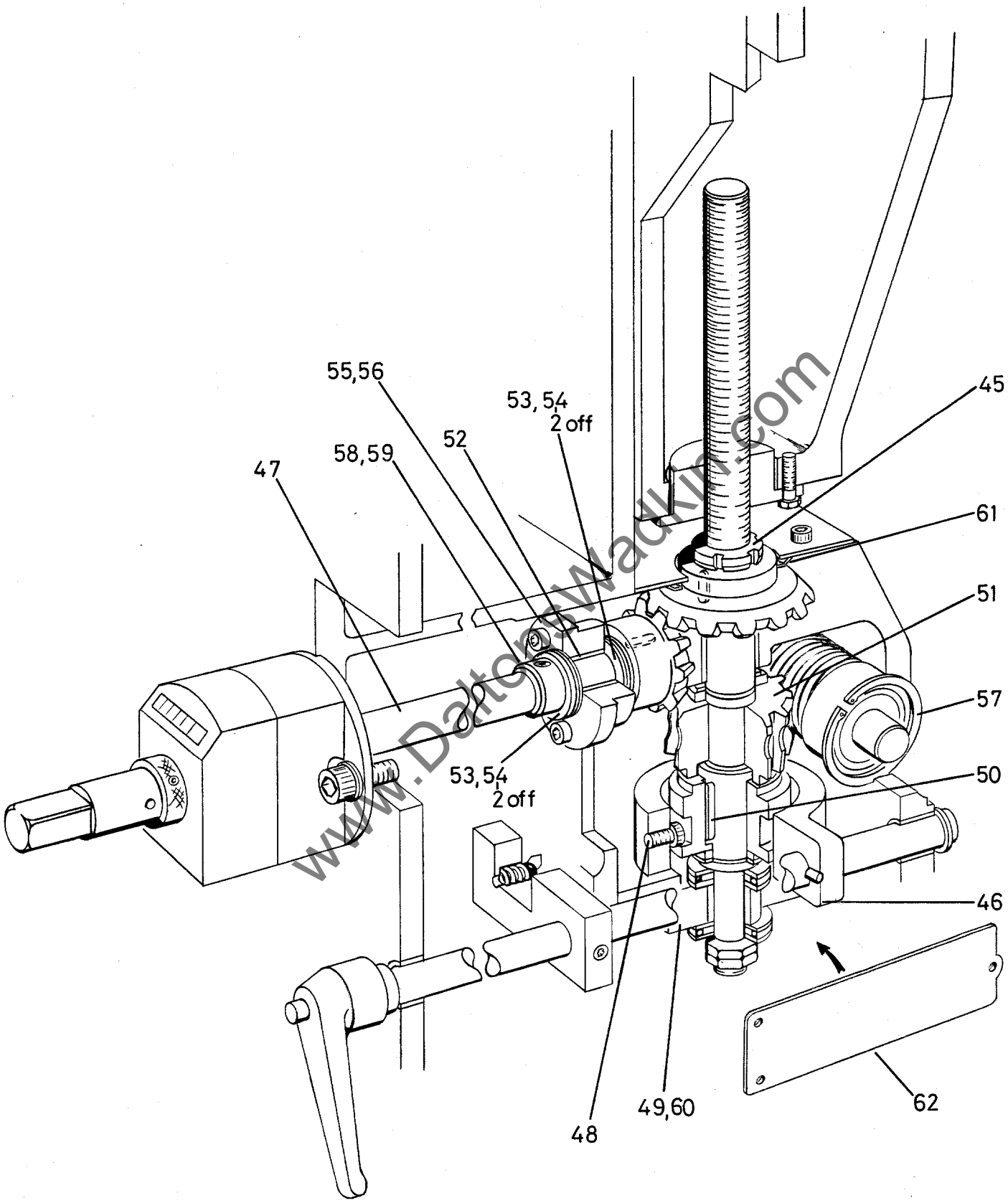


FIG 6 TOP HEAD VERTICAL ADJUSTMENT

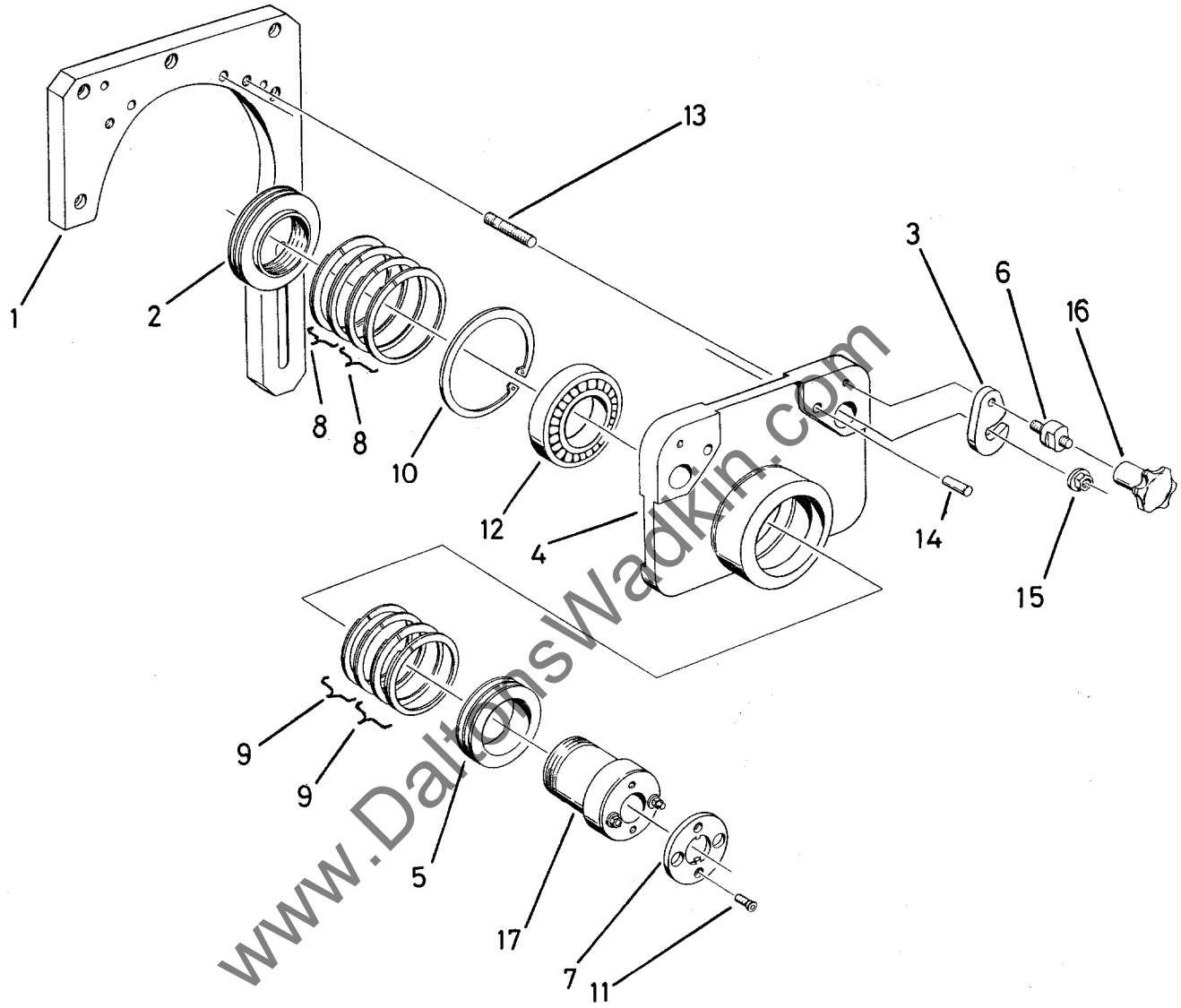
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7. TOP HEAD OUTBOARD BEARING

Ref No.	Description	No Off.
1	Support bracket for outboard (manual lock)	
or	support bracket for outboard (hydro lock)	1
2	Locknut	1
3	'C' washer	2
4	Housing for outboard bearing	1
5	Sealing bush	1
6	Shoulder screw	2
7	End plate	1
8	Laminar sealing ring	2
9	Laminar sealing ring	2
10	Internal circlip 100mm dia.	1
11	Hexagon socket countersunk screw M5 x 12mm long	2
12	'RHP' bearing ref. 6211-TB-EP7	1
13	Stud M12 x 80mm long	2
14	Taper Dowel 12mm dia. x 60mm long	2
15	Collar nut M12	2
16	Handhweel	2
17	ETP sleeve	1
18 *	Cover for outboard	1
19 *	Magnetic catch	1
20 *	Plain washer M6	2
21 *	Hexagon head setscrew M6 x 12mm long	2

* Not illustrated

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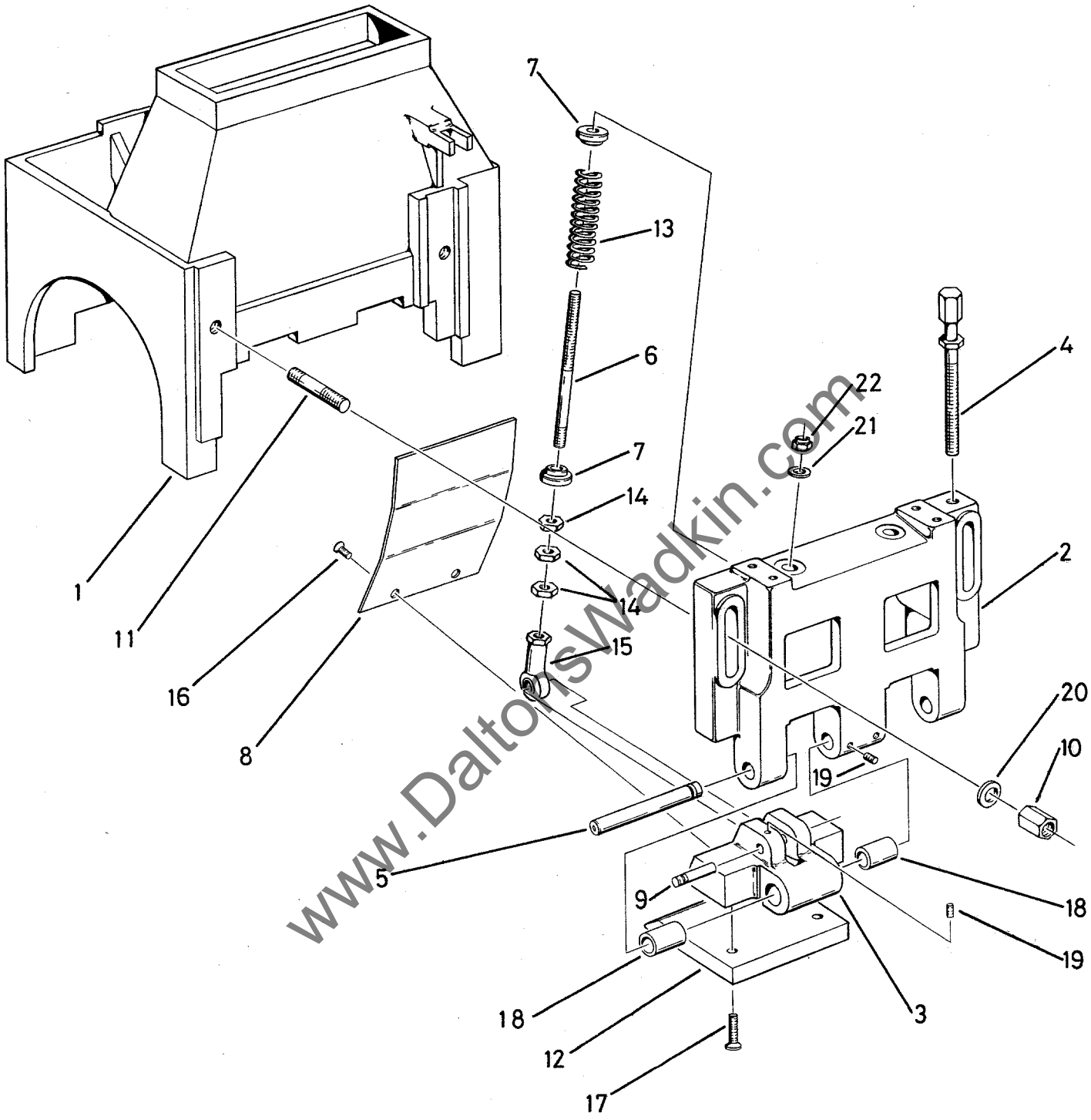
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FIG 7 TOP HEAD OUTBOARD BEARING

8. TOP HEAD FLAPPER TYPE CHIPBREAKER

Ref No.		Description	No Off.
1		Top head hood	1
2		Chipbreaker mounting	1
3		Chipbreaker	2
4		Rise and fall adjustment screw	1
5		Pivot pin for chipbreaker	2
6		Stud for spring pressure	2
7		Cap for spring	4
8		Chip deflector	2
9		Pivot pin for eye joint	2
10		Locking nut	2
11		Stud for chipbreaker mounting lock	2
12		Chipbreaker shoe 70mm long	2
	or	Chipbreaker shoe 90mm long	2
	or	Chipbreaker shoe 115mm long	2
13		Compression spring	2
14		Locknut M10	6
15		'Festo' M10 eye joint ref. SGS-M10	2
16		Hexagon socket countersunk screw M6 x 10mm long	4
17		Hexagon socket countersunk screw M8 x 25mm long	4
18		Bronze bush 20mm O/D x 16mm I/D x 25mm long	4
19		Hexagon socket grubscrew M6 x 8mm long	4
20		Plain washer M12	2
21		Plain washer M10	2
22		Self locking nut M10	2

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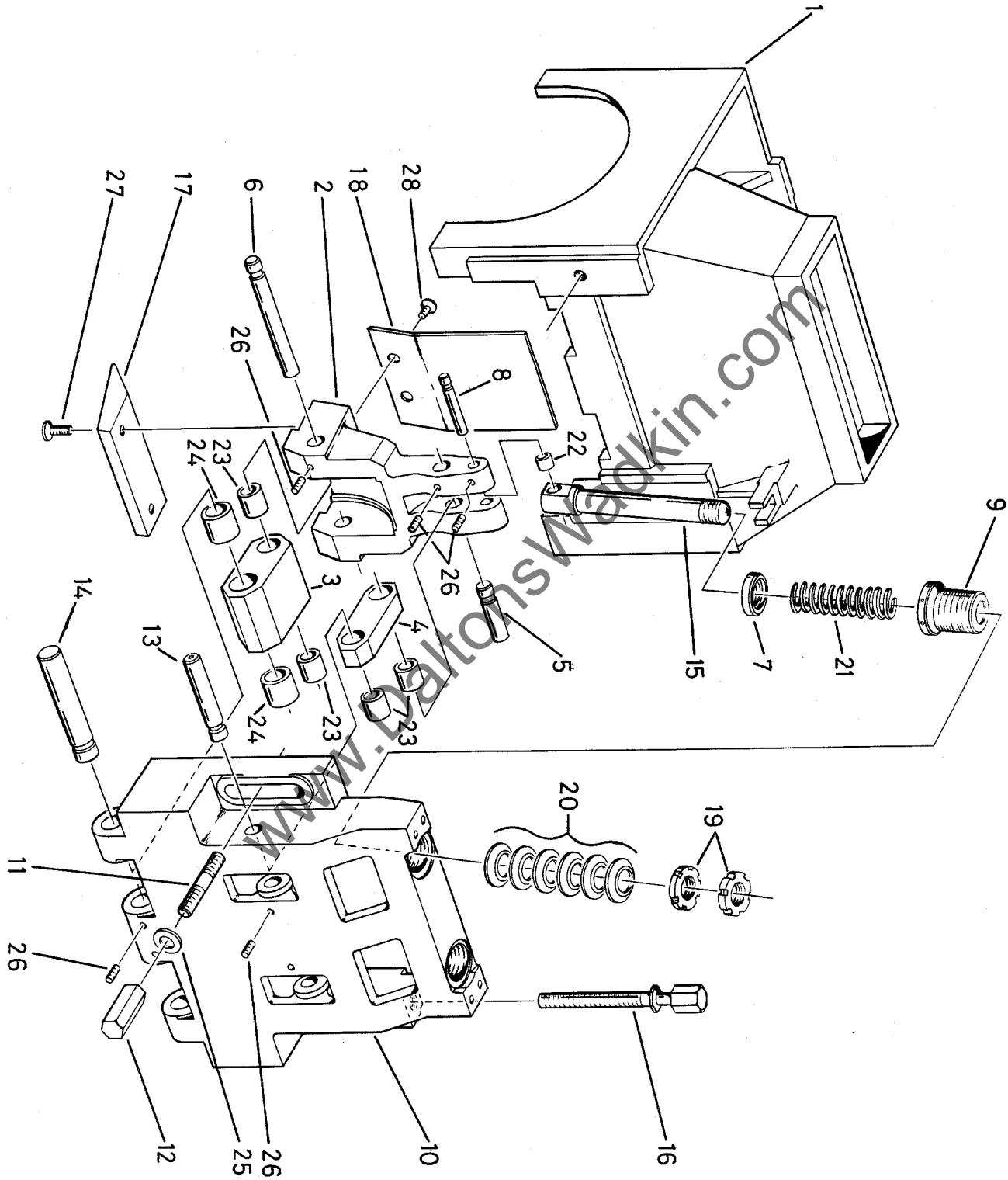
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FIG 8 TOP HEAD FLAPPER TYPE CHIPBREAKER

9 TOP HEAD RECEDING CHIPBREAKER

Ref No.	Description	No Off.
1	Top head hood	1
2	Radial chipbreaker	2
3	Bottom pivot link	2
4	Top pivot link	2
5	Top bearing pin	2
6	Bottom bearing pin	2
7	Spring cap	2
8	Pin for eye joint	2
9	Spring pressure for adjusting nut	2
10	Radial chipbreaker mounting	1
11	Stud for rise and fall lock	2
12	Locking nut	2
13	Short pivot bar	2
14	Long pivot bar	2
15	Stud for spring pressure	2
16	Rise and fall screw	1
17	Shoe for chipbreaker - 65mm long	2
or	Shoe for chipbreaker - 90mm long	2
or	Shoe for chipbreaker - 110mm long	2
18	Chip deflector	2
19	Chamfered notch nut M20	2
20	Disc spring 36.6mm O/D x 20.4mm I/D x 0.5mm thick	12
21	Compression spring 27.94mm O/D, wire dia. 2.15mm, free length 88.9mm	2
22	Bronze brush 14mm O/D x 10mm I/D x 16mm long	2
23	Bronze brush 20mm O/D x 16mm I/D x 16mm long	8
24	Bronze brush 25mm O/D x 20mm I/D x 20mm long	4
25	Plain washer M12	2
26	Hexagon socket grubscrew M6x 8mm long	10
27	Hexagon socket countersunk screw M8 x 25mm long	4
28	Hexagon socket countersunk screw M6 x 10mm long	4

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FIG 9 TOP HEAD RECEDING CHIPBREAKER

10. PNEUMATIC CHIPBREAKER TOP HEAD

Ref No.	Description	No Off.
1	Bracket for pneumatic cylinder	1
2	'Festo' single acting cylinder ref. 2384-AG-35-50	2
3	Hexagon socket capscrew M8 x 80m long	4
4	Hexagon socket grubscrew M6 x 8mm long	2
5	Locknut M10	2
6	'WDS' domed nut M10 ref. 617-203	2
7	Plastic insert	2
8	Standard receding chipbreaker mounting	1
9	Standard flapper chipbreaker mounting	1

Note:-
The assembly of the pneumatic cylinder is the same as the normal chipbreaker apart from the addition of those parts indicated on this page.

Item 5 replaces item 22 on the standard flapper type chipbreaker.

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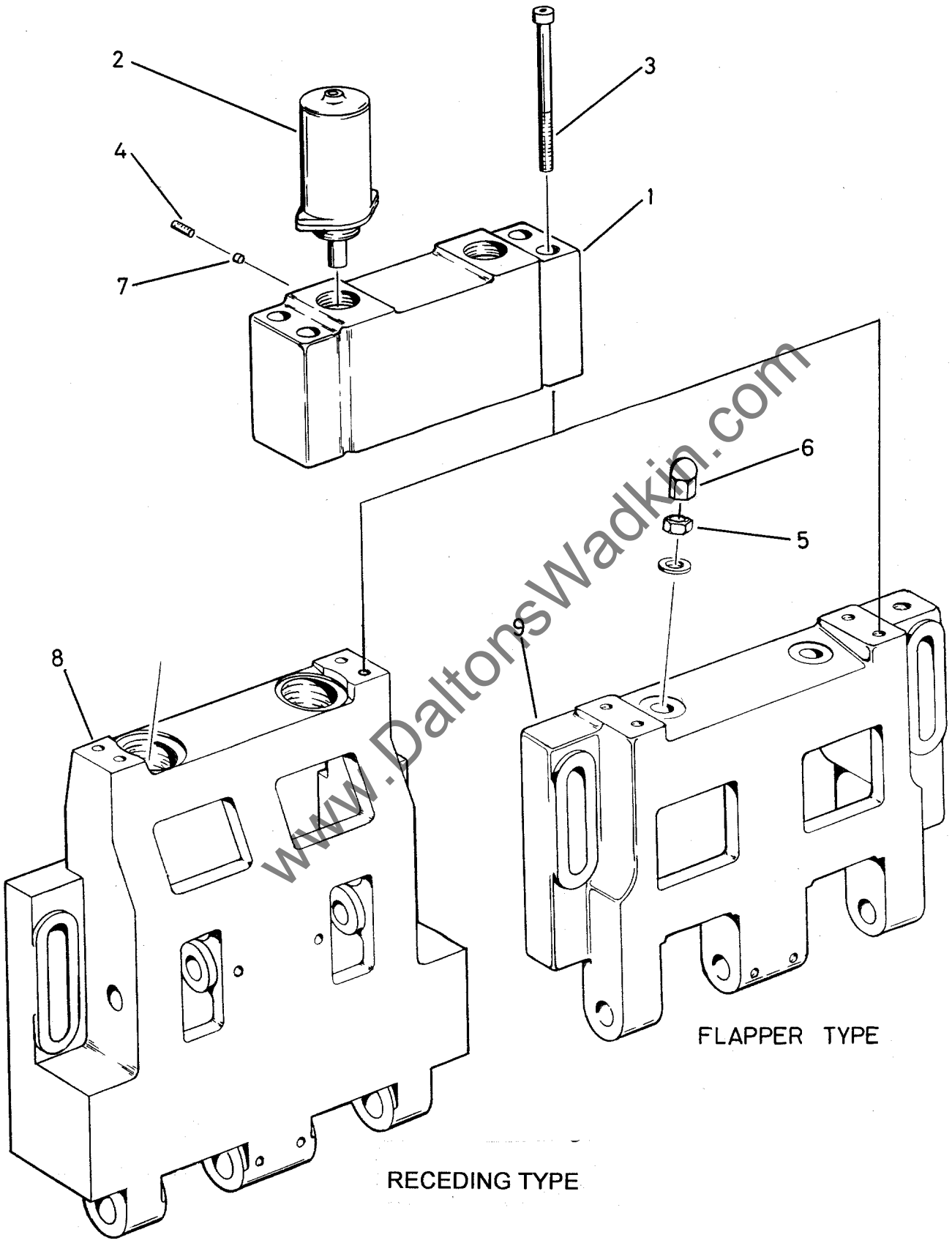


FIG 10 PNEUMATIC CHIPBREAKER — TOP HEAD

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11. MANUAL LOCK FOR TOP HEAD OUTBOARD BEARING

Ref No.	Description	No Off.
1	Outboard bearing support	1
2	Mounting block	1
3	Plate for limit switch	1
4	Shim for outboard bearing lock	1
5	Actuator for lock	1
6	Handle M12	1
7	Limit switch	1
8	Stud M12 x 95mm long	1
9	Hexagon socket capscrew M8 x 30mm long	2
10	Hexagon socket capscrew M6 x 16mm long	2
11	Hexagon socket capscrew M4 x 16mm long	2
12	Hexagon socket grubscrew M5 x 12mm long	1

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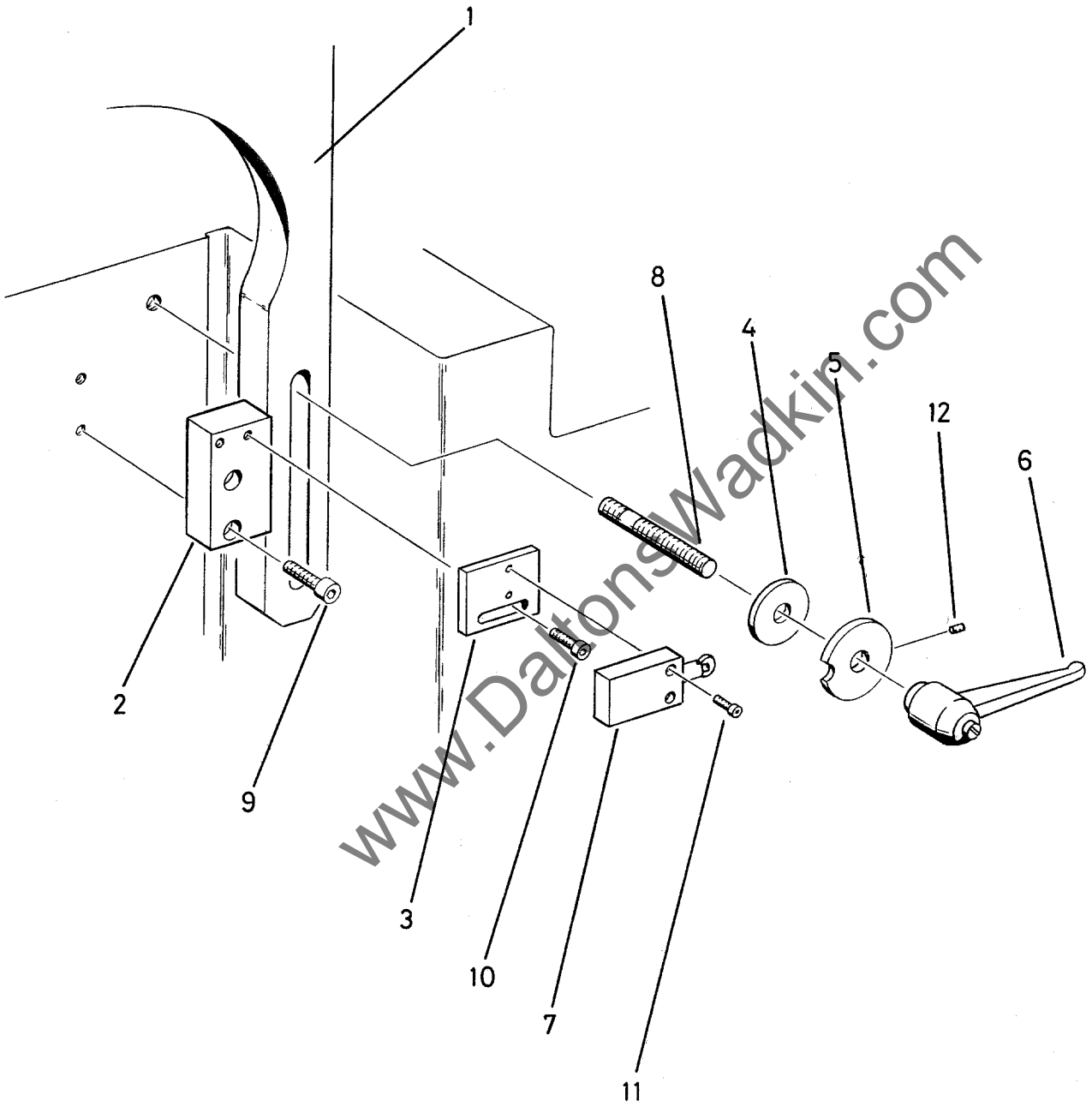


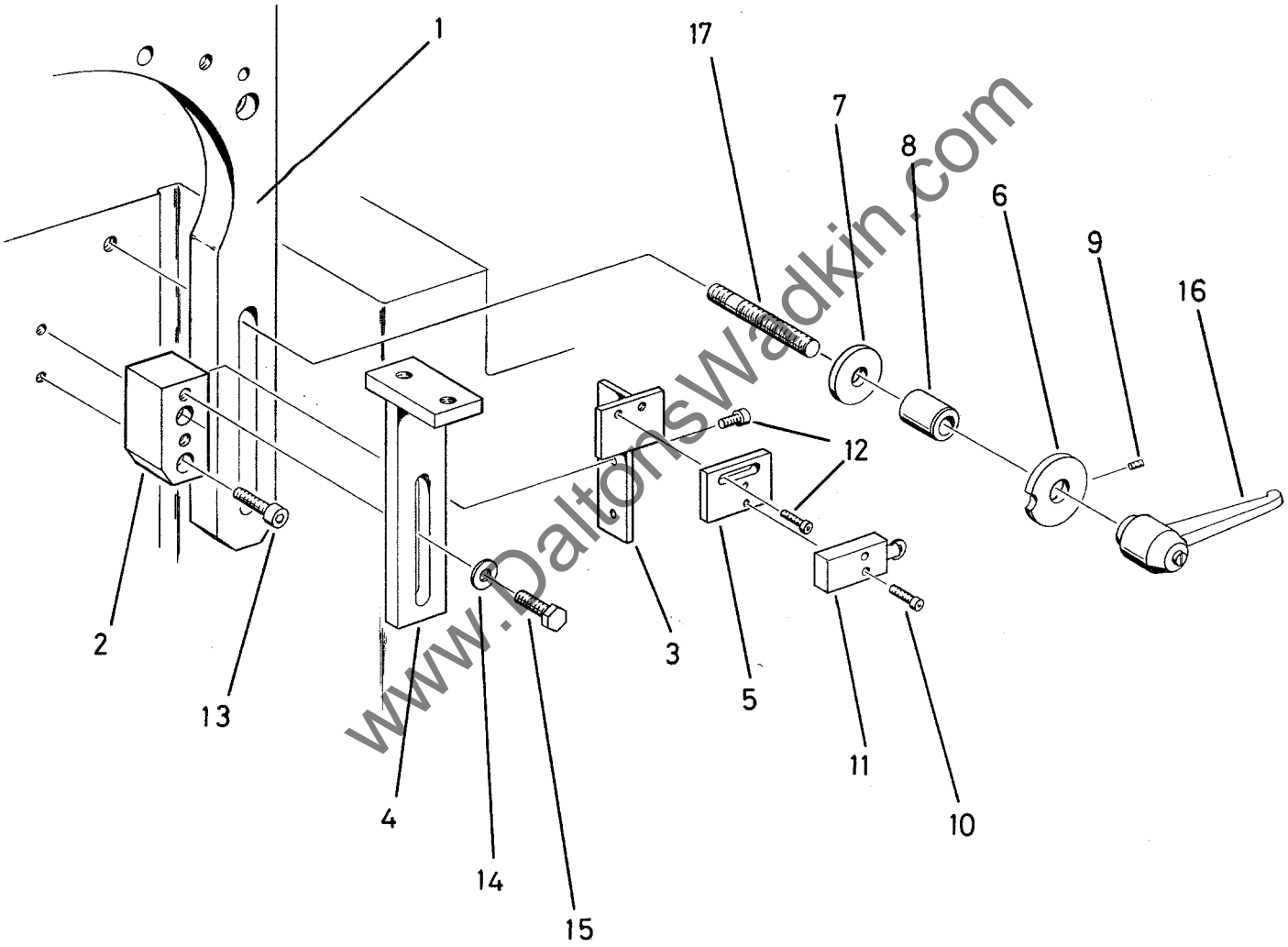
FIG 11 MANUAL LOCK FOR TOP HEAD OUTBOARD BEARING

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12. MANUAL LOCK FOR TOP HEAD OUTBOARD BEARING (WITH SIDE GUIDE)

Ref No.	Description	No Off.
1	Outboard support	1
2	Side guide support block	1
3	Limit switch bracket	1
4	Side guide support	1
5	Rear plate for limit switch	1
6	Actuator for outboard bearing lock	1
7	Shim for bearing lock	1
8	Spacer	1
9	Hexagon socket grubscrew M5 x 12mm long	1
10	Hexagon socket capscrew M4 x 16mm long	2
11	Limit switch	1
12	Hexagon socket capscrew M6 x 16mm long	4
13	Hexagon socket capscrew M8 x 40mm long	2
14	Plain washer M10	2
15	Hexagon head setscrew M10 x 25mm long	2
16	Handle M12	1
17	Stud M12 x 95mm long	1

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FIG 12 MANUAL LOCK FOR TOP HEAD OUTBOARD BEARING
(WITH SIDE GUIDE)

13. TOP HEAD PAD PRESSURE

Ref No.	Description	No Off.
1	Top head hood	1
2	Shoe for pad pressure	1
3	Cross tenon	1
4	Top pressure slide	1
5	Gib strip	1
6	Wear strip	1
7	Raising screw	1
8	Top plate	1
9	'Flexo' compression spring ref. 283824	1
10	Plastic handwheel	1
11	'WDS' tee nut ref. 664203	1
12	Grease nipple	2
13	Tension pin dia. 6 x 20mm long	2
14	Bronze headed bush	1
15	Hexagon locknut M12	2
16	Hexagon locknut M8	4
17	Hexagon nut M10	1
18	Plain washer M10	1
19	Stud M10 x 50mm long	1
20	Plain washer M12	2
21	Hexagon head setscrew M8 x 25mm long	10
22	Hexagon head setscrew M8 x 30mm long	4

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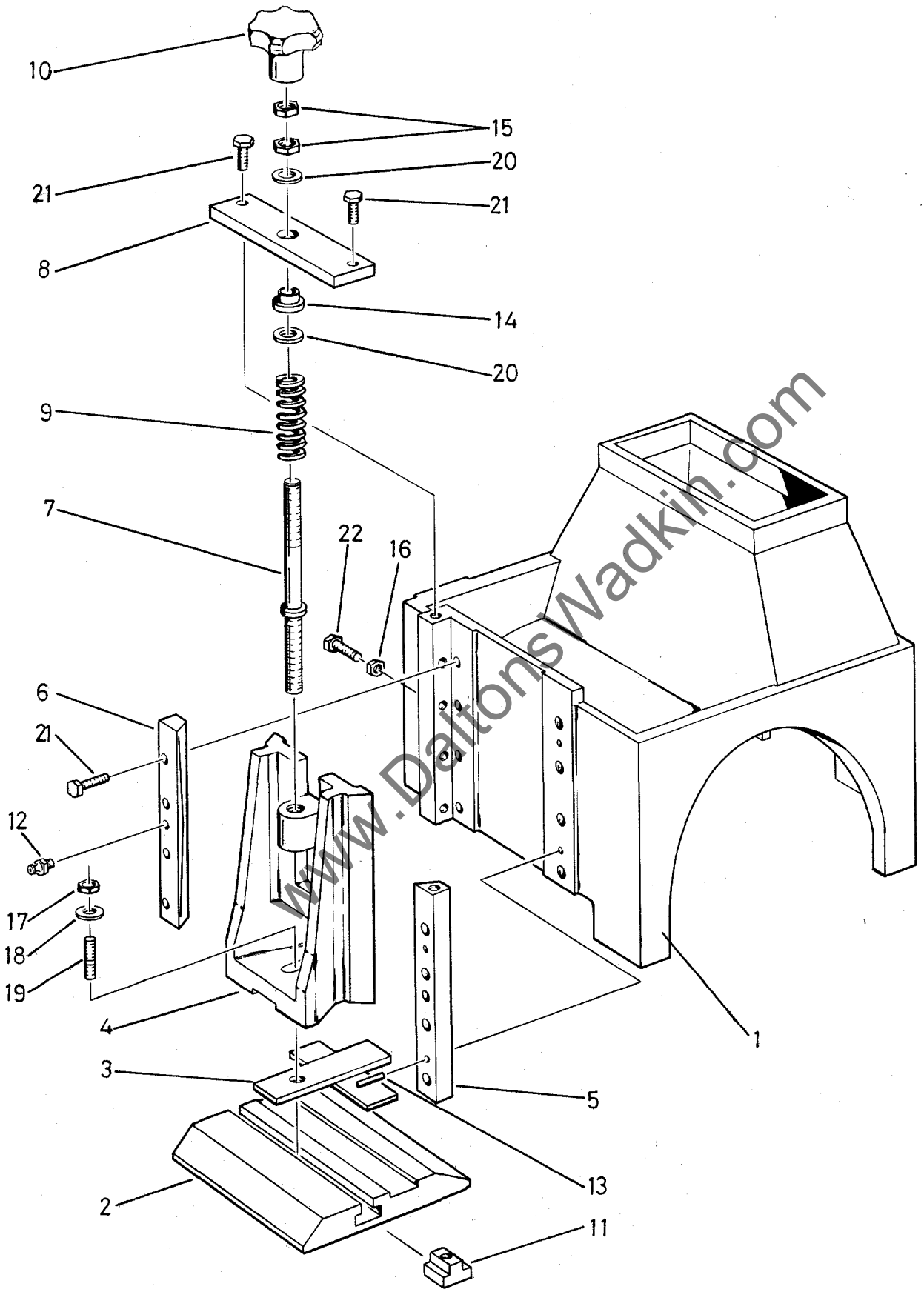


FIG 13 TOP HEAD PAD PRESSURE

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14. FENCE AND NEAR SIDE HEAD ADJUSTMENT

Ref No.	Description	No Off.
1*	Spindle carriage	1
2	Nut for horizontal adjustment	1
3	Nut for vertical adjustment	1
4	Vertical adjustment screw	1
5	Gear bracket	1
6	Bevel gear	2
7	Gear bracket cover (not illustrated)	1
8	Rear shaft	1
9	Collar	1
10	Bearing plate	1
11*	Locking shaft	1
12	Clamping block	1
13	Legend plate	1
14	Grease nipple	2
15	Calibrated dial	1
16*	Vertical adjusting shaft	1
17*	Vertical adjusting shaft (digital readout)	1
18*	Horizontal adjusting shaft	1
19*	Horizontal adjusting shaft (digital readout)	1
20	Square end shaft adaptor	1
21	'INA' thrust bearing ref.AXK 2542	1
22	'INA' thrust washer ref.AS2542	1
23	'INA' shaft washer ref. LS 2542	1
24	Chamfered notch nut M24 x 1.5p	2
25	Bronze bush 25mm O/D x 20mm I/D x 25mm long	1
26	Bronze bush 20mm O/D x 16mm I/D 25mm long	1
27	Hexagon self-locking nut M12	1
28	Hexagon socket grubscrew M6 x 6mm long	2
29	Hexagon socket capscrew M8 x 50mm long	2
30	Hexagon socket capscrew M10 x 30mm long	4
31	Hexagon head setscrew M10 x 80mm long	1
32	Hexagon head setscrew M10 x 20mm long	1
33	Hexagon socket grubscrew M6 x 8mm long	1
34	Plain washer M10	2
35	Large plain washer M10	1
36	Nut M10	1
37	Tension pin 6mm dia. x 50mm long	2
38	Key 5mm x 5mm x 20mm long	4
39	Taper pin No.1 (quantity per digital readout)	1
40	Taper pin No.2	2
41	Collar 32mm O/D 20mm I/D x 14mm wide	2
42	'Gaco' 'O' ring ref. RM-0246-24(quantity per dial readout)	1
43	Drive screw No. 6 x 3/8" long	2
44	Support stud	1

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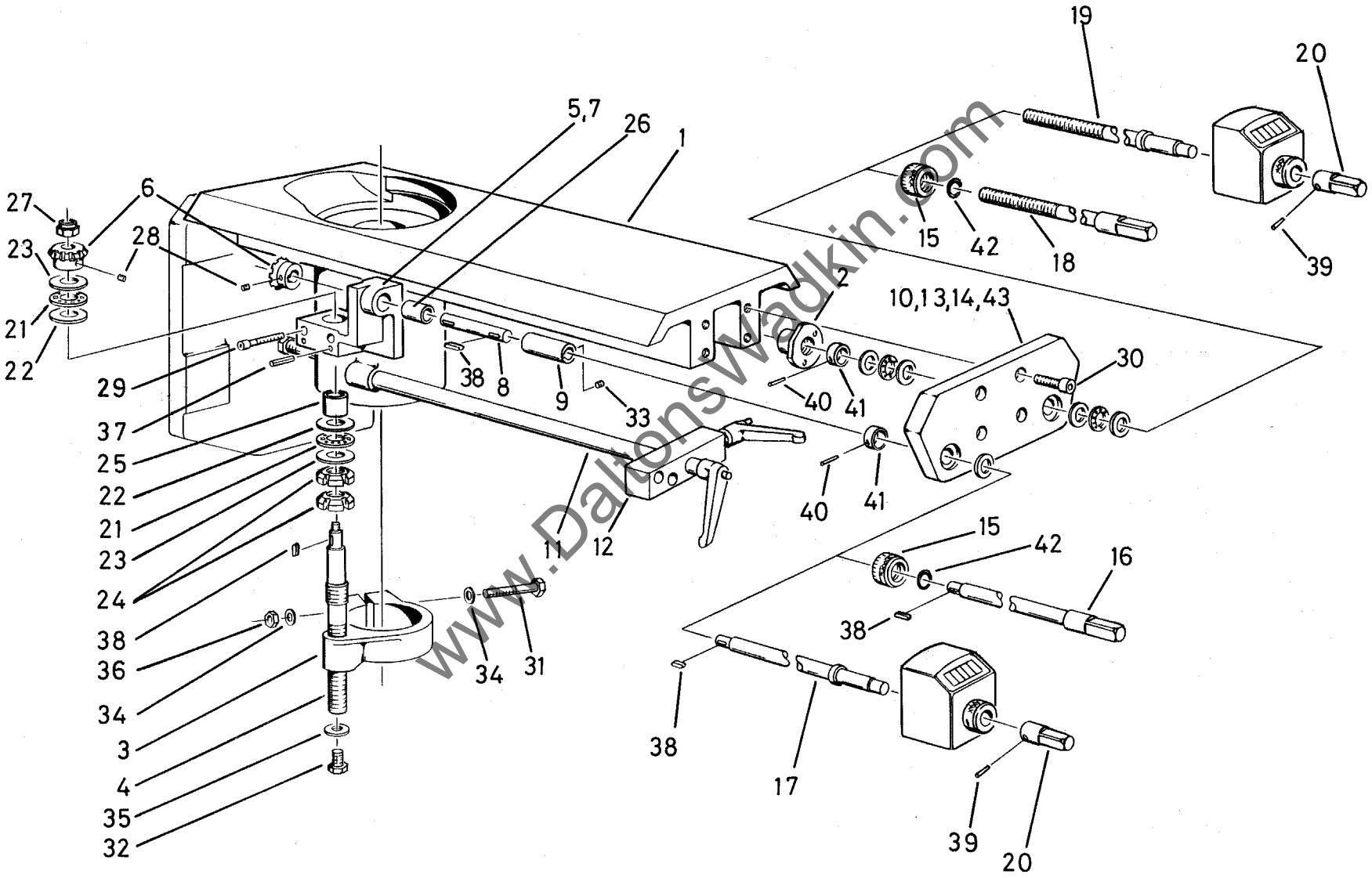


FIG 14 FENCE SIDE AND NEAR SIDE HEAD ADJUSTMENT

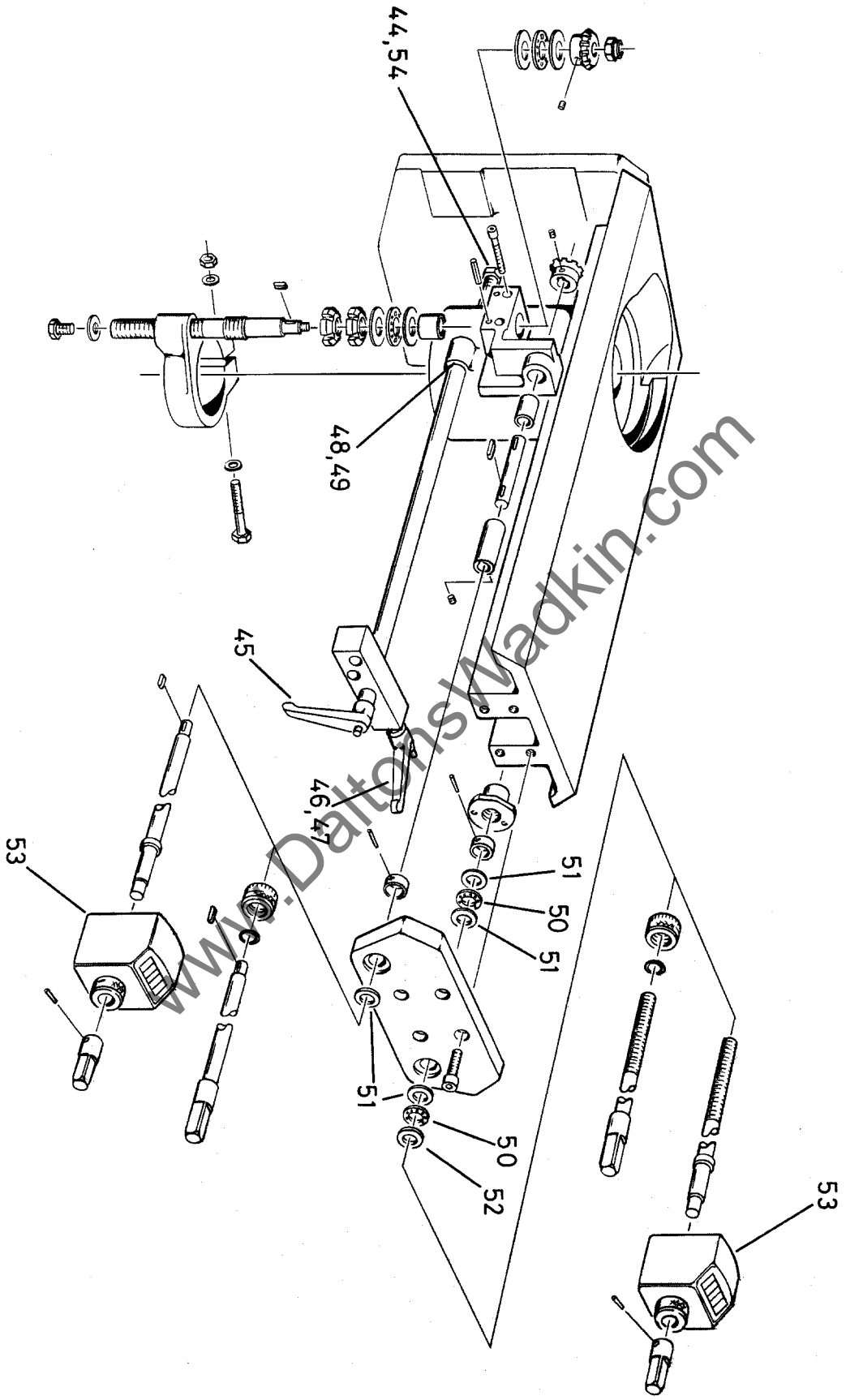
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14. FENCE AND NEAR SIDE HEAD ADJUSTMENT (cont)

Ref No.	Description	No Off.
45	Locking handle M12 x 25mm long	1
46	Locking handle M10 x 25mm long	1
47	Brass pad 6mm dia. x 5mm	1
48	Stud M12 x 70mm long (not illustrated)	1
49	Plain washer M12	1
50	'INA' thrust bearing ref. AXK 2035	2
51	'INA' thrust washer ref. AS 2035	4
52	'INA' shaft washer ref. WS 81104	1
53	Digital readout	1
54	Lock nut M16	2

* Specify if item is for fence or near side head

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FIG 14 FENCE AND NEAR SIDE HEAD ADJUSTMENT

15 NEAR SIDE HEAD CHIPBREAKER AND SIDE PRESSURE

Ref No.	Description	No. Off
1	Bracket and pivot pin	1
2	Chip deflector	1
3	Shoe	1
4	Hexagon head setscrew M10 x 35mm	2
	Plain washer M10	2
5	Spring, spring tensioner and roller arm	1
6	Pin for roller, roller and 20mm circlip	1

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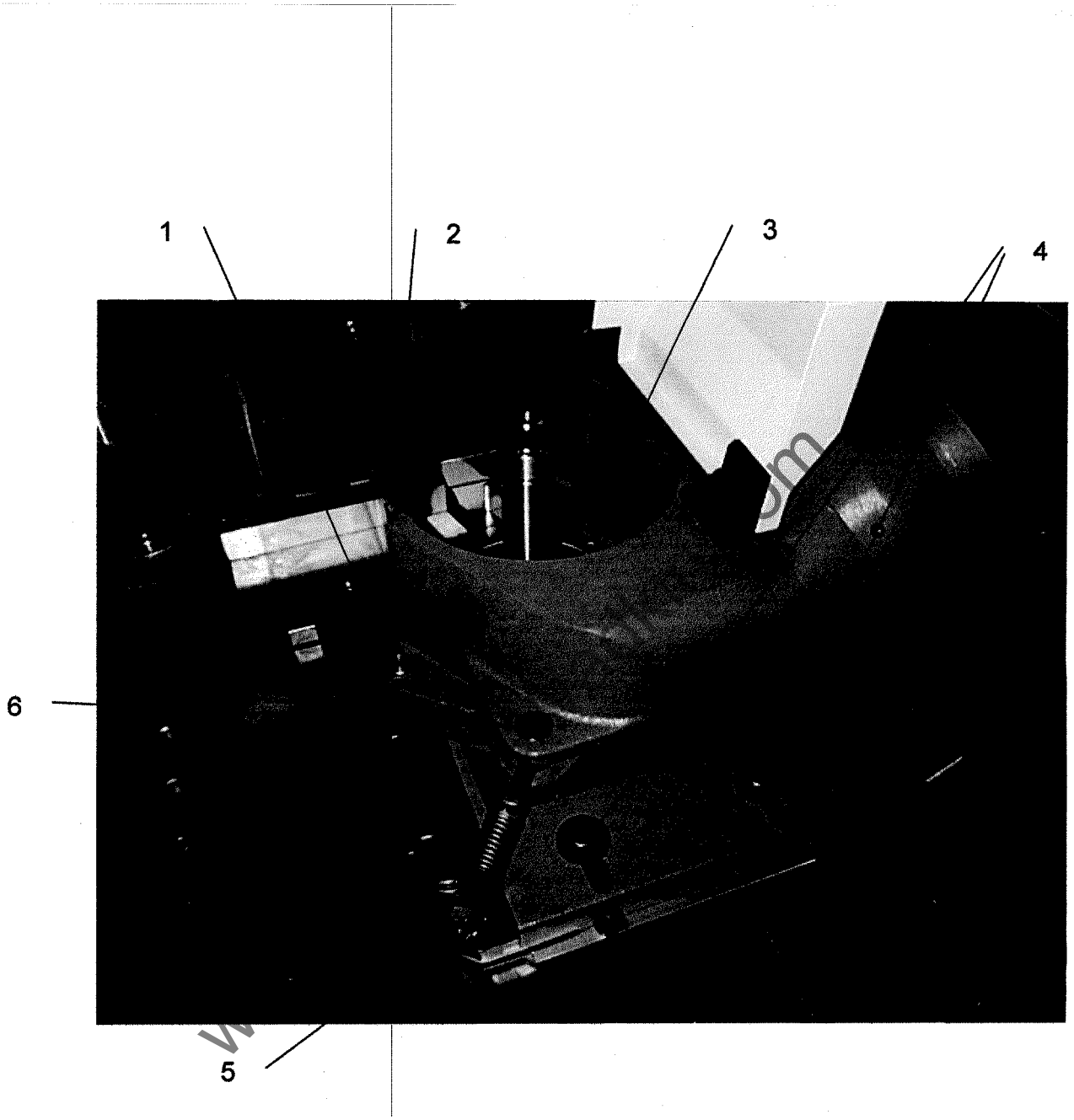


FIG 15 NEAR SIDE HEAD CHIPBREAKER AND SIDE PRESSURE

16. MAIN DRIVE AND GEAR BOXES

Ref No.	Description	No Off.
1	'Siti' gearbox - output shafts both ends (male - male)	-
2	'Siti' gearbox - output shaft one end only (male - female)	-
3	'Siti' gearbox - output shaft one end only, blanked off other side	-
4	Upper cover for drive belt	-
5	Lower cover for drive belt	-
6	Bottom wormbox mounting bracket	-
7	Wormbox mounting bracket	-
8	'Uniroyal' HTD belt ref. 800-8M-50	-
9	'Uniroyal' pulley and bush set comprising of HTD 40-8M-50F pulley and taperlock bush 1615 40mm bore	-
10	'Uniroyal' pulley and bush set comprising of HTD 48-8M-50F pulley and taperlock bush 2012 30mm bore	-
11	Feed drive pulley cover	-
12	Feed drive bracket	-
13	Gearbox mounting bracket	-
14 *	'Simplatrol' drive motor 5.5kW (7.5hp)	-
15	Gearbox extension shaft	-
16	Drive shaft (specify length)	-
17 *	'Brook' drive motor 11kW (15 hp)	-
18	'Simplabelt' sub-assembly	-
19	'Uniroyal' HTD belt ref. 1200-8M-50	-
20	Extension shaft	-
21	'Fenner' taperlock bush ref. 029P0038	-
22	'Fenner' HTD pulley ref. 90.8.50	-
23	'Fenner' pulley and bush set comprising of HTD pulley 30-8-50 5F and taperlock bush 1210 28mm bore	-
24	Plate for power train	-
25	Pivot shaft for motor	-
26	Motor plate for pivot	-
27	Mounting bracket for gear boxes	-
28	Pivot bracket	-
29	Cover	-

Illustration only shows an example of possible gearbox layout

* Note: when ordering motors specify frequency

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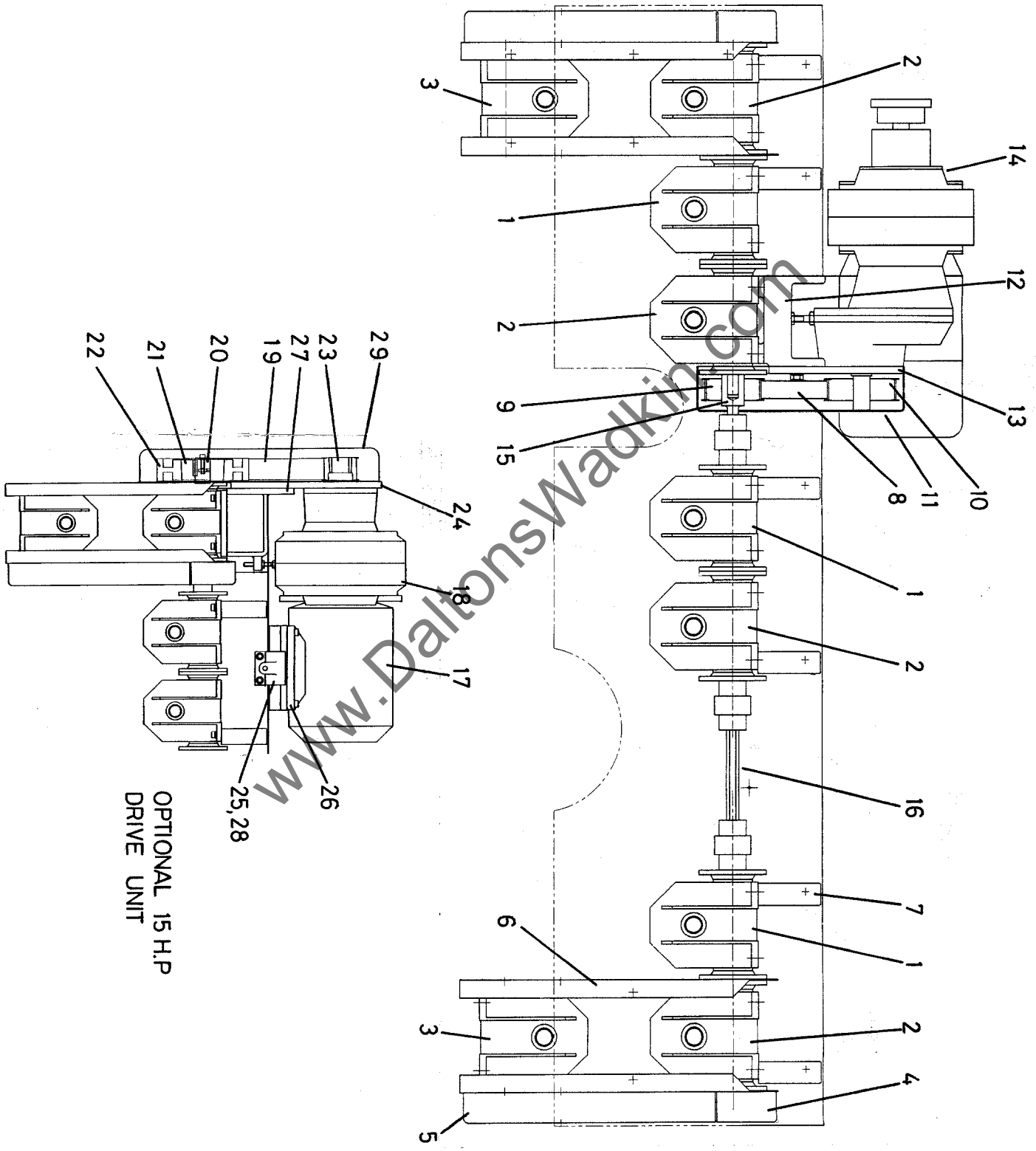


FIG 16 MAIN DRIVE AND GEARBOXES

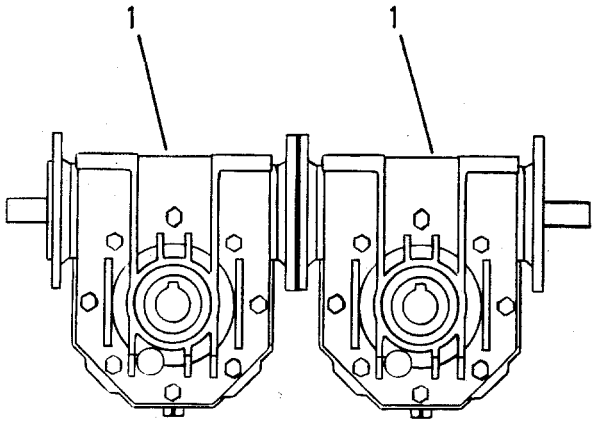
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17. GEARBOX COUPLINGS

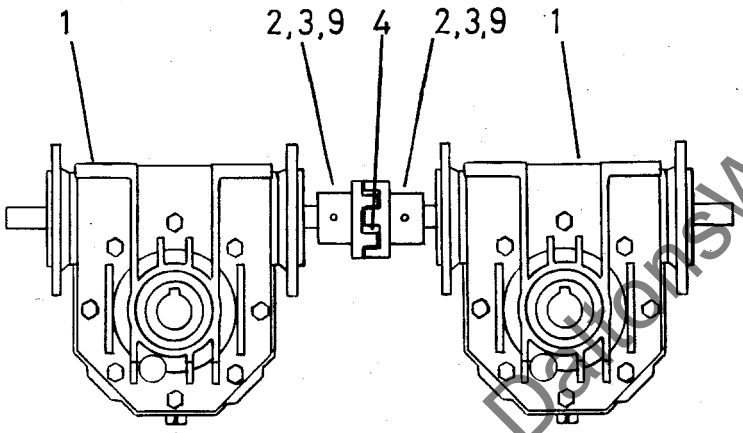
Ref No.	Description	No Off.
1	Gearbox	1
2	Coupling segment dia. 19mm bore or dia. 24mm bore	1
3	Hexagon socket grubscrew M6 x 10mm long	1
4	Flexible spider insert	1
5	Coupling segment 19mm A/F	1
6*	Hexagonal drive shaft 19mm A/F	1
7	Extended coupling segment dia. 19mm bore or dia. 24mm bore	1
8	Gearbox extension shaft	1
9	Key 6mm x 6mm x 35mm long	1
10	Flange coupling	1
11	Taper lock bush ref 029K0019	1
12	Pulley	1
13	Hexagon socket capscrew M6 x 12mm long	4
14	Boss for drive coupling	4
15	'Gaco' 'O' ring ref RMO 156-24	4

* Note: Specify bore size on couplings and length on drive shaft.

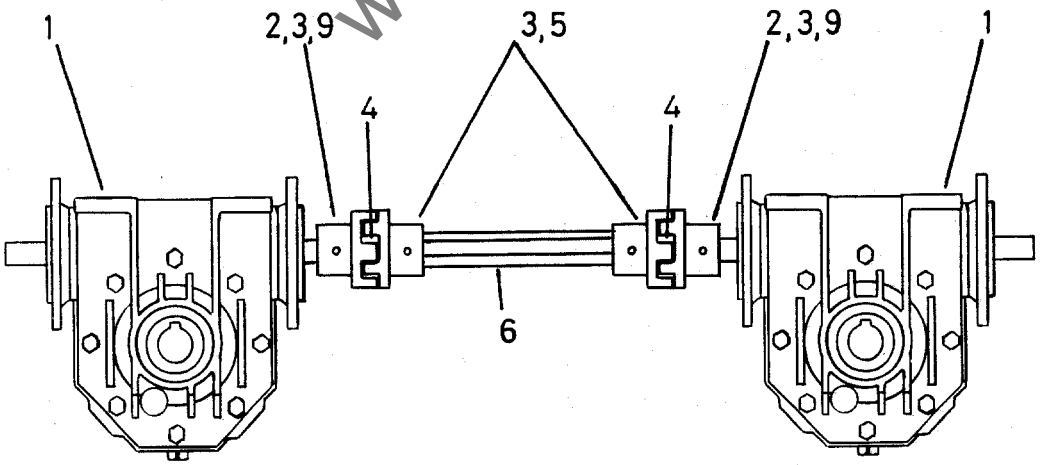
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GEARBOXES FLANGE CONNECTED



GEARBOXES CONNECTED BY A SINGLE COUPLING



GEARBOXES CONNECTED BY A DRIVE SHAFT AND TWO COUPLINGS

FIG 17 GEARBOX COUPLINGS

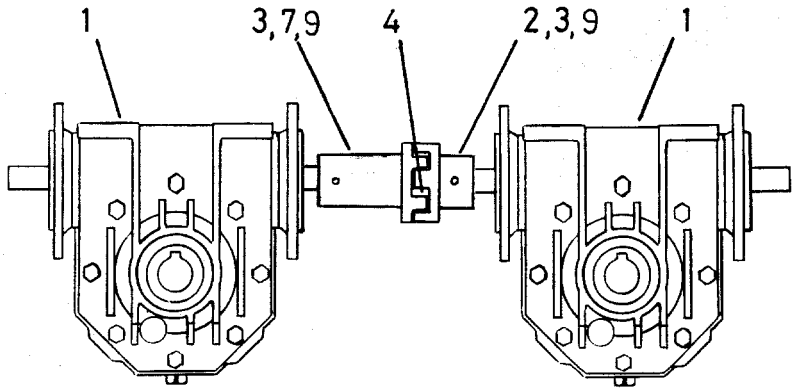
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17. GEARBOX COUPLINGS (cont)

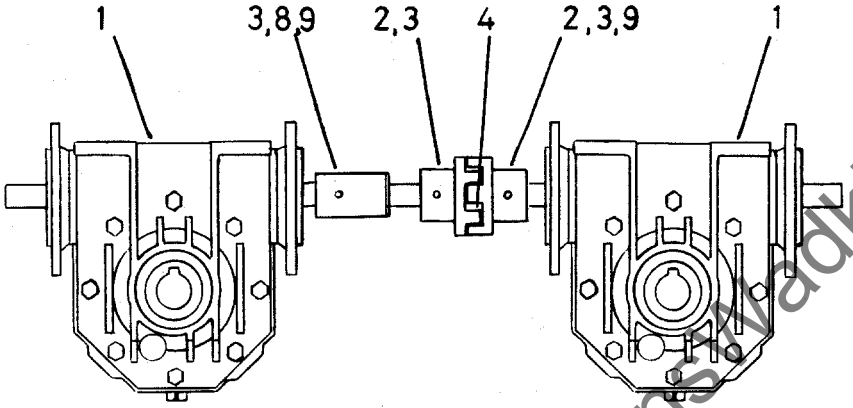
Ref No.	Description	No Off.
1	Gearbox	1
2	Coupling segment dia. 19mm bore or dia. 24mm bore	1
3	Hexagon socket grubscrew M6 x 10mm long	1
4	Flexible spider insert	1
5	Coupling segment 19mm A/F	1
6*	Hexagonal drive shaft 19mm A/F	1
7	Extended coupling segment dia. 19mm bore or dia. 24mm bore	1
8	Gearbox extension shaft	1
9	Key 6mm x 6mm x 35mm long	1
10	Flange coupling	1
11	Taper lock bush ref 029K0019	1
12	Pulley	1
13	Hexagon socket capscrew M6 x 12mm long	4
14	Boss for drive coupling	4
15	'Gaco' 'O' ring ref RMO 156-24	4

* Note: Specify bore size on couplings and length on drive shaft.

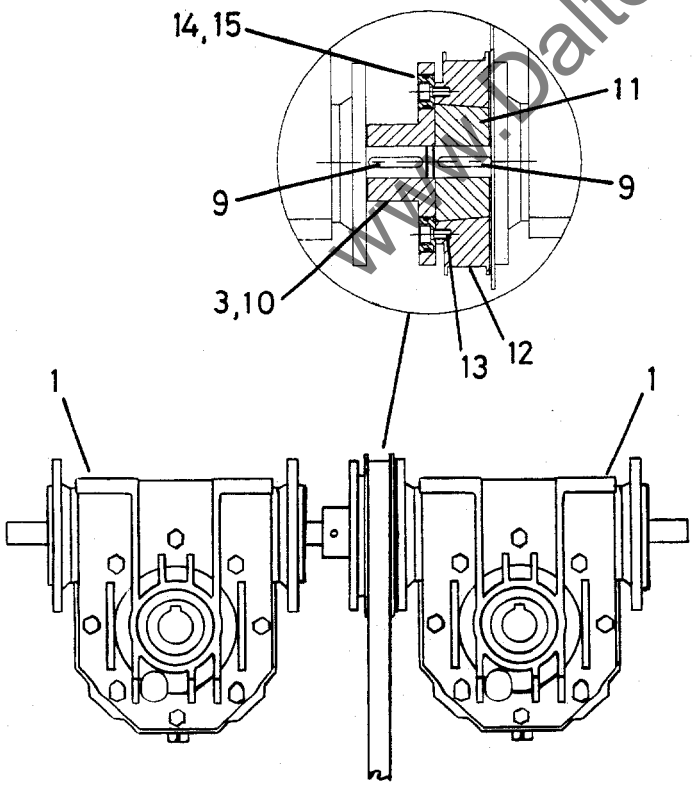
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GEARBOXES CONNECTED BY A STANDARD COUPLING HALF AND AN ELONGATED HALF



GEARBOXES CONNECTED BY A COUPLING AND AN EXTENSION SHAFT



GEARBOX PROVIDING DRIVE TO BOTTOM FEED ROLL GEARBOX CONNECTED BY PULLEY AND FLANGED COUPLING

FIG 17 GEARBOX COUPLINGS (cont)

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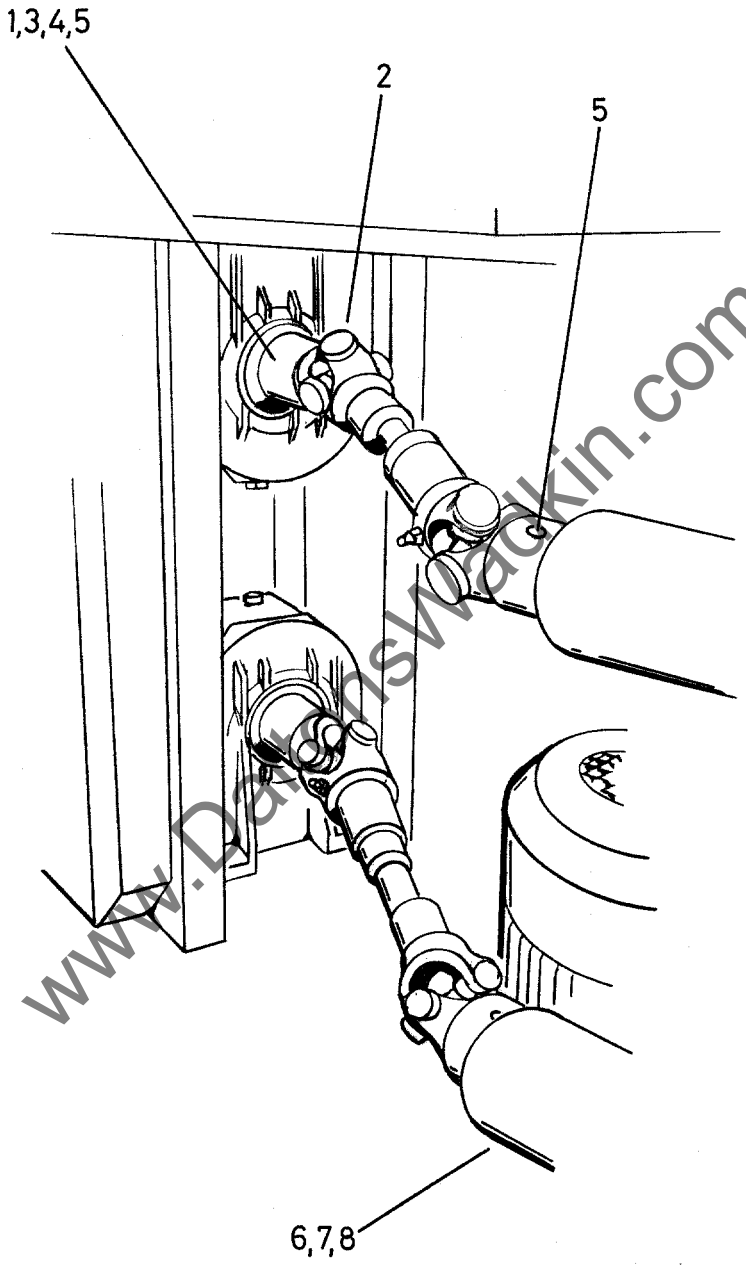
18. DRIVE FROM GEARBOXES TO FEED ROLLS

Ref No.	Description	No Off.
1	Output shaft for gearbox	1
2	Universal drive shaft 'IMS' ref. OA 131	1
3	Key 8mm x 7mm x 35mm long	2
4	External circlip dia. 28mm	1
5	Hexagon socket grubscrew M8 x 8mm long	2
6*	Spigot for universal joint gaiter	1
7*	Gaitor	1
8*	Jubilee clip dia. 80mm	2

* Items are not illustrated and are only used on the bottom feed roll units on certain head sequence machines.

Note: Quantities are for one gearbox/feed roll drive unit

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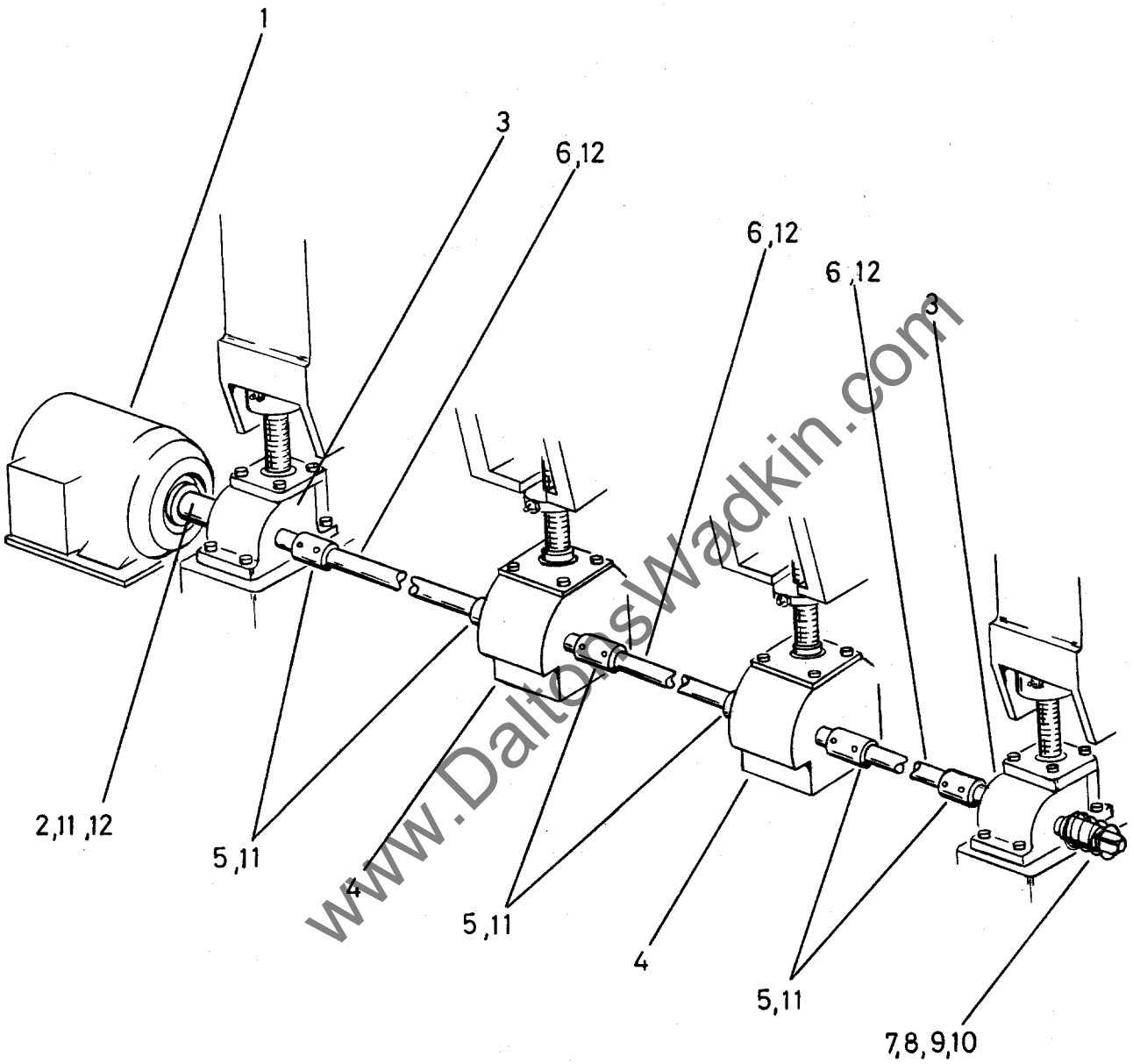
FIG 18 DRIVE FROM GEARBOXES TO FEEDROLLS

19. DRIVE SHAFTS FOR BEAM RISE AND FALL

Ref No.	Description	No Off.
1	'Brook' drive motor	1
2	Collar motor (to first gear housing)	1
3	Beam rise and fall gearbox	-
4	Top head rise and fall gearbox	-
5	Connecting shaft collar	-
6	Drive shaft (specify length)	-
7	Square end adaptor	1
8	Compression spring	1
9	Taper pin No. 2	1
10	External circlip 30mm dia.	1
11	Nyloc grubscrw M6 x 8mm long	-
12	Key 6mm x 6mm x 20mm long	-

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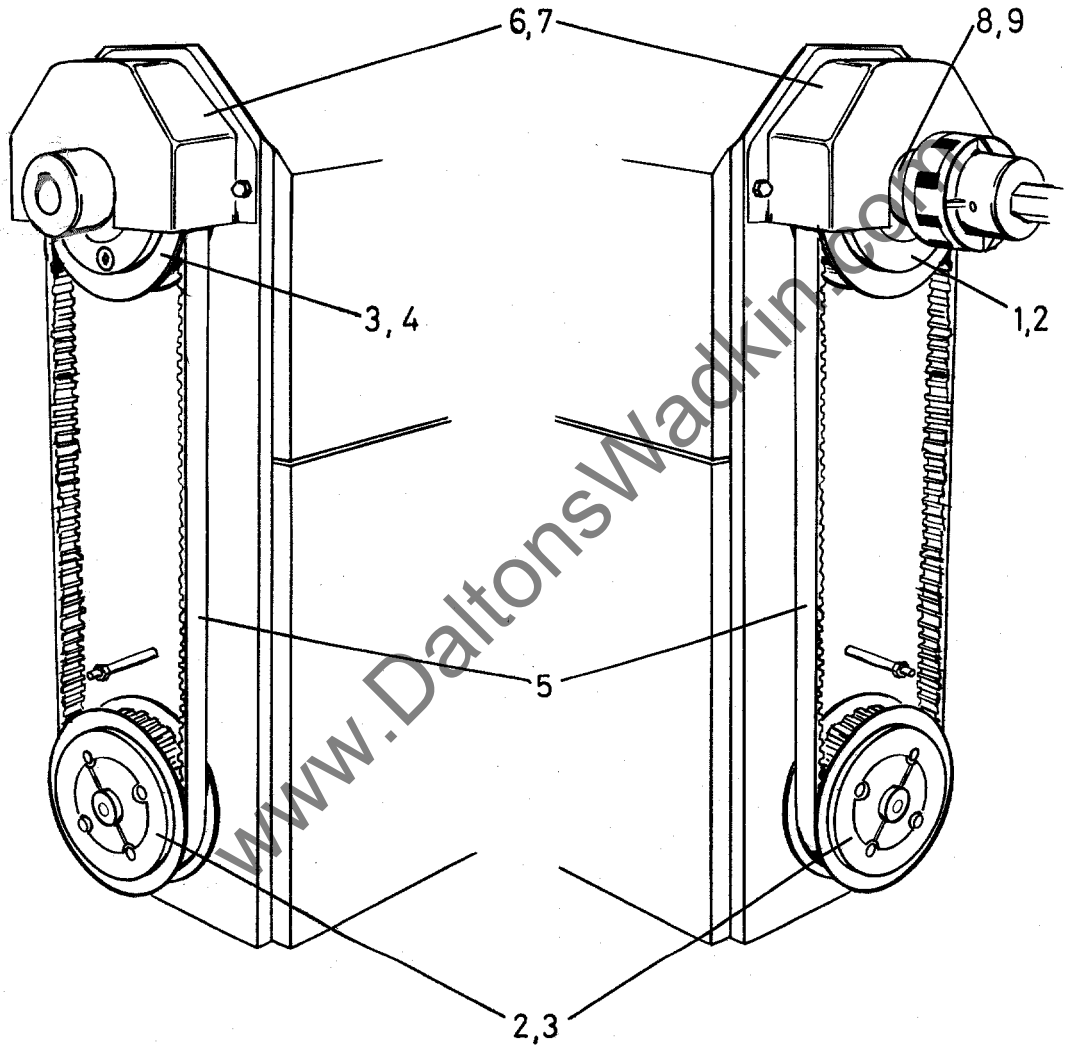
FIG 19 DRIVE SHAFTS FOR BEAM RISE AND FALL

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20. DRIVE TO BOTTOM FEED ROLLS

Ref No.	Description	No Off.
1	Taper lock bush 'Fenner' ref 2012 dia. 48mm bore	1
2	Pulley 'Fenner' ref. P48 8M 20F	3
3	Taper lock bush 'Fenner' ref 2012 19mm dia. bore or 24mm dia.bore	3
4	Special pulley for drive coupling	1
5	Timing belt 'Fenner' ref 1200 8M 20	2
6	Top timing belt cover	2
7	Bottom timing belt cover (not shown)	2
8	Extended coupling segment 19mm dia. bore or 24mm dia. bore	1
9	Hexagon socket grubscrew M6 x 10mm long	1

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USED WHEN GEARBOX IS CONNECTED TO A FLANGED COUPLING

USED WHEN CONNECTING TO ANOTHER SERRATED SEGMENT

FIG 20 DRIVE TO BOTTOM FEEDROLLS

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21. BEAM RISE AND FALL GEARBOX

Ref No.	Description	No Off.
1	Worm gear housing	1
2	Worm shaft	1
3	Worm wheel	1
4	Top cover for worm gear housing	1
5	Rise and fall head screw	1
6	Nut for rise and fall leadscrew	1
7	Bronze brush 30mm O/D 25mm I/D x 20mm long	1
8	'INA' thrust bearing ref. AXK2035	2
9	'INA' thrust washer ref. AS 2035	3
10	'INA' shaft washer ref WS 81104	1
11	Bronze bush 25mm O/D x 20mm I/D x 20mm long	1
12	'SKF' bearing ref. 6204 RS	2
13	Hexagon locknut M20	2
14	Internal circlip dia. 47mm	2
15	Key 6mm x 6mm x 32mm long	1
16	Hexagon socket capscrew M6 x 25mm long	4

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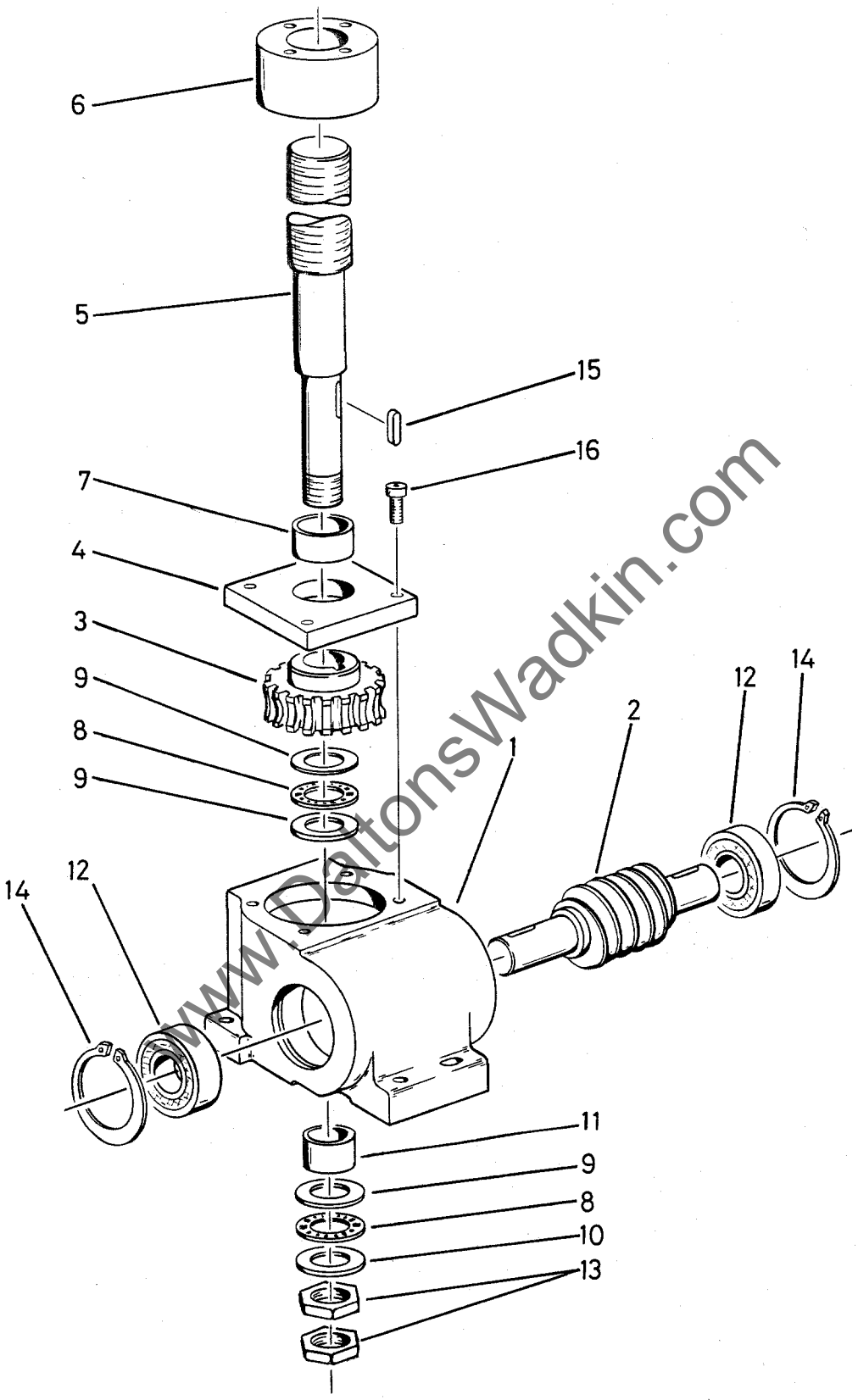


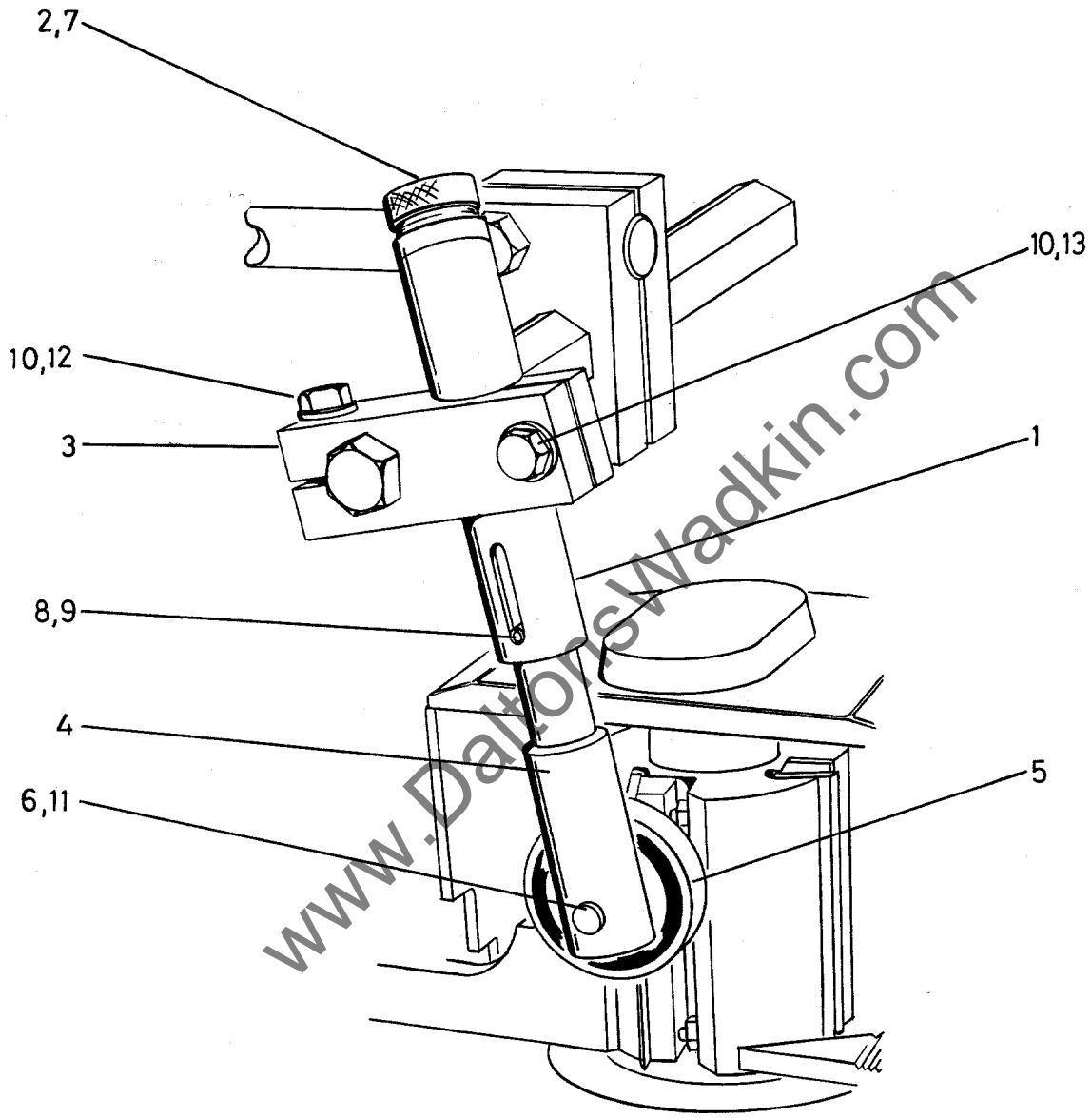
FIG 21 BEAM RISE AND FALL GEARBOX

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22. TOP ROLLER PRESSURE UNIT

Ref No.	Description	No Off.
1	Barrel,	1
2	Spring tensioner	1
3	Split clamp,	1
4	Roller arm,	1
5	Roller, complete with bearing	1
6	Roller pin,	1
7	Spring,	1
8	Tension pin, 8mm dia. x 24mm long	1
9	Tension pin, 5mm dia. x 24mm long	1
10	Hexagon head setscrew, M12 x 45mm long	2
11	Circlip, 20mm external	1
12	Plain washer M12	2

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FIG 22 TOP ROLLER PRESSURE

23 TOP PRESSURE MOUNTING

Ref No.	Description	No Off.
1	Bracket, top pressure	1
2	Horizontal bar, longitudinal adjustment	1
3	Horizontal bar, transverse adjustment	1
4	Split clamp, top pressure horizontal bars	1
5	Screwed stud, M10 x 55mm long	1
6	Hexagon nut, M10	1
7	Washer, M10	1
8	Hexagon socket capscrew, M10 x 25mm long	2
9	Hexagon head setscrew, M12 x 40mm long	2

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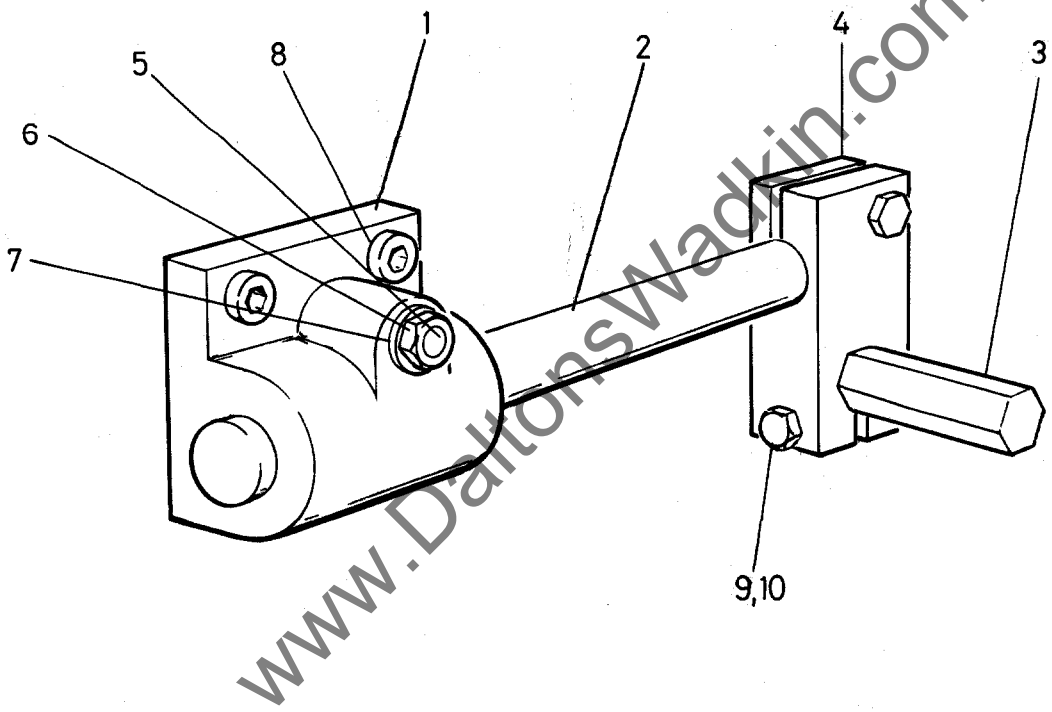


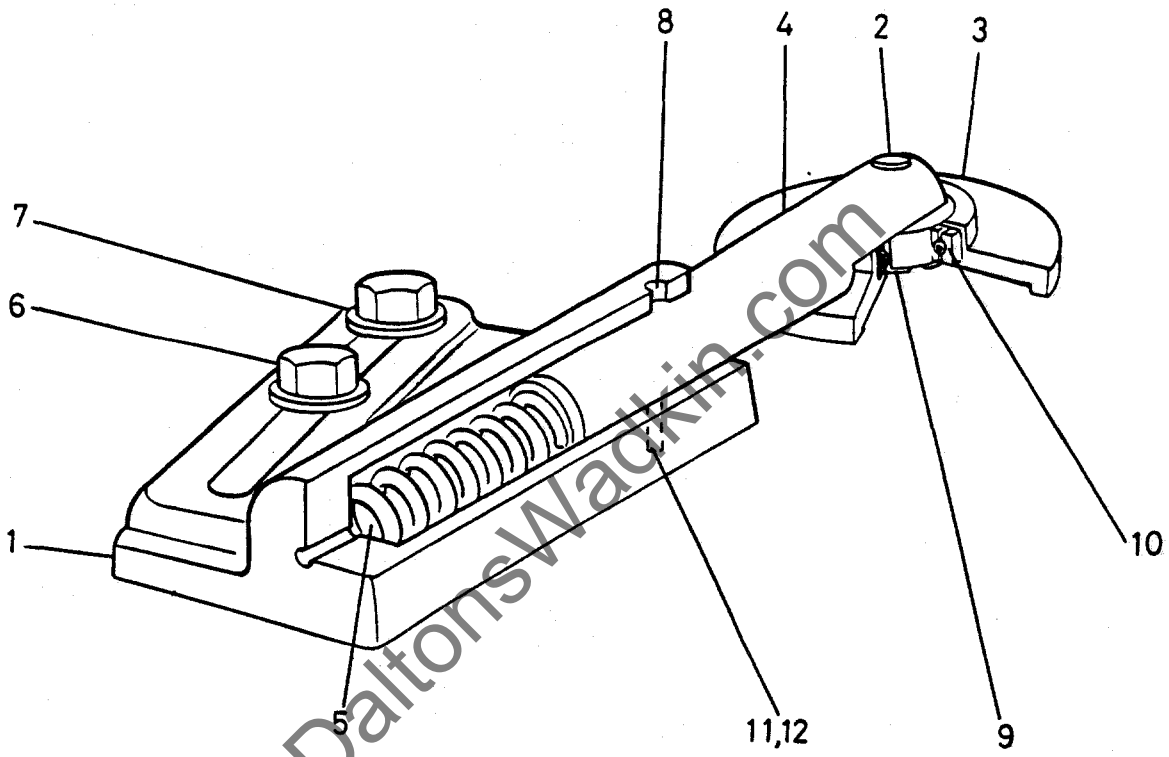
FIG 23 TOP PRESSURE MOUNTING

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24 SINGLE SIDE ROLLER PRESSURE

Ref No.	Description	No. Off
1	Bracket , single side roller pressure unit	1
2	Pin, side pressure roller	1
3	Pressure roller	1
4	Sliding shaft, pressure roller	1
5	Infeed pressure spring	
6	Hexagon head screw, M12 x 35mm long	2
7	Washer, 12m, mild steel	2
8	Nylon domed plug, black, 8mm hole	1
9	Circlip, 20mm external	1
10	Bearing, SKF 6004 2RS	1
11	Tension pin, 8mm diameter x 30mm long	1
12	Tension pin, 5mm diameter x 30mm long	1

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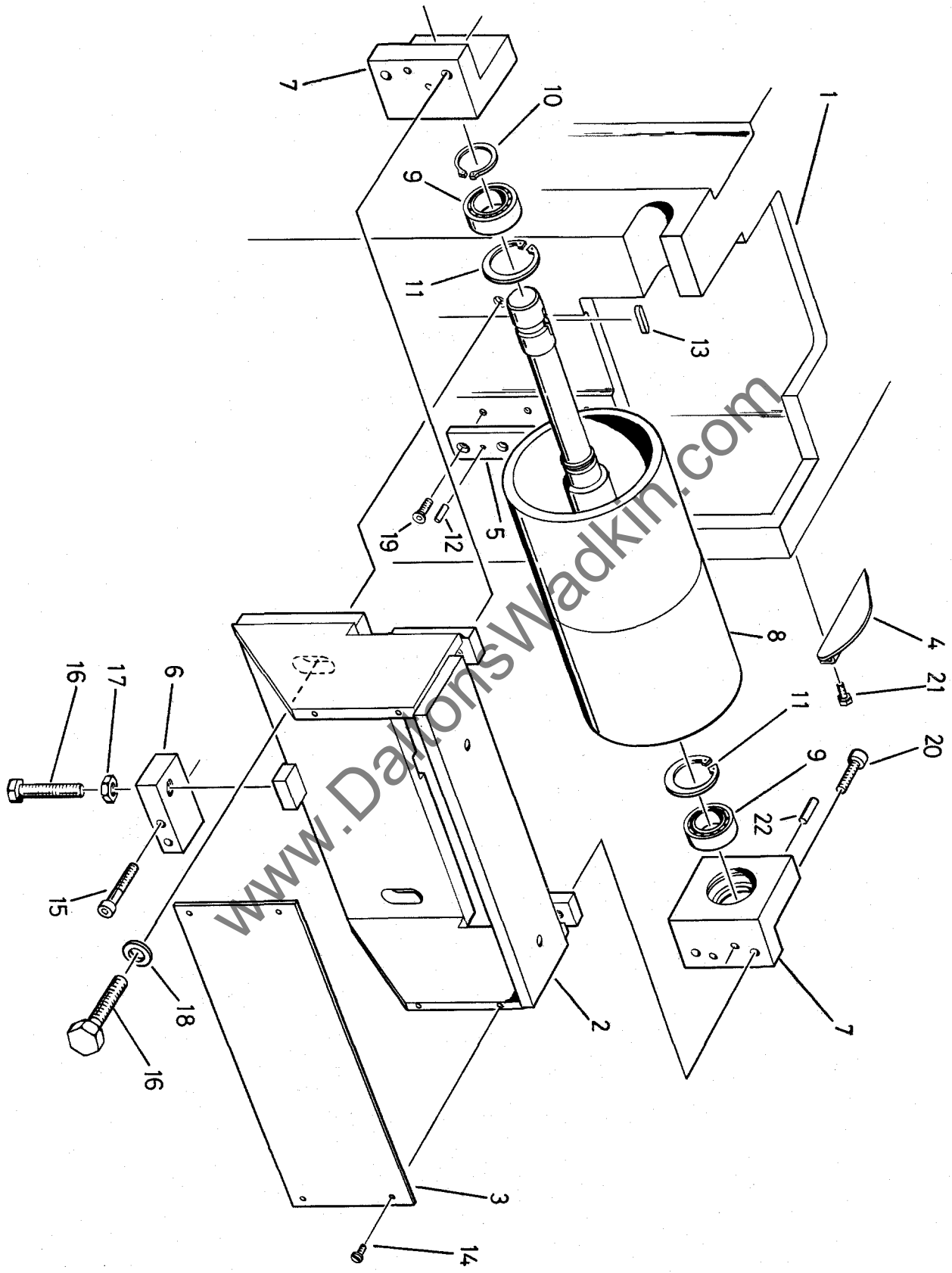
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FIG 24 SINGLE SIDE ROLLER PRESSURE

25. OUTFEED BED ROLL

Ref No.	Description	No Off.
1	Main frame	1
2	Outfeed table	1
3	Cover for outfeed table	1
4	Front guard	1
5	Tenon for table	1
6	Block for jacking screw	1
7	Bearing housing	2
8	Bedroll assembly	1
9	'SKF' bearing ref. 6006-2RS	2
10	External circlip dia. 30mm	1
11	Internal circlip dia. 55mm	2
12	Dowel pin	2
13	Key 8mm x 7mm x 40mm long	1
14	Pan head screw M4 x 10mm long	4
15	Hexagon socket capscrew M8 x 45mm long	2
16	Hexagon head set screw M12 x 45mm long	3
17	Hexagon locknut	1
18	Plain washer M12	2
19	Countersunk screw M6 x 20mm long	3
20	Hexagon socket capscrew M10 x 20mm long	4
21	Hexagon head setscrew M4 x 10mm long	2
22	Tension pin dia. 6mm x 32mm long	4

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FIG 25 OUTFEED BEDROLL

26. FLANGE MOUNTED FEEDROLL

Ref No.	Description	No Off.
1	Eye bolt M12	1
2	'C' washer	1
3	Spacer for swing	1
4	Pivot shaft for swing	1
5	Shaft	1
6	Flange	1
7	Feedroll swing	1
8	Disc spring 50mm O/D x 25.4mm I/D x 1.5mm	2
9	Bronze bush 30mm O/D x 25mm I/Dx 25mm long	2
10	Bearing 'SKF' 6006-2RS	2
11	External clip 30mm dia.	1
12	Internal circlip 55mm dia.	1
13	Hexagon head setscrew M12 x 190mm long	1
14	Key 8mm x 7mm x 20mm	1
15	Locknut M12	1
16	Feed roll (specify width and type (i.e. polyurethane or serrated steel)	
17	'Schrader' single acting cylinder ref IXB 4726C	1
18	Pivot pin } supplied with	1
19	Retaining clip } cylinder	1
20	Heli-coil insert M12 x 1.75p	1

Note: The swing, depending on location, may not require items 3 and/or 8 (spacer and disc spring). It may also be mounted in the reverse position to that shown i.e. with the cranked arm to the rear.

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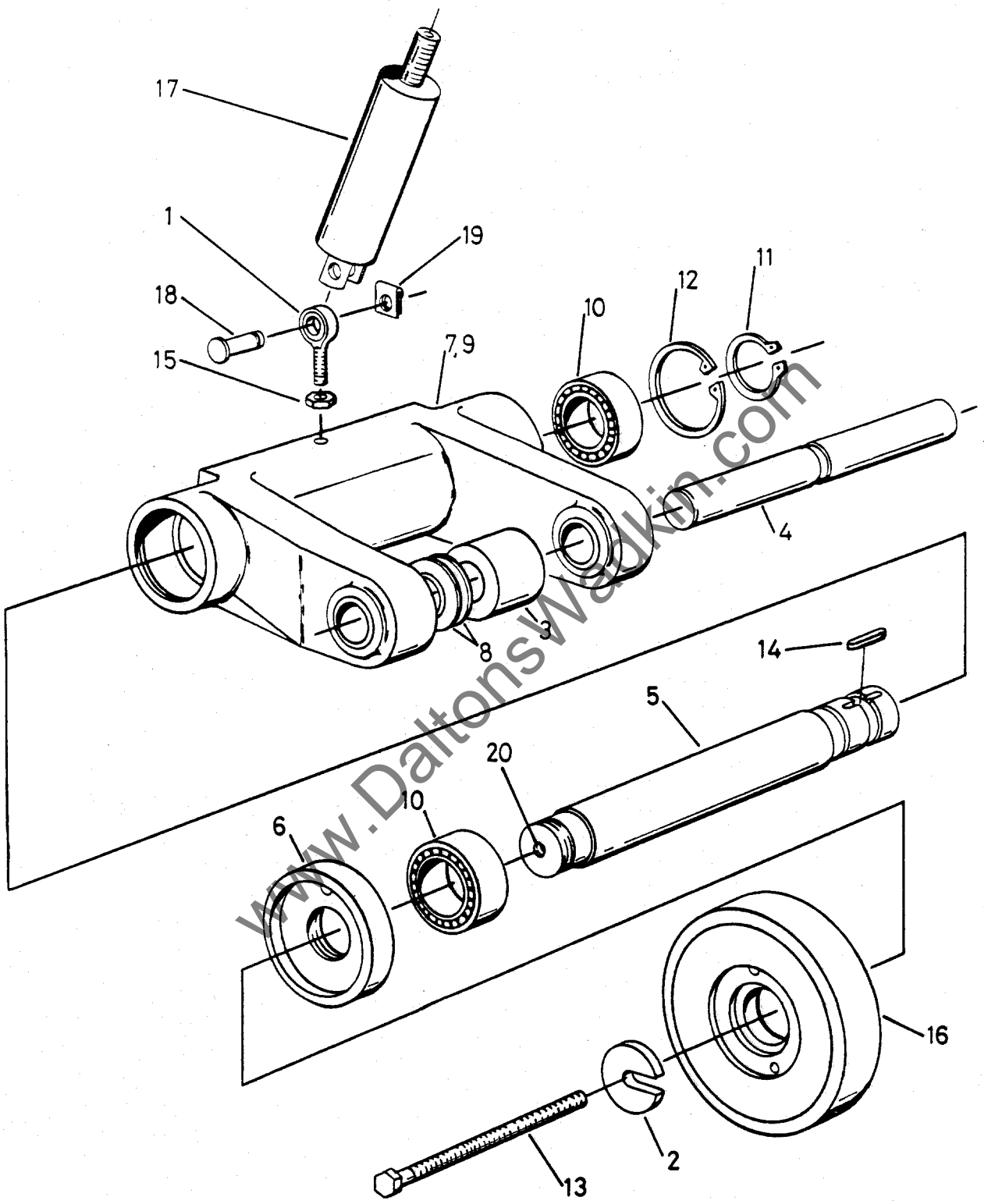


FIG 26 FLANGED MOUNTED FEEDROLL

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27. SHAFT MOUNTED FEED ROLL

Ref No.	Description	No Off.
1	Eye bolt M12	1
2	'C' washer	1
3	Spacer for swing	1
4	Pivot shaft for swing	1
5	Key	1
6	Shaft	1
7	Feedroll swing	1
8	Disc spring 50mm O/D x 25.4mm I/D X 1.5mm	2
9	Bronze bush 30mm O/D x 25mm I/D x 25mm long	2
10	Bearing 'SKF' ref. 6006-2RS	2
11	External circlip 30mm dia.	3
12	Internal circlip 55mm dia.	1
13	Tolerance ring 'Rencol' SV30 x 8SS	1
14	Key 8mm x 7mm x 20mm	1
15	Locknut M12	1
16	Spacer (specify width)	1
17	Single acting cylinder 'schrader' ref IXB 4726C	1
18	Pivot pin (supplied with cylinder)	1
19	Retaining clip (supplied with cylinder)	1
20	Hexagon head setscrew M12 x 25mm long	1
21	Hexagon socket counter sunk screw M4 x 12mm long	2
22	Feed roll (specify width and type, i.e. polyurethane or serrated steel)	

NOTE:
The swing, depending on location, may not require items 3 and/or 8 (spacer and disc spring). It may also be mounted in the reverse position to that shown, i.e. with the cranked arm to the rear.

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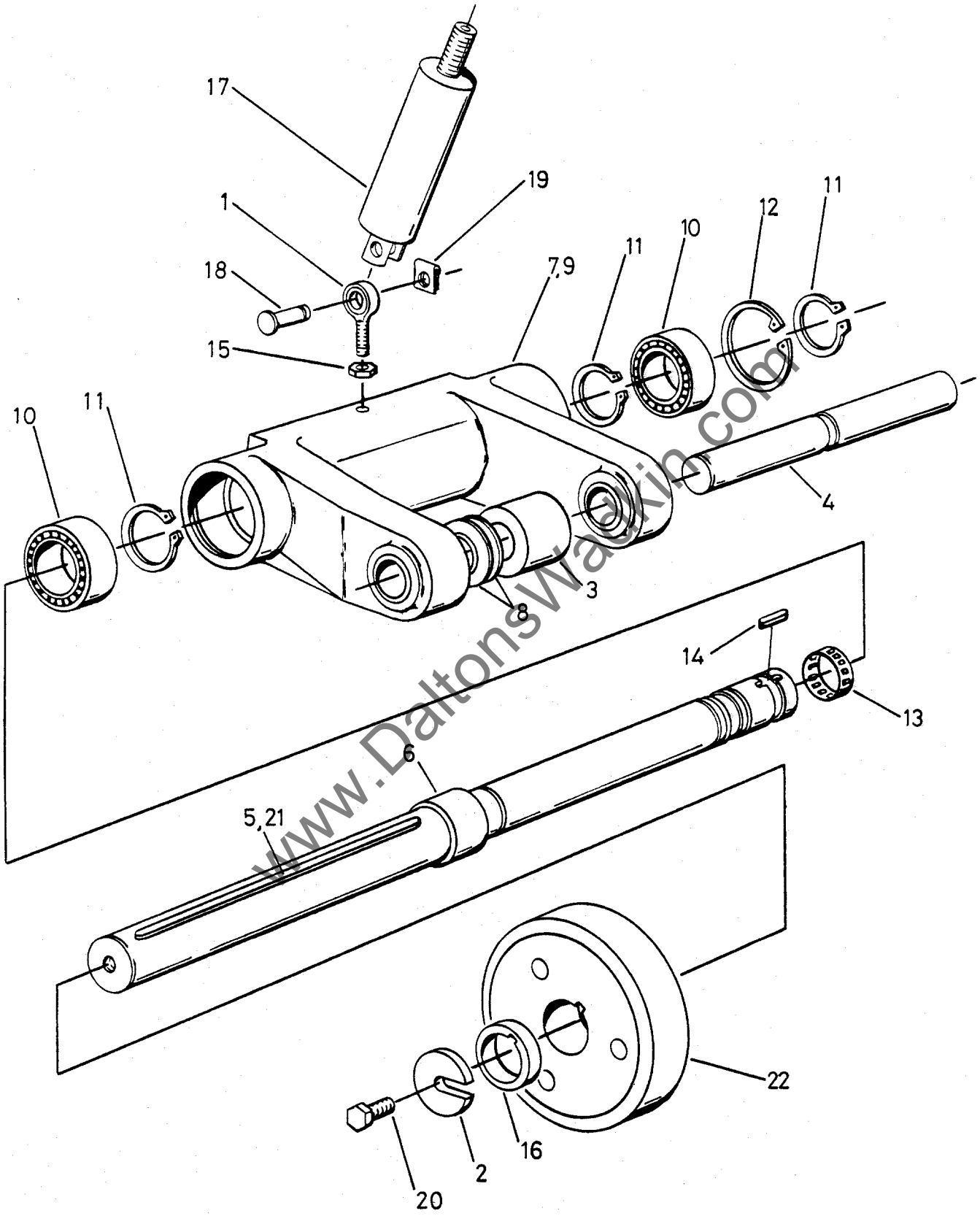


FIG 27 SHAFT MOUNTED FEEDROLL

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28. STANDARD VERTICAL SPINDLE

Ref No.	Description	No Off.
1	Spindle	1
2	Barrel	1
3	Pulley spigot	1
4	Spindle barrel nut	1
5	Spindle barrel locknut	1
6	Locking collar	1
7	Locking nut	1
8	Bearing 'RHP' ref 6009 (grease packed)	1
9	Disc spring washer 71.5mm O/D x 45.5mm I/D x 0.7mm	6
10	Key 8mm x 7mm x 40mm	1
11	Socket head capscrew M12 x 35mm long	1
12	Pulley	1
13	Bearing 'RHP' ref 6306 (grease packed)	1

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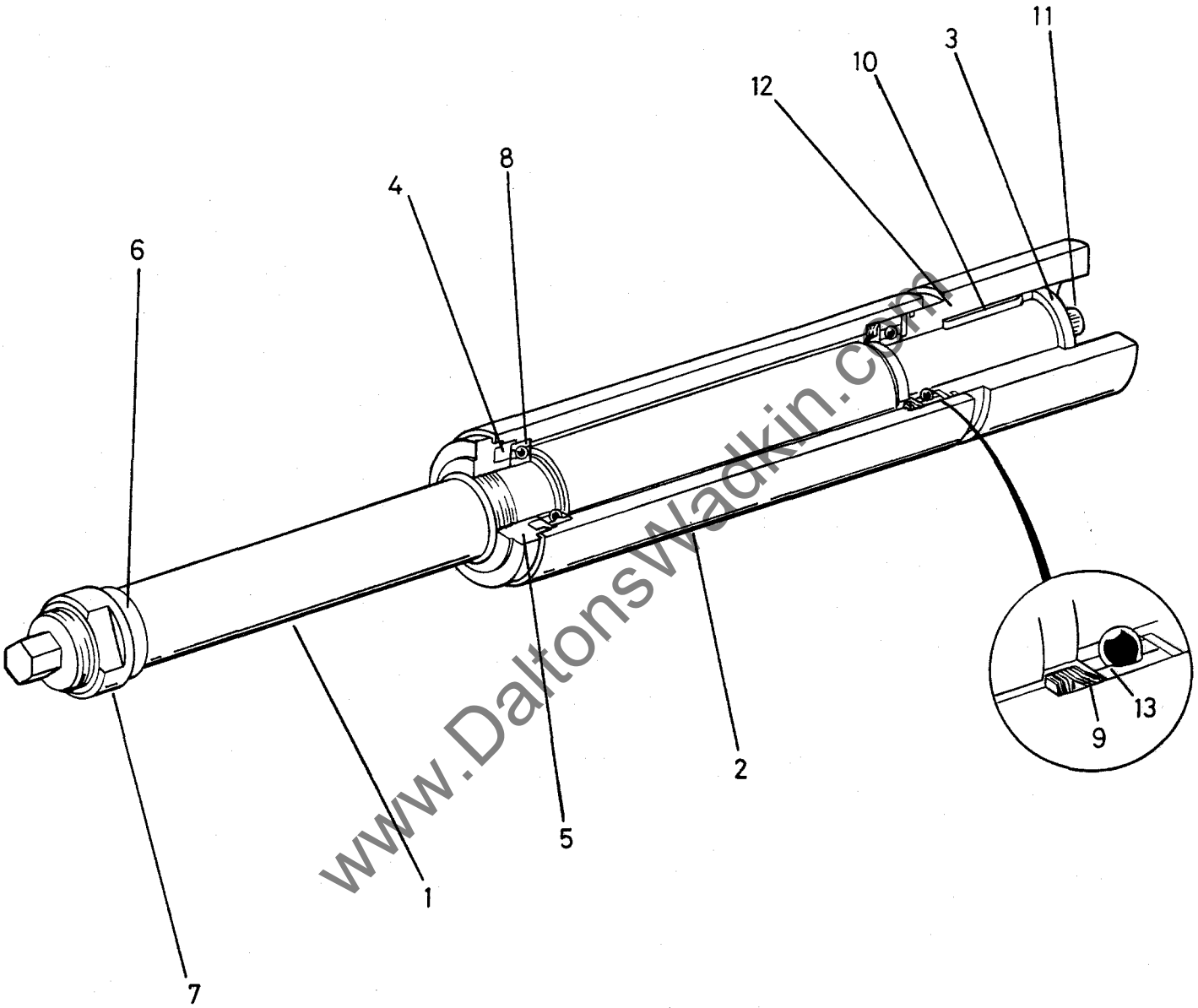


FIG 28 STANDARD VERTICAL SPINDLE

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29. STANDARD HORIZONTAL SPINDLE

Ref No.	Description	No Off.
1	Spindle	1
2	Barrel	1
3	Pulley spigot	1
4	Spindle barrel nut	1
5	Spindle barrel locknut	1
6	Locking collar	1
7	Locking nut	1
8	Bearing 'RHP' ref. 6009 (grease packed)	2
9	Disc spring washer 74.5mm O/D x 55.5mm I/D x 0.8mm	10
10	Key 14mm x 9mm x 60mm	1
11	Socket head capscrew M12 x 35mm long	1
12	Pulley	1

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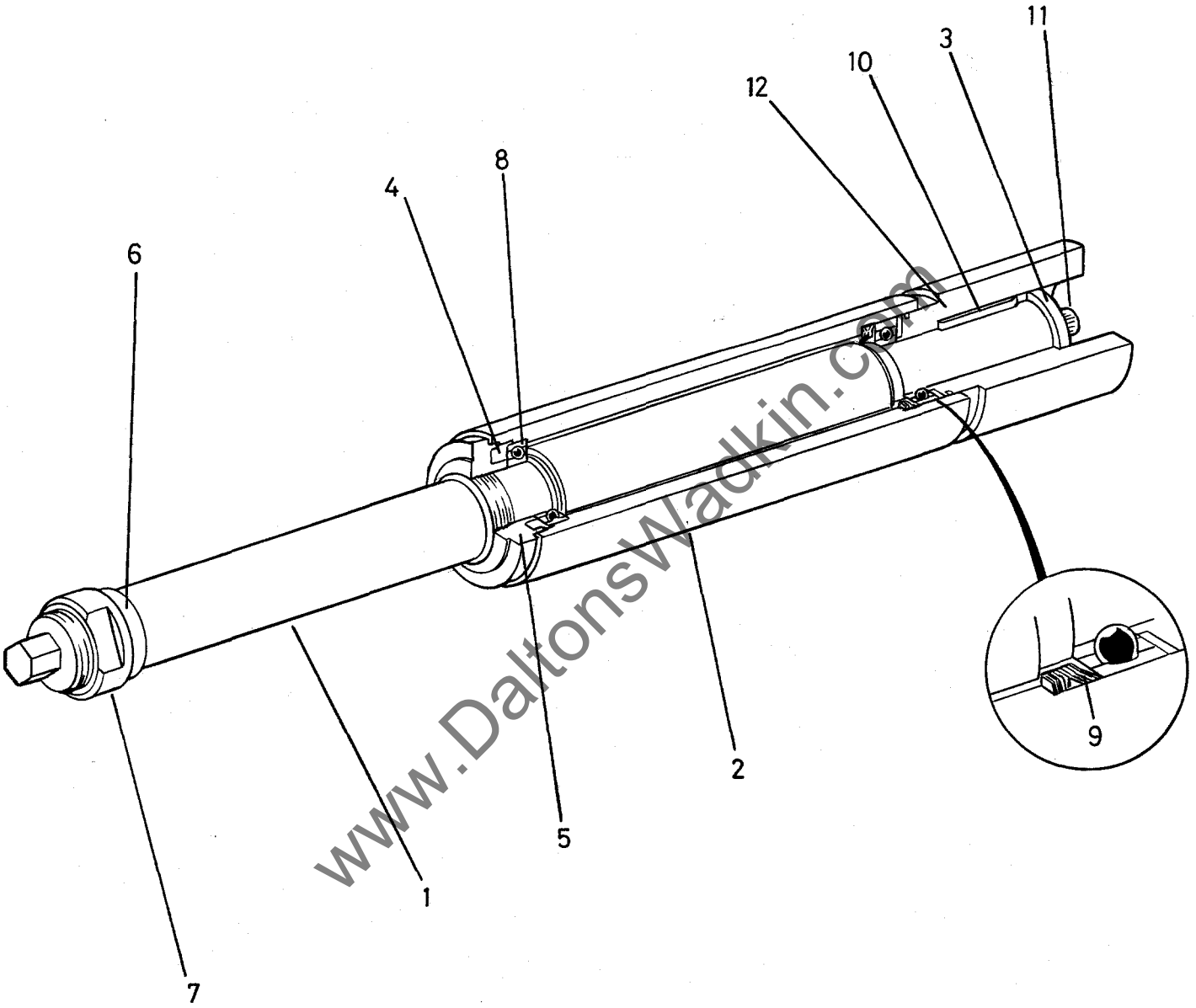


FIG 29 STANDARD HORIZONTAL SPINDLE

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30. HIGH PRECISION HORIZONTAL SPINDLE

Ref No.	Description	No Off.
1	Spindle for outboard bearing	1
2	Barrel	1
3	Pulley washer	1
4	Spindle barrel nut	1
5	Spindle barrel locknut	1
6	Locking collar	1
7	Locking nut	1
8	Bearings matched pair grease packed 'RHP' ref 7009 TDUF-EP7	2
9	Bearing spacers comprising of an inner and outer ring	2
10	Key 14mm x 9mm x 60mm	1
11	Socket head capscrew M12 x 35mm	1
12	Pulley	1

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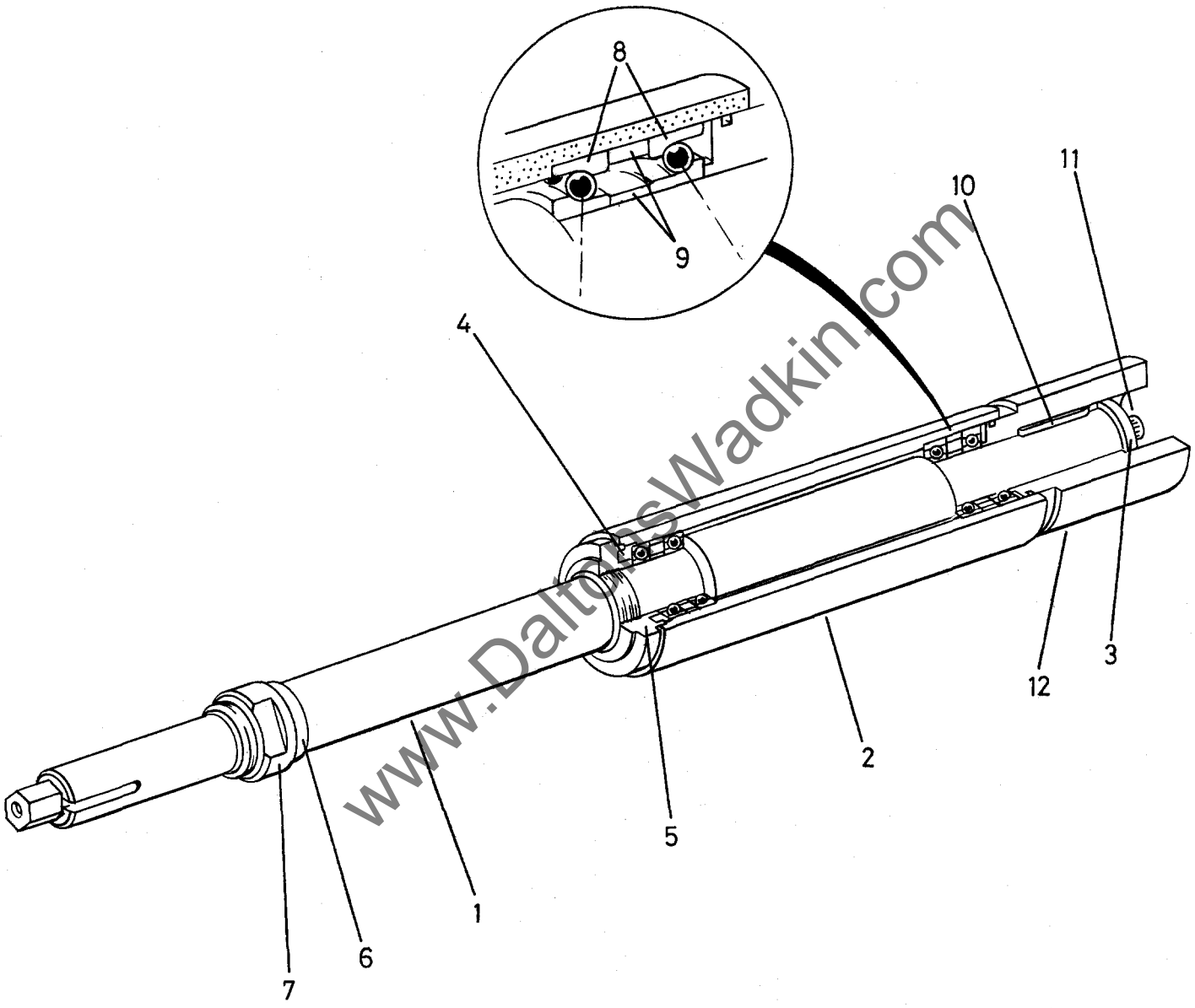


FIG 30 HIGH PRECISION HORIZONTAL SPINDLE

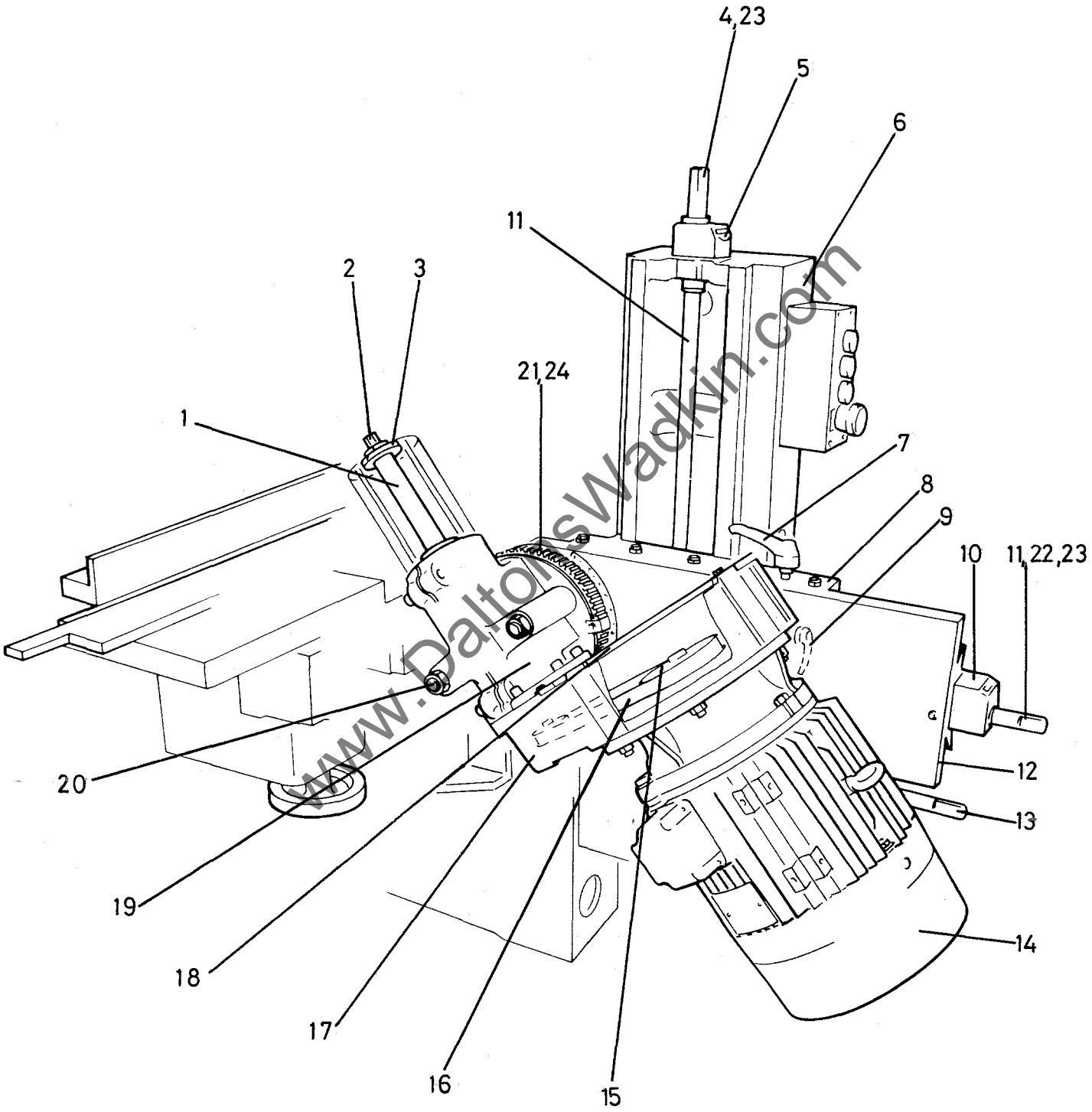
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31. UNIVERSAL HEAD ADJUSTING MECHANISM

Ref No.	Description	No Off.
1	Universal head spindle, 40mm dia. square shoulder	1
2	Locking nut	1
3	Locking collar assembly	1
4	Square end shaft extension	1
5	Digital readout (option)	1
6	Vertical slide stand	1
7	Locking handle, M10 x 50mm, male	1
8	Saddle, universal head	1
9	Locking handle	1
10	Digital readout (option)	1
11	Horizontal traverse screw	1
12	Cross slide universal head	1
13	Worm gear adjusting shaft	1
14	Electric motor	1
15	Drive pulley	1
16	Drive belt, Fenner SPZ 940	3
17	Pulley/belt housing	1
18	Pulley/belt housing cover	1
19	Spindle carriage	1
20	Bolt, spindle carriage	2
21	Wormwheel, universal head	1
22	Square end shaft extension	2
23	Taper pin No. 1	2
24	Worm gear	1

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FIG 31 UNIVERSAL HEAD ADJUSTING MECHANISM

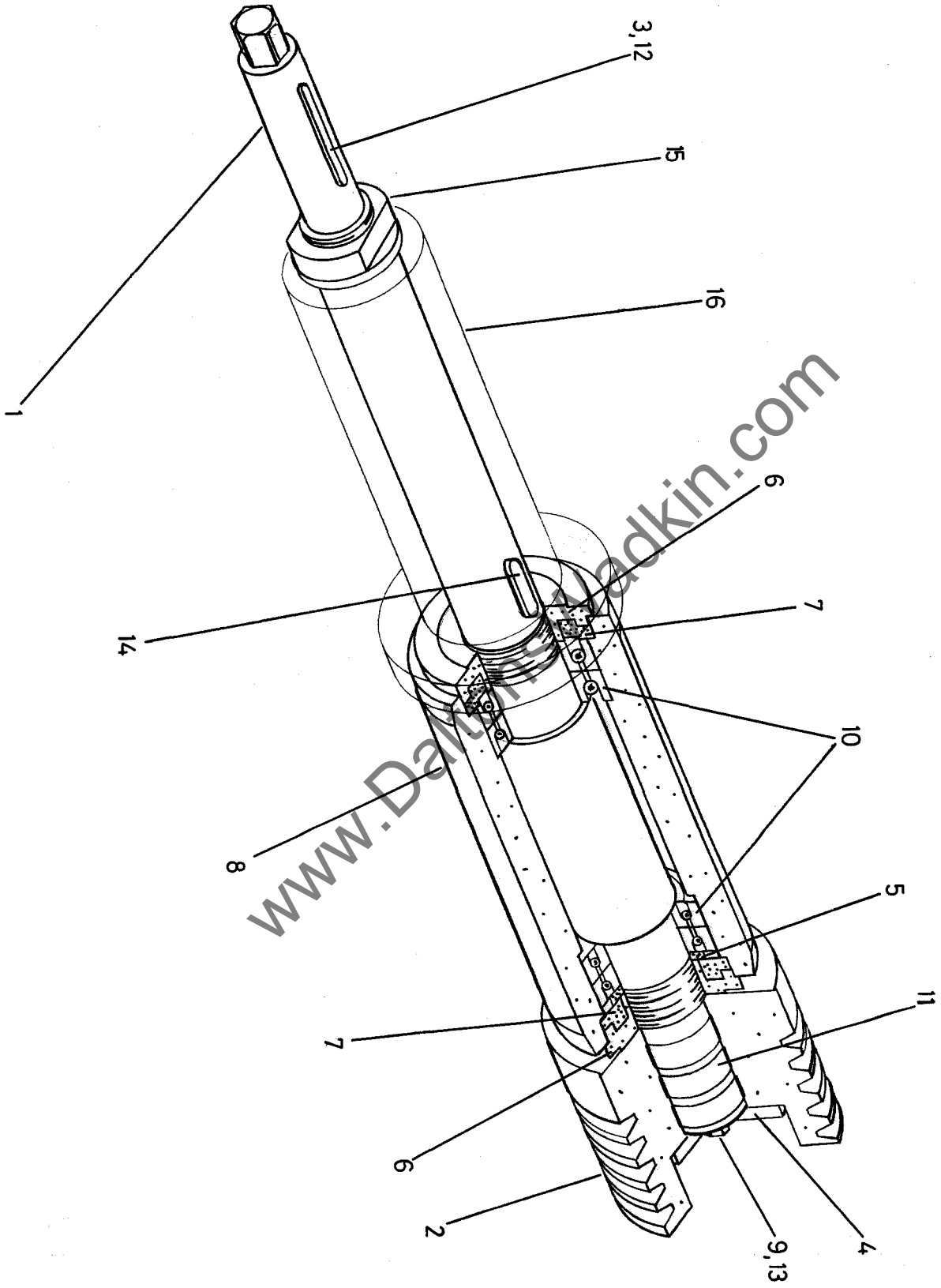
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32. UNIT 'G' SPLITTING HEAD - SPINDLE (V BELT DRIVE)

Ref No.	Description	No Off.
1	Spindle	1
2	Pulley	1
3	Key 8mm x 7mm x 80mm long	2
4	Pulley retainer/extractor	1
5	Spacer	1
6	Locknut for spindle	2
7	Locknut for spindle barrel	2
8	Spindle barrel	1
9	Hexagon socket capscrew M12 x 35mm long	1
10	Bearings 'RHP' 7011 IAU EP7	4
11	Tolerance rings 'Rencol' SV50 x 20	3
12	Hexagon socket capscrew M3 x 8mm long	2
13	Spring washer M12	1
14	Key 14mm x 9mm x 40mm long	1
15	Spindle saw sleeve locking nut	1
16	Saw sleeve	1

* Specify drive motor horse power and motor speed

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FIG 32 UNIT 'G' SPLITTING HEAD SPINDLE(V BELT DRIVE)

33. UNIT 'G' SPLITTING HEAD - SPINDLE (TIMING BELT DRIVEN)

Ref No.	Description	No Off.
1	Spindle	1
2	Pulley	1
	Key 8mm x 7mm x 80mm long	2
4	Key 12mm x 8mm x 40mm long	1
5	Spacer	1
6	Locknut for spindle	2
7	Locknut for spindle barrel	2
8	Spindle barrel	1
9	Saw sleeve	1
10	Bearings 'RHP' 7011 IAU EP7	4
11*	Taper lock bush	1
12	Hexagon socket capscrew M3 x 8mm long	2
13	Locking nut for saw sleeve	1
14	Key 14mm x 9mm x 40mm long	1

* Specify drive motor horse power and motor speed.

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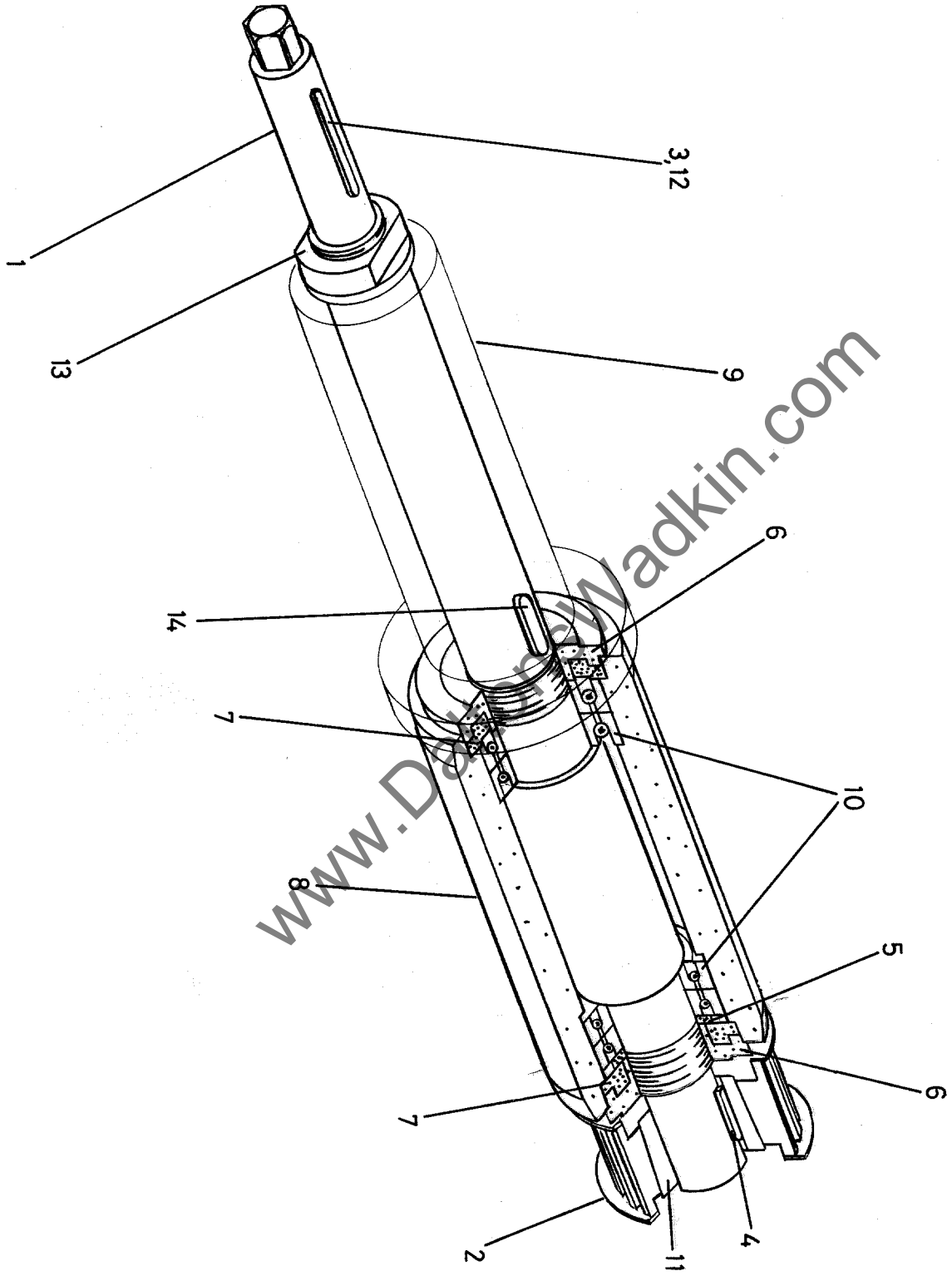
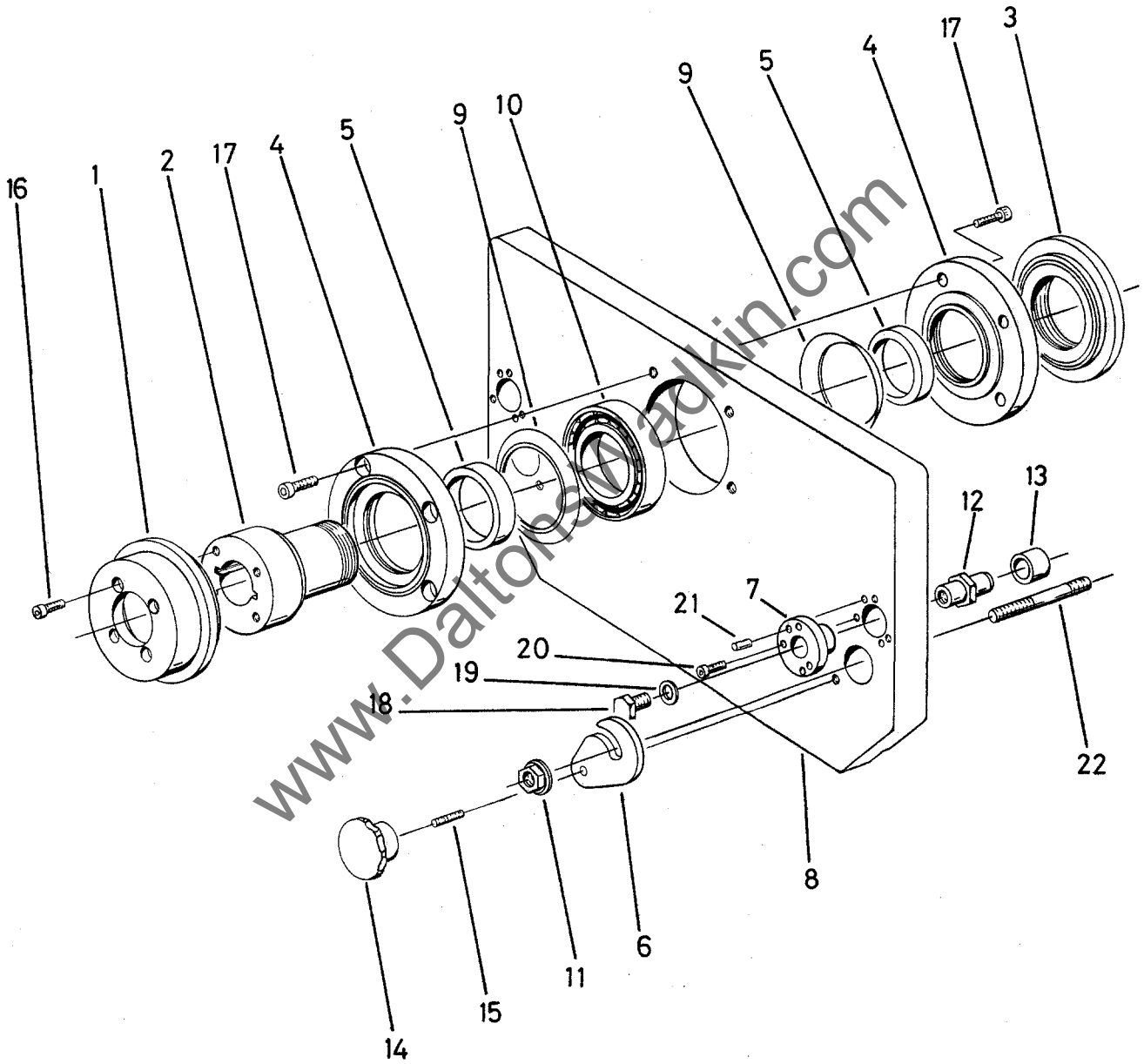


FIG 33 UNIT 'G' SPLITTING HEAD SPINDLE (TIMMING BELT DRIVE)

34. UNIT 'G' SPLITTING HEAD - OUTBOARD BEARING

Ref No.	Description	No Off.
1	Protective ring	1
2	Outboard bearing sleeve	1
3	Locknut for outboard bearing	1
4	End cap for bearing housing	2
5	Bearing spacer	2
6	'C' washer	2
7	Bush for locating pin	2
8	Housing for bearing	1
9	Disc spring	2
10	Bearing 'RHP' 6211-TB-EP7	1
11	Collar nut 'WDS' 404-204 M12	2
12	Locating pin	2
13	Locating bush	2
14	Black plastic handle M8	2
15	Grubscrew M8 x 30mm long	2
16	Hexagon socket capscrew M5 x 16mm long	4
17	Hexagon socket capscrew M6 x 12mm long	1
18	Hexagon setscrew M8 x 20mm long	2
19	Plain washer M8	2
20	Hexagon socket capscrew M6 x 20mm long	6
21	Tension pin dia. 6mm x 20mm long	4
22	Stud M12 x 70mm long	2

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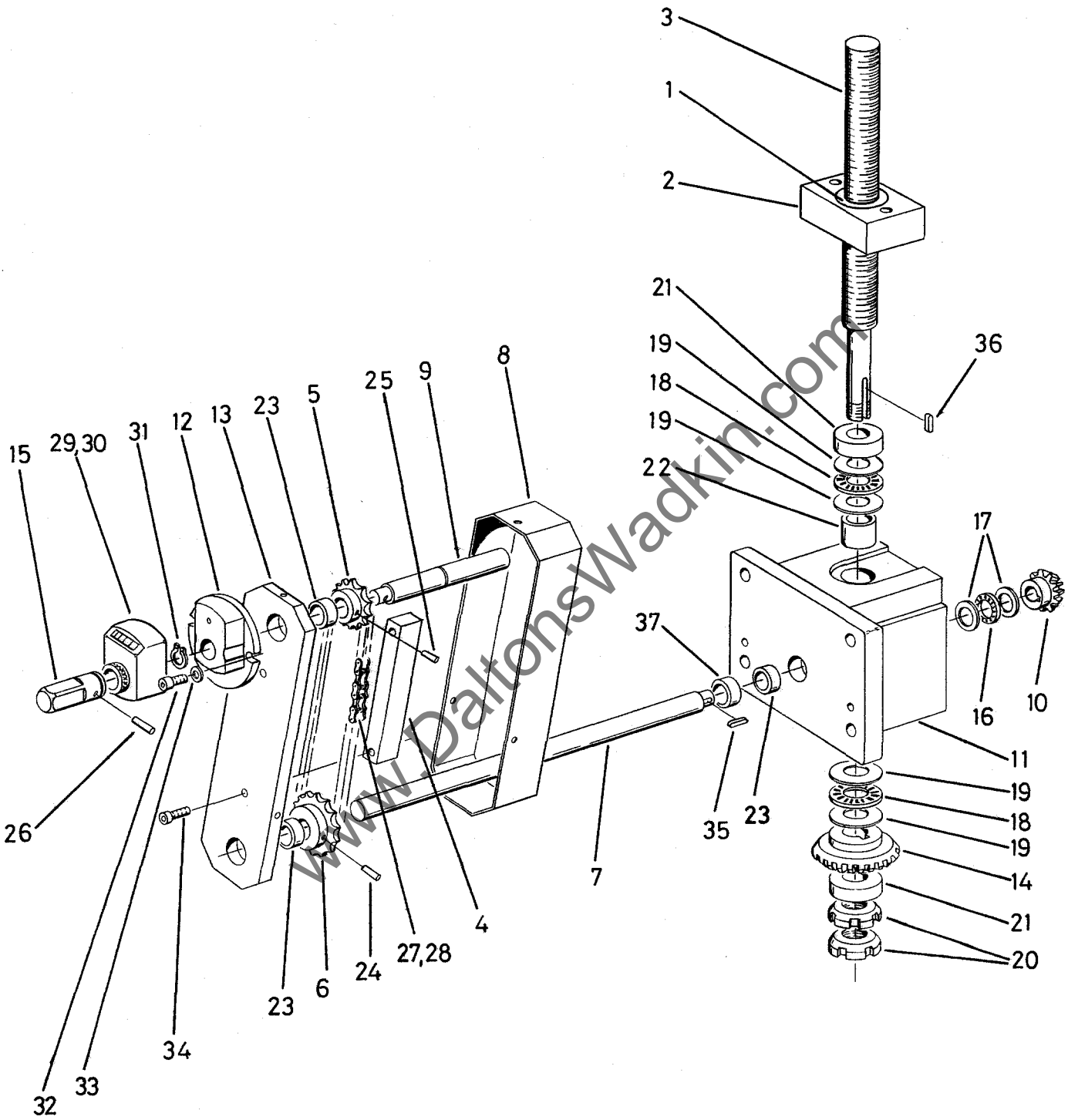
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FIG 34 UNIT 'G' SPLITTING HEAD – OUTBOARD BEARING

35. UNIT 'G' SPLITTING HEAD - VERTICAL ADJUSTMENT

Ref No.	Description	No Off.
1	Horizontal adjusting nut	1
2	Block for mounting nut	1
3	Traverse screw	1
4	Block for adjustment plate	1
5	Sprocket 12 teeth,1/2" pitch, 20mm dia. bore	1
6	Sprocket 15 teeth,1/2" pitch, 20mm dia. bore	1
7	Rise and fall shaft	1
8	Cover for chain	1
9	Rise and fall top shaft	1
10	Bevel gear	1
11	Bracket for bevel gears	1
12	Bracket for shaft bearing	1
13	Adjustment plate	1
14	Bevel gear	1
15	Shaft extension	1
16	Thrust bearing 'INA' AXK 2035	1
17	Thrust washer 'INA' AS 2035	2
18	Thrust bearing 'INA' AXK 2542	2
19	Thrust washer 'INA' AS 2542	4
20	Notch nut M24 x 1.5mm	2
21	Plain collar 40mm O/D x 25mm I/D x 16mm	2
22	Bronze bush 30mm O/D x 25mm I/D x 25mm long	1
23	Bronze bush 25mm O/D x 20mm I/D x 15mm long	3
24	Taper pin No. 3	1
25	Taper pil No. 2	1
26	Taper pin No. 1	1
27	Chain 1/2" pitch,44 pitches long	1
28	Chain connecting link	1
29	'Siko' position indicator	1
30	'O' ring 'Gaco' RM 0196-24	1
31	External circlip 20mm dia.	1
32	Hexagon socket capscrew M8 x 20mm long	2
33	Plain washer M8	2
34	Hexagon socket capscrew M8 x 60mm long	2
35	Key 5mm x 5mm x 20mm long	1
36	Key 8mm x 7mm x 14mm long	1
37	Collar 32mm O/D x 20 I/D x 14mm	1

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FIG 35 UNIT 'G' SPLITTING HEAD– VERTICAL ADJUSTMENT

36. UNIT 'G' SPLITTING HEAD - HORIZONTAL ADJUSTMENT

Ref No.	Description	No Off.
1	Spindle barrel traverse nut	1
2	Traverse screw	1
3	Bearing housing for traverse screw	1
4	Motor traverse screw	1
5	Motor traverse nut	1
6	Bearing housing for motor traverse screw	1
7	Shaft for lateral adjustment	1
8	Lateral adjustment shaft	1
9	Universal coupling and square shaft assembly	1
10	Universal coupling and square tube assembly	1
11	Bracket for adjustment shaft	1
12	Square end shaft extension	1
13	Notched nut M24 x 1.5p	2
14	Thrust washer 'INA' AS 2035	4
15	Thrust bearing 'INA' AXK 2035	2
16	Sprocket for axial adjustment	4
17	Chain 1/2" pitch, 49 pitches long	1
18	Connecting link	2
19	Chain 1/2" pitch, 41 pitches long	1
20	External circlip dia. 20mm	3
21	Bronze bush 25mm O/D x 20mm I/D x 15mm long	2
22	Bronze bush 25mm O/D x 20mm I/D x 25mm long	1
23	'Sixo' position indicator	1
24	'O' ring 'Gaco' RM 0196-24	1
25	Taper pin No. 1	5
26	Hexagon socket capscrew M8 x 20mm long	2
27	Plain washer M8	2
28	Hexagon locknut M16	2
29	Thrust washer 'INA' AS 1730	3
30	Shaft washer 'INA' WS 81103	1
31	Thrust bearing 'INA' AXK 1730	2
32	Hexagon socket capscrew M6 x 16mm long	4
33	Bronze bush 20mm O/D x 16mm I/D x 16mm long	1

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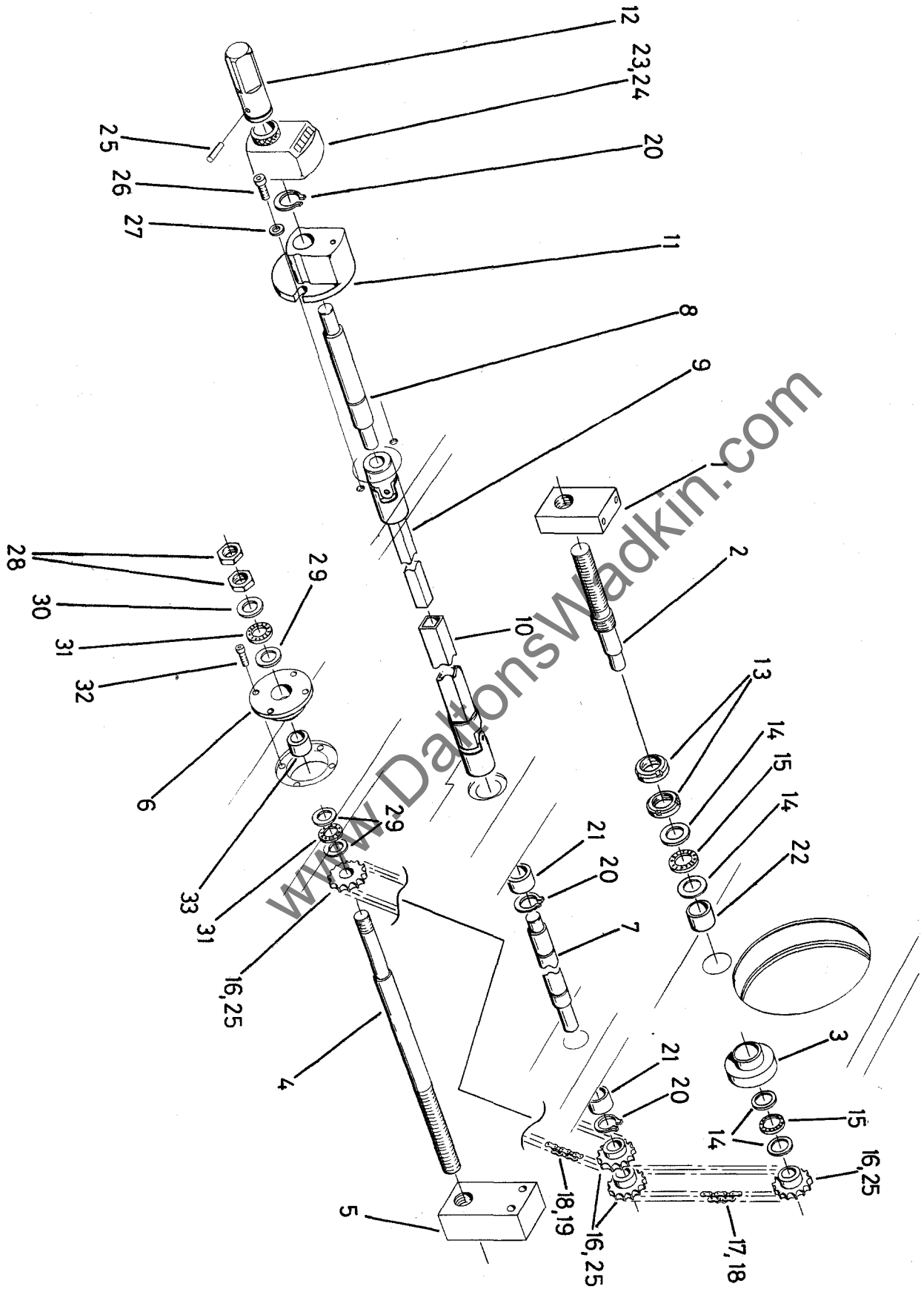


FIG 36 UNIT 'G' SPLITTING HEAD – HORIZONTAL ADJUSTMENT

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37. UNIT 'G' SPLITTING HEAD-TOP PAD PRESSURE AND RIVING KNIVES

Ref No.	Description	No Off.
1	Screw for pressure slide	1
2	Bracket for mounting top pressure	1
3	Nut for splitting saw motor plate	1
4	Slide	1
5	Strip for jacking pressure slide	1
6	Strip for pressure slide	2
7	Stop for pressure bracket	1
8	Block for pressure pad	1
9	Plate for mounting pressure pad	1
10	Pressure pad	1
11	Bracket for top pressure	1
12	Mounting block for riving knife carrier	20
13	Stud for mounting riving knives	4
14	Riving knife	10
15	Carrier for riving knife	10
16	Hexagon socket capscrew M6 x 30mm long	20
17	Hexagon socket countersunk screw M4 x 10mm long	30
18	Plain washer M12	12
19	Spring washer M12	8
20	Plain nut M12	8
21	Stud M12 x 40mm long	4
22	Loose collar 28mm O/D x 16mm I/D x 12mm long	2
23	Taper pin no. 2	2
24	Bronze headed bush 22mm O/D x 16mm I/D x 12mm long	2
25	Hexagon socket capscrew M6 x 12mm long	4
26	Hexagon socket capscrew M8 x 25mm long	12
27	Hexagon socket grubscrew M6 x 30mm long	3
28	Locknut M6	3
29	Hexagon set screw M8 x 50mm long	2
30	Hexagon set screw M8 x 16mm long	2
31	Hexagon set screw M12 x 30mm long	2

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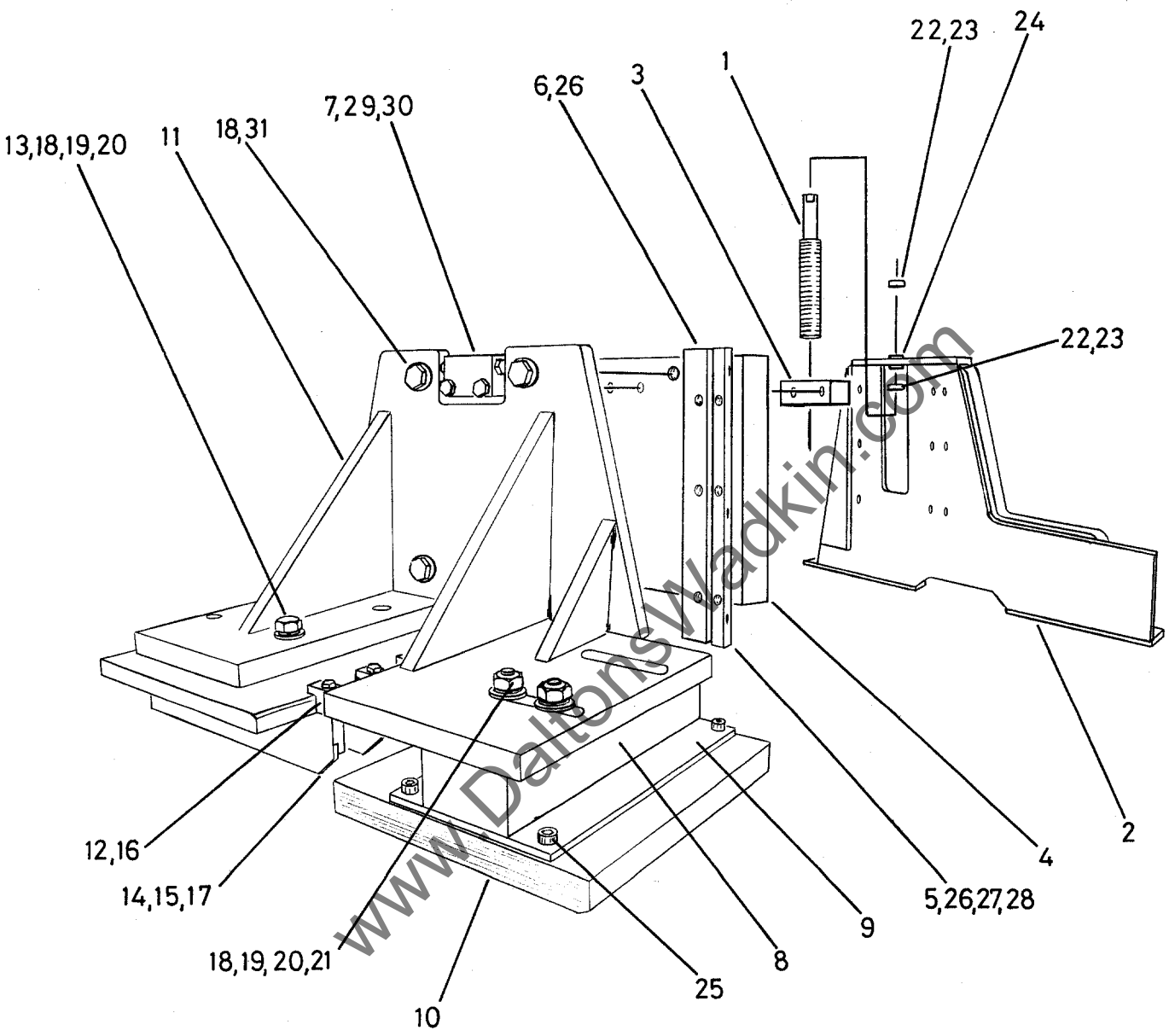


FIG 37 UNIT 'G' SPLITTING HEAD – TOP PAD PRESSURE AND RIVING KNIVES

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38. UNIT 'G' SPLITTING HEAD - ANTI-KICK BACK FINGERS

Ref No.	Description	No Off.
1	Plate for anti-kick back finger frame	2
2	Bar for anti-kick frame	1
3	Shaft for finger pivot	1
4	Plate for mounting anti-kick fingers	1
5	Fingers	57
6	Ball knob M12	1
7	Thrust washer 'INA' AS 2035	58
8	Stud M12 x 65mm long	1
9	Notch nut M20 x 1.5p	2
10	Locknut M16	4
11	Plain washer M16	4
12	Hexagon socket capscrew M16 x 40mm long	2
13	Black plastic handle M8	1
14	Stud M8 x 70mm long	1

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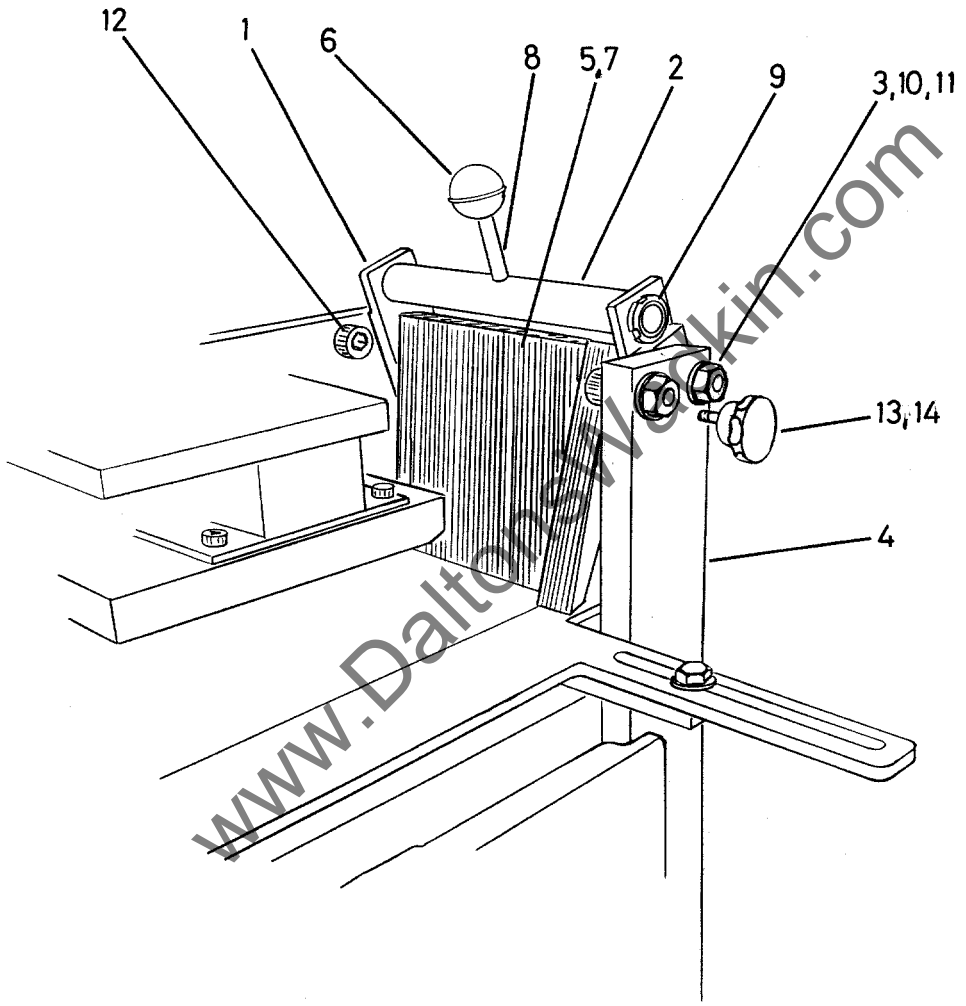


FIG 38 UNIT 'G' SPLITTING HEAD - ANTI KICK BACK FINGERS

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39. UNIT 'G' SPLITTING HEAD-CHAIN TENSIONER TO HORIZONTAL SPINDLE

Ref No.	Description	No Off.
1	Chain tensioner	1
2	Bar for chain tensioner	1
3	Pin	1
4	Hexagon nut M12	1
5	Plain washer M12	3
6	Nyloc nut M12	2
7	Setscrew and washer (one of the four motor mounting plate screws)	
8	Stud M12 x 65mm long	1

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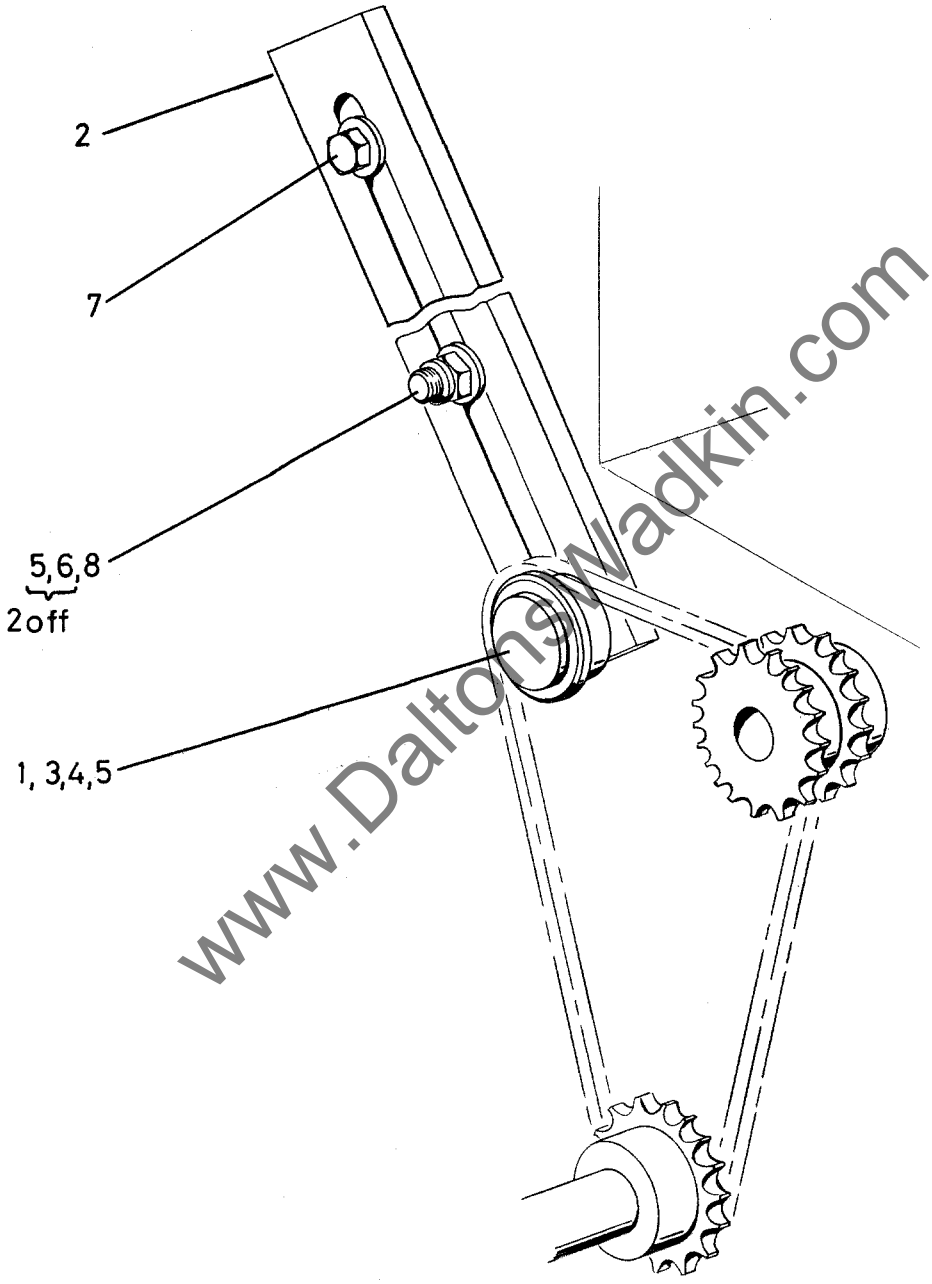


FIG 39 UNIT 'G' SPLITTING HEAD - CHAIN TENSIONER (HORIZONTAL SPINDLE)

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40 INTERMEDIATE FEED ROLL

Ref No.	Description	No Off.
1	Pivot bracket (specify left hand as illustration or right hand)	1
2	Pivot arm	1
3	Cylinder bracket	1
4	Tension pin (stop pin)	1
5	Shoulder screw	1
6	Handwheel	1
7	Taper pin No. o	1
8	Plunger	1
9	Plunger body (loctite into pivot arm)	1
10	Bush 30mm I/D x 35mm O/D x 20mm long	1
11	Chamfered notch nut	2
12	'Schrader' single acting cylinder ref I X B 4726C	1
13	Rubber washer (supplied with cylinder)	2
14	Steel washer (supplied with cylinder)	1
15	Nyloc nut (supplied with cylinder)	1
16	Pivot pin (supplied with cylinder)	1
17	Retaining clip for pivot pin (supplied with cylinder)	1
18	Eye bolt	1
19	Nut M12	1
20	Steel serrated feed rolls	2
21	Shaft	1
22	Rear bearing housing	1
23	Front bearing housing	1
24	Drive gear	2
25	Idler gear	1
26	Feedroll shaft	1
27	Bearing 'RHP' ref. 16010	4
28	Bearings 'RHP' ref. 16006	2
29	Spacers for feed rolls (specify width)	
30	'C' washer	2
31	Hexagon head setscrew M12 x 30mm long	2
32	M12 washer	2
33	Key 10mm x 8mm x 115mm long	2
34	Hexagon socket countersunk screw M4 x 12mm long	4
35	Shaft mounted feedroll swing	1
36	Cover for feed rolls (not illustrated)	1
37	Block spacer for cover (not illustrated)	2

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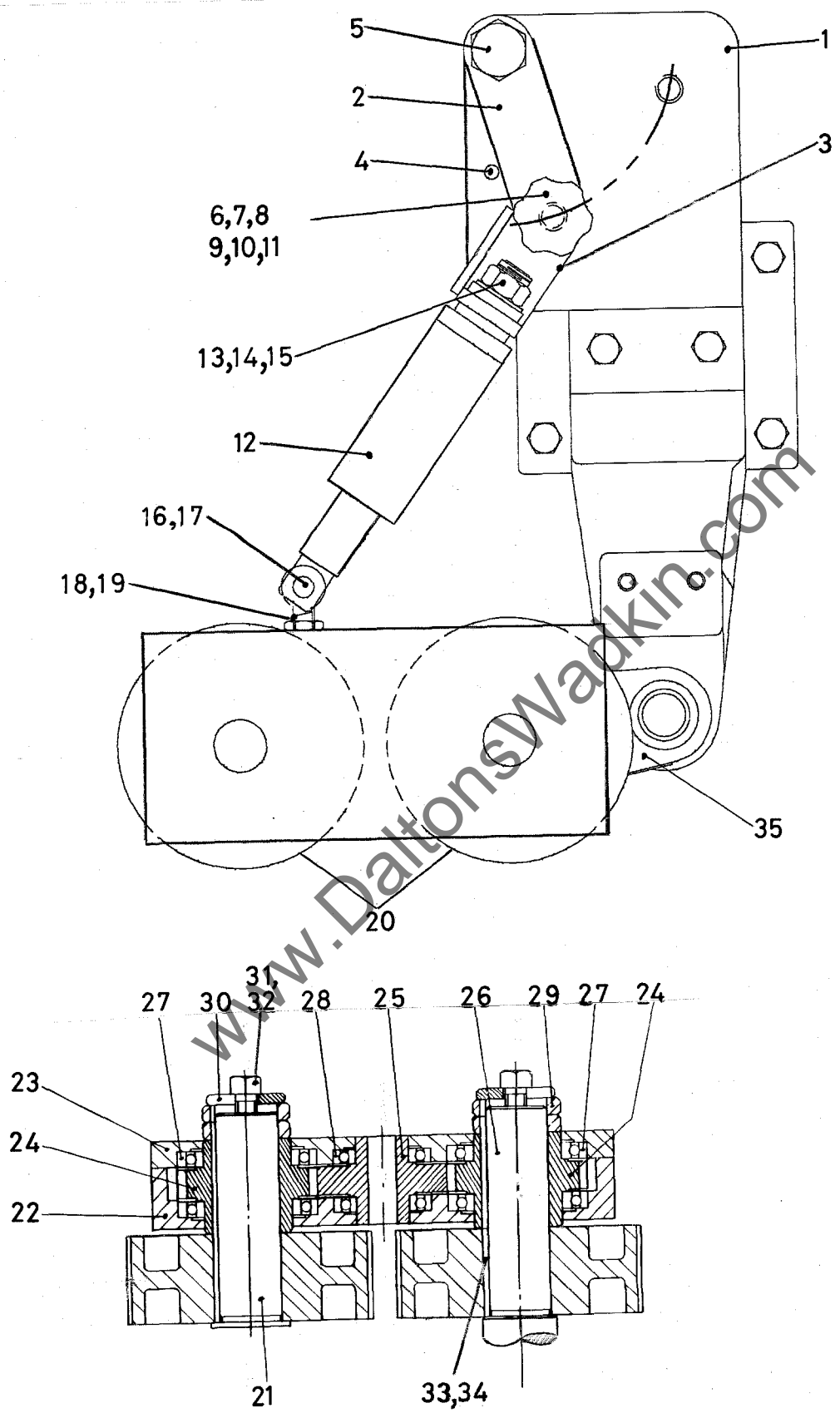


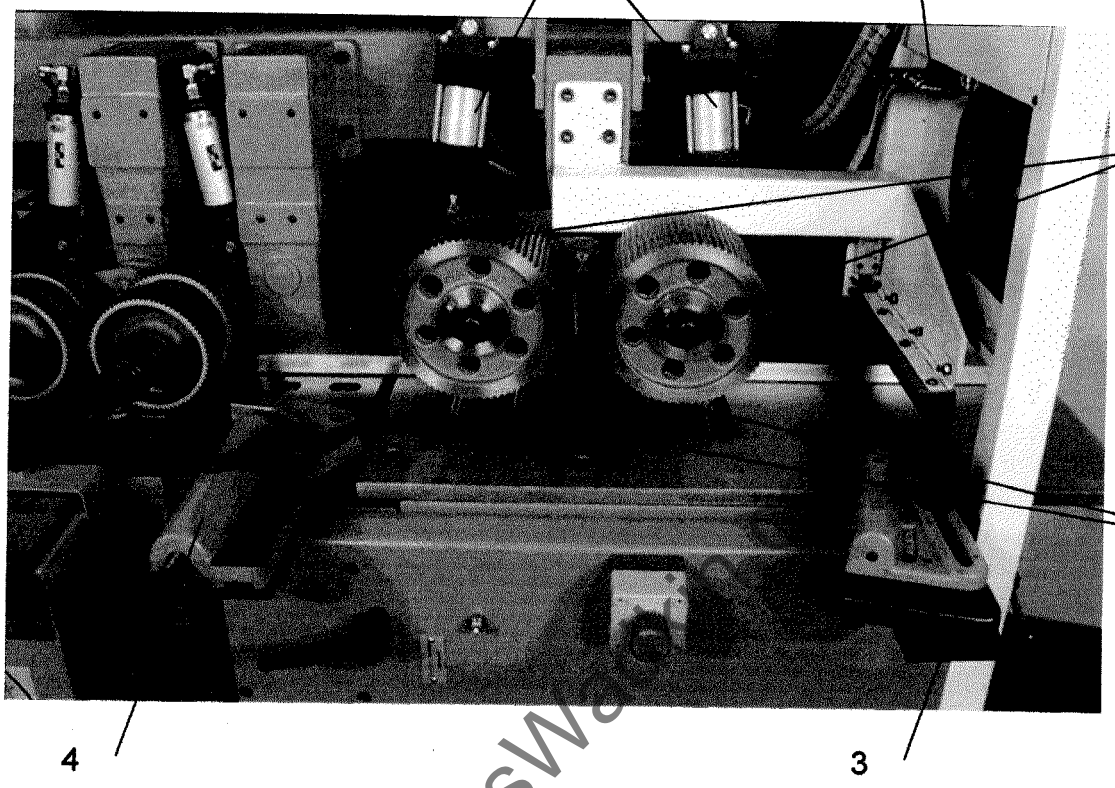
FIG 40 INTERMEDIATE FEED ROLL

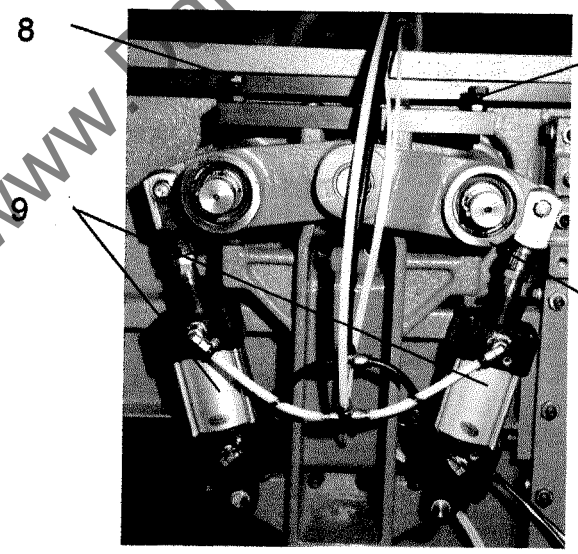
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41 PUSH FEED SYSTEM

Ref no.	Description	No. off
1	Top Roller	2
2	Bottom Roller	2
3	Side Skid Pressure Roller	1
4	Side Pressure Roller	1
5	Top Cylinder	2
6	Air Switch	1
7	Set Screw (Bottom) (Factory Set)	2
8	Set Screw (Top) (Factory Set)	2
9	Air Cylinder	2

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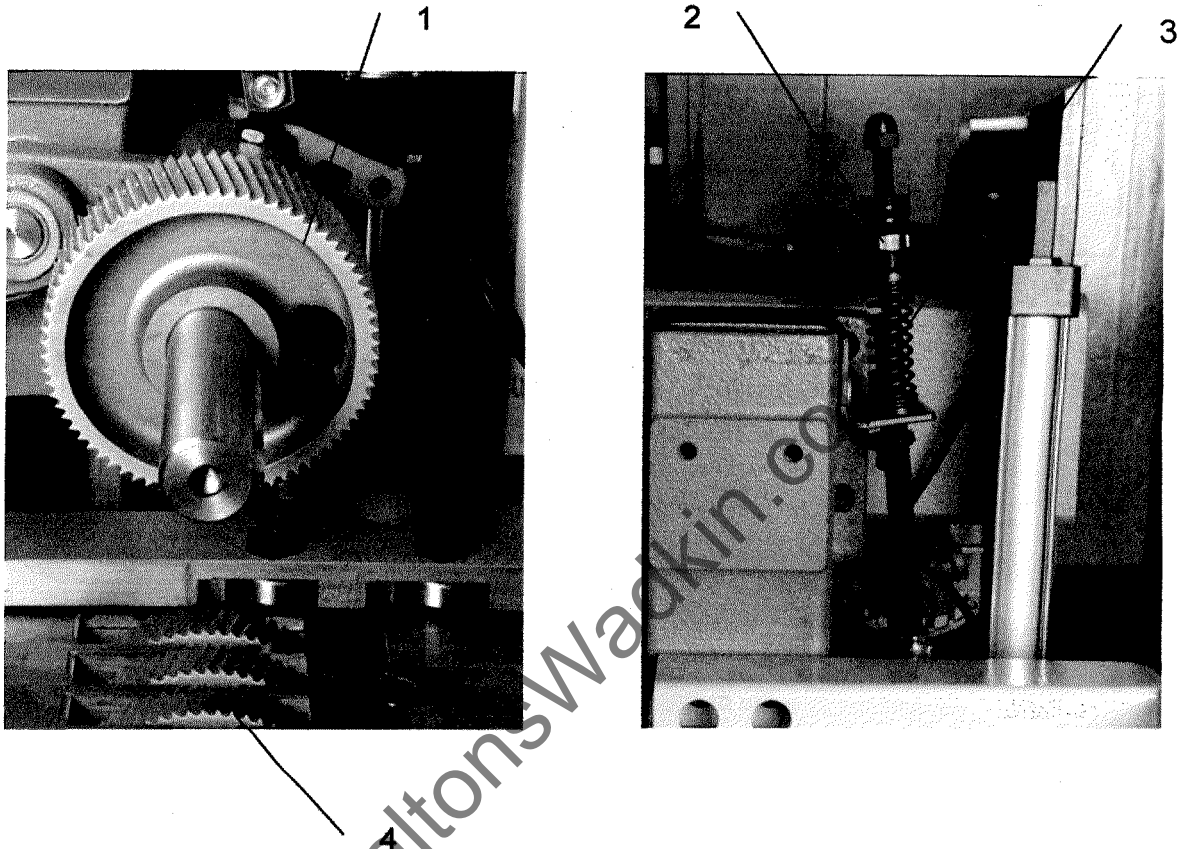
REAR VIEW

FIG 41 PUSH FEED SYSTEM

42 INFEED NIP DRIVEN ROLLER SYSTEM

Ref No.	Description	No. Off
1	Pneumatically-controlled top feed rolls	3
2	Adjusting nut	1
3	Compression spring	1
4	Pneumatically-controlled bottom feed rolls	3
5	Selector switch (not shown)	1
6	Regulator (not shown)	1

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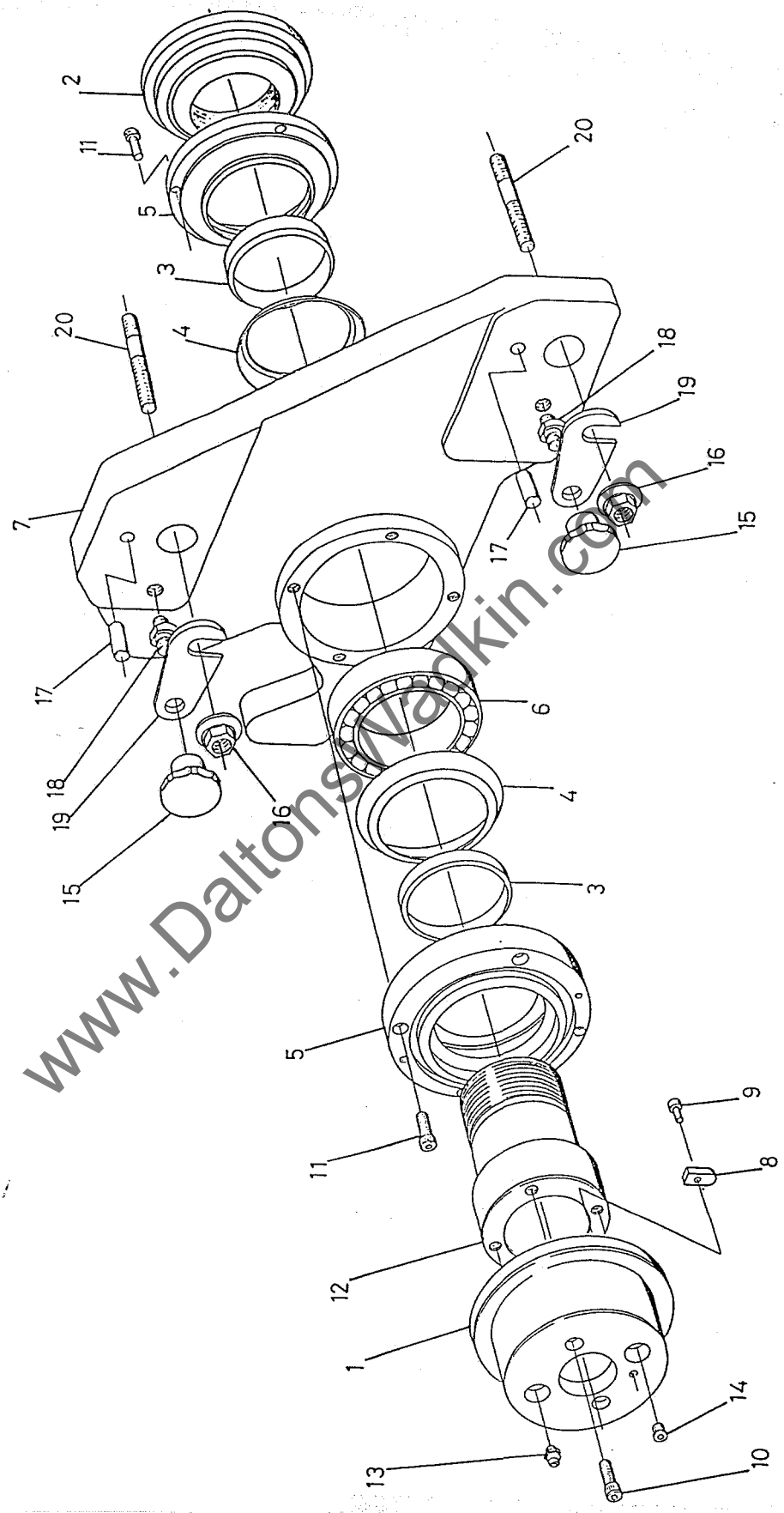
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FIG 42 INFEED NIP DRIVEN ROLLER SYSTEM

43 XE E-UNIT (OUTBOARD BEARING TOP HEAD)

Ref. No.	Description	No Off
1	Protective ring for hydrogrip sleeve	1
2	Locknut for outboard bearing	1
3	Bearing spacer	2
4	Disc spring 99mm O/D x 70.5mm I/D x 1mm	2
5	End cap for outboard bearing housing	1
6	R.H.P. grease packed bearing 6211-TB-EP7	1
7	Outboard bearing housing	1
8	Drive key	1
9	Hexagon socket capscrew M3 x 12mm long	1
10	Hexagon socket capscrew M5 x 12mm long	2
11	Hexagon socket cap screw M6 x 12mm long	8
12	ETP sleeve (less front plate)	1
13	Grease nipple) Items only supplied	1
14	Pressure release valve) With E.T.P. sleeve	1
15	Hand wheel M8 threaded	2
16	Collar nut WDS 404-204 M12	2
17	Taper dowel 12 x 40	2
18	Shoulder screw	2
19	'C' washer	2
20	Stud M12 x 70mm long	2

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FIG 43 XE E-UNIT (OUTBOARD BEARING TOP HEAD)

43 XE E-UNIT (TOP HEAD PAD PRESSURE)

Ref. No.	Description	No. Off
1	Cover for top head pressure spring	1
2	Nut for top head pressure adjustment	1
3	Pointer support first top head	1
OR	pointer support second top head	1
4	Wear strip	1
5	Saddle for top head pressure	1
6	0-130mm Metric scale	1
7	Pointer	1
8	Screw for top head pressure adjustment	1
9	Bracket for mounting top head pressure pad	1
10	Cross tenon	1
11	Slide for top head pressure	1
12	Hexagon head setscrew	4
13	Hexagon socket grubscrew M6 x 6mm long	1
14	Hexagon socket capscrew M10 x 16mm long	2
15	Hexagon socket capscrew M10 x 50mm long	2
16	Hexagon socket capscrew M6 x 10mm long	2
17	Compression spring 'Flexo' 283816	1
18	Thrust washer 'INA' AS 1226	2
19	Locknut M12	2
20	Taper pin	2
21	Handwheel M12	1
22	Helicoil insert M12	1
23	Tee nut WDS 664203	2
24	Stud M10 x 55mm long	2
25	Nut M10	2
26	Plain large washer M10	2
27	Hexagon socket capscrew M8 x 20mm long	2
28	Collar	1
29	Pad pressure shoe — for machine with one top head only	
OR	Pad pressure shoe for splitting/counter profiling — for machine with one top head only	
OR	Pad pressure shoe — for machine with two or more top heads	
	Pad pressure shoe for Ø 125 cotting circle — for machine with two or more top heads	
OR	Pad pressure shoe for soft pads (optional)	

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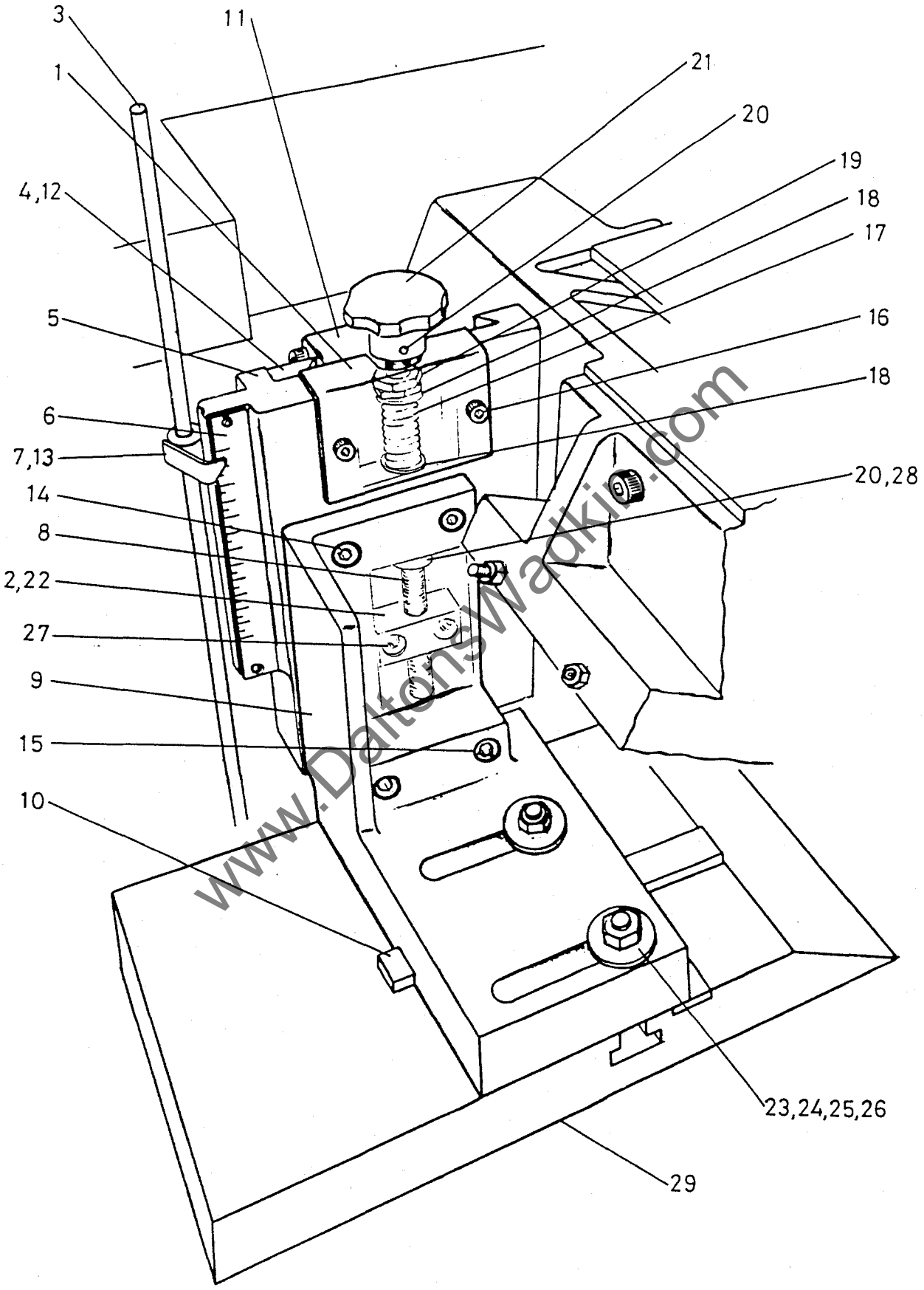


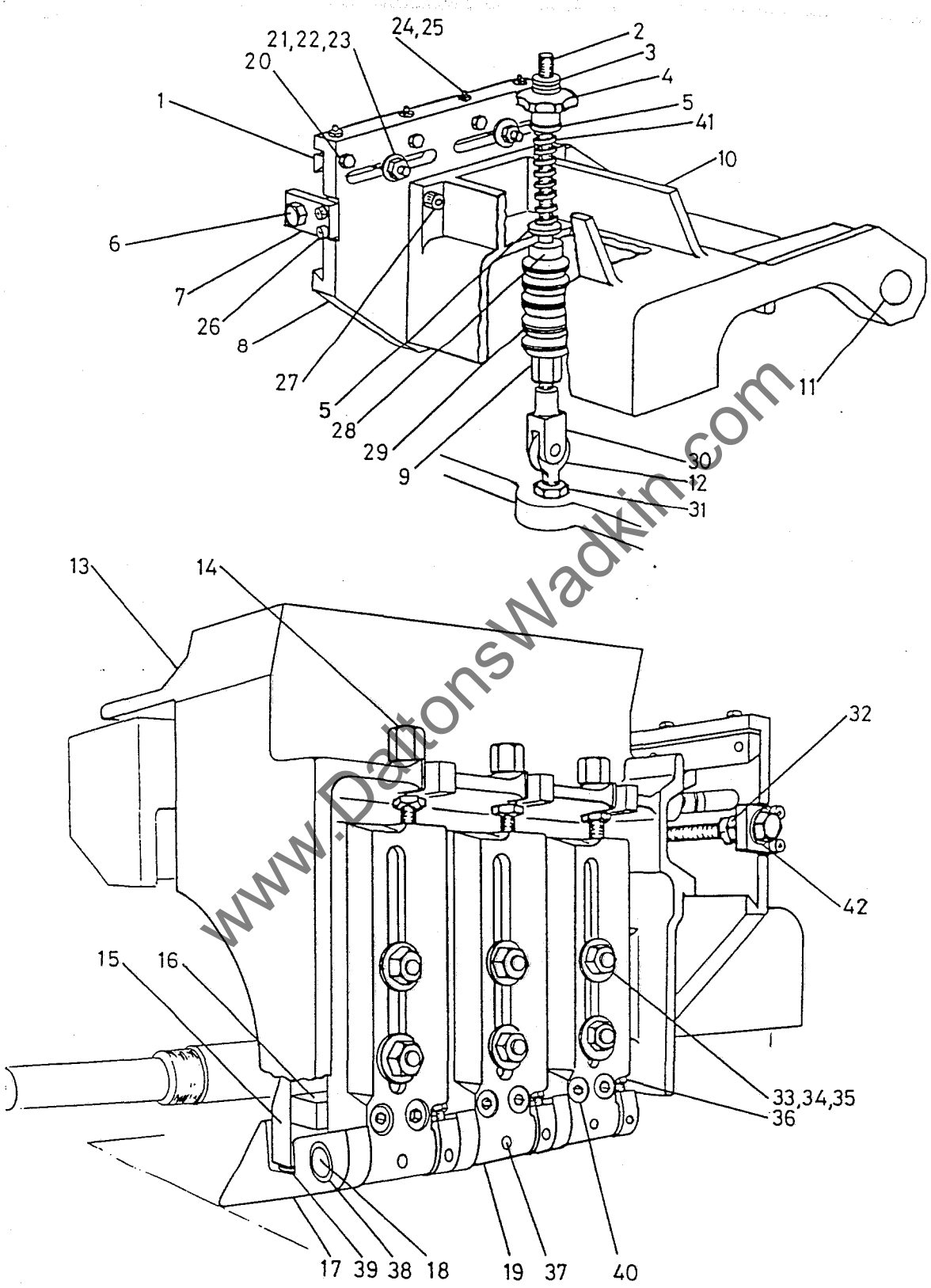
FIG 43 XE E-UNIT (TOP HEAD PAD PRESSURE)

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43 XE E-UNIT (TOP HEAD CHIPBREAKER)

Ref. No.	Description	No. Off
1	Wear strip	1
2	Screw	1
3	Thumb nut WDS 614-204	1
4	Hand knob	1
5	Cap for tension spring	2
6	Adjusting screw	1
7	Plate for adjusting screw	1
8	Swing for chipbreaker (front)	1
9	Stop for top head chipbreaker	1
10	Swing for chipreaker (rear)	1
11	Shaft for chipbreaker pivot	1
12	Eye bolt	1
13	Hod for chipbreaker carrier	1
14	Adjusting screw for top chipbreaker	3
15	Baffle/spring housing	3
16	Block for spacing baffle	3
17	Shoe for chipbreaker	3
18	Pin of chipbreaker shoe pivot	3
19	Bracket for mounting chipbreaker shoe	3
20	Hexagon head setscrew M8 x 20mmlong	4
21	Stud M12 x 50mm long	2
22	Large washer M12	2
23	Nut M12	2
24	Hexagon head grubscrew M6 x 20mm long	4
25	Locknut M6	4
26	Hexagon socket capscrew M6 x 16mm long	2
27	Hexagon socket capscrew M12 x 30mm long	4
28	Collar 40mm OD x 25mm ID x 16mm wide	1
29	Disc springs 50mm OD x 25.4mm ID x 1.5	10
30	Rod clevis festo SG M12	1
31	Nut M12	1
32	Lock screw M12	2
33	Stud M12 x 65mm long	6
34	Washer M12	6
35	Nut M12	6
36	Hexagon head setscrew M6 x 30mm long	3
37	Hexagon socket grubscrew M6 x 10mm long	3
38	Oilite bronze bush 20mm OD x 16mm ID x 12mm long	6
39	Compression spring	1
40	Hexagon socket capscrew M10 x 60mm long	6
41	Compresion sping 135mm long x 28.2 OD x 21.8 ID	1
42	Thrust washer INA AS 1226	2

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FIG 43 XE E-UNIT (TOP HEAD CHIPBREAKER)

43 XE E-UNIT (OUTBOARD BEARING SECOND BOTTOM HEAD)

Ref. No.	Description	No Off
1	Protective ring for hydrogrip sleeve	1
2	Locknut for outboard bearing	1
3	Bearing spacer	2
4	Disc spring 99mm O/D x 70.5mm I/D x 1mm	2
5	End cap for outboard bearing housing	1
6	R.H.P. grease packed bearing 6211-TB-EP7	1
7	Outboard bearing housing	1
8	Drive key	1
9	Hexagon socket capscrew M3 x 12mm long	1
10	Hexagon socket capscrew M5 x 12mm long	2
11	Hexagon socket cap screw M6 x 12mm long	8
12	ETP sleeve (less front plate)	1
13	Grease nipple) Items only supplied	1
14	Pressure release valve) With E.T.P. sleeve.	1
15	Hand wheel M8 threaded	2
16	Collar nut WDS 404-204 M12	2
17	Taper dowel 12 x 40	2
18	Shoulder screw	2
19	'C' washer	2
20	Stud M12 x 70mm long	2

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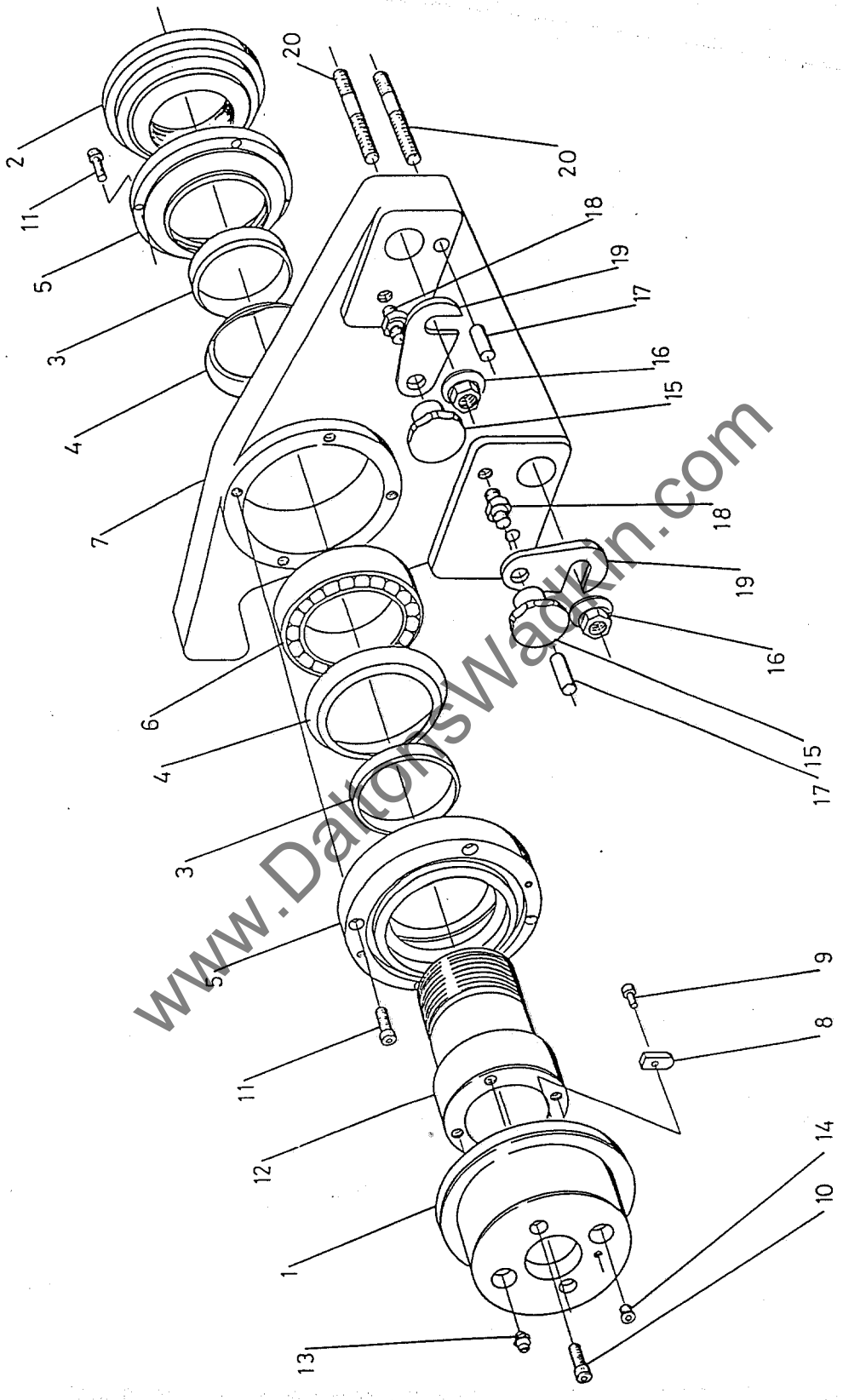


FIG 43 XE E-UNIT (OUTBOARD BEARING SECOND BOTTOM HEAD)

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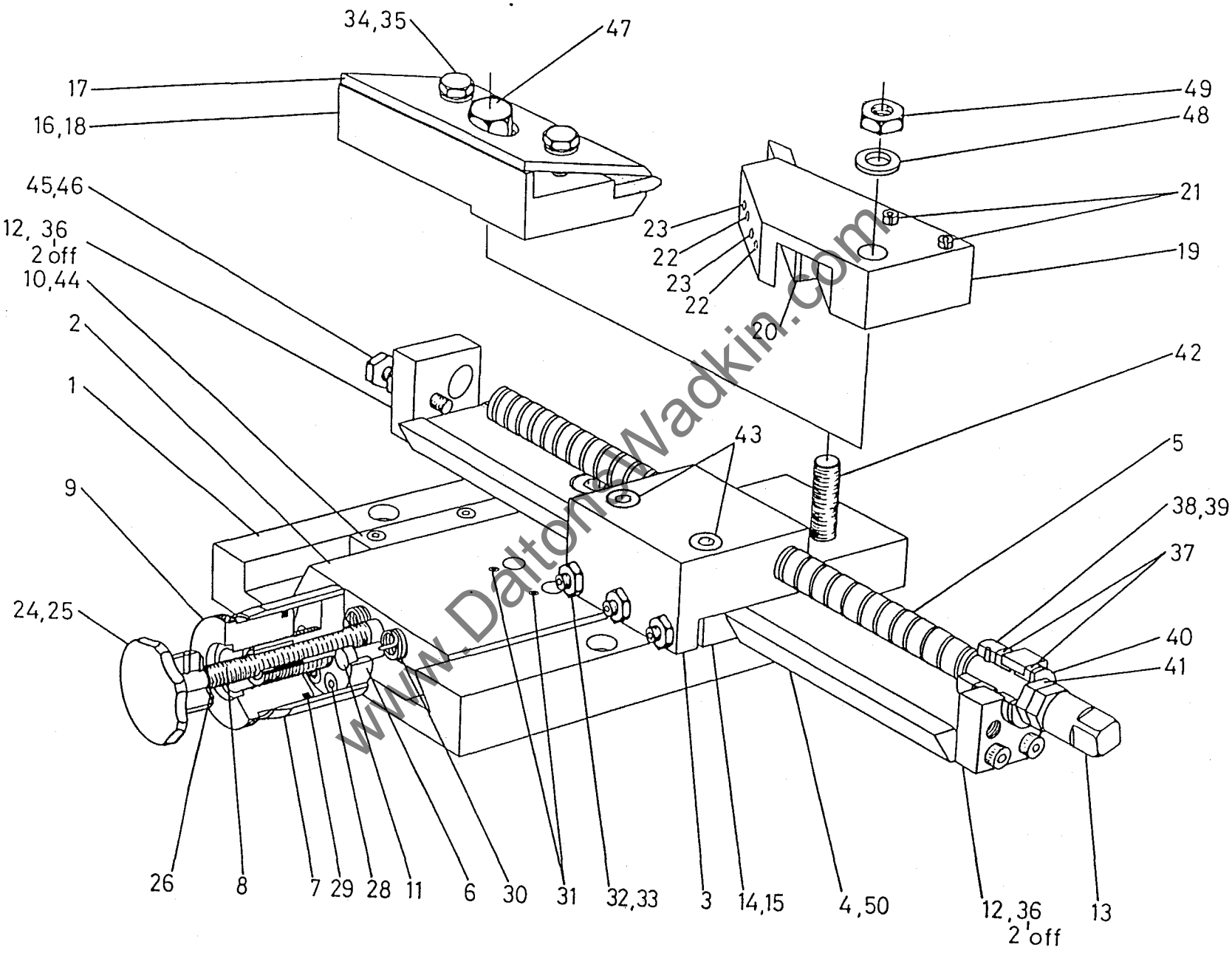
43 XE E-UNIT (SECOND BOTTOM HEAD JOINTER)

Ref. No.	Description	No. Off
1	Slideway for bottom head jointer feed	1
2	Slide for bottom head jointer feed	1
3	Saddle for bottom head jointer	1
4	Slide for bottom head jointer traverse	1
5	Screw for horizontal jointer traverse	1
6	Nut for jointer feed	1
7	Sleeve for jointer feed	1
8	Screw for jointer feed	1
9	Dial for jointer adjustment	1
10	Jointer feed slide strip	1
11	Spring anchor pin	2
12	Block for jointer traverse/stop	2
13	Square drive adaptor	1
14	Wear Strip	1
15	Clamp Block	1
16	Body for profile jointer stone	1
17	Plate for profile jointer stone holder	1.
18	Washer for profile jointer stone holder body	1
19	Holder for straight jointer stone	1
20	Clamp plate	1
21	Tension pin 6mm dia x 40mm long	2
22	Tension pin 4mm dia x 12mm long	2
23	Hexagon socket grubscrew M6 x 12mm long	2
24	Handwheel	1
25	Taper Pin	1
26	Large diameter plain washer M10	1
27	Helicoil insert M12 F112-N24	1
28	Hexagon socket capscrew M6 x16mm long	2
29	'GACO' 'O' ring RMO 445-30	1
30	Extension spring	2
31	Tension pin 4mm dia x 16mm long	2
32	Hexagon socket grubscrew M8 x 25mm long	3
33	Hexagon locknut M8	3
34	Hexagon head setscrew M8 x 30mm long	2
35	Plain washer M8	2
36	Hexagon socket capscrew M6 x 25mm long	4
37	Bronze headed bush 18mm O/D x 12mm I/D x 8mm long	2
38	Plain collar 25mm O/D x 12mm I/D x 12mm width	1
39	Tension pin 4mm dia x 24mm long	1
40	Plain washer M12	1
41	Hexagon locknut M12	1
42	Stud M12 x 55mm long	1
43	Hexagon socket capscrew M8 x 50mm long	2
44	Hexagon scoekt capscrew M8 x 25mm long	3
45	Hexagon socket capscrew M8 x 40mm long	1
46	Hexagon locknut M8	1
47	Collar nut 'WDS' 404-204 M12	1
48	Plain washer M12	1
49	Hexagon nut M12	1
50	Hexagon socket capscrew M10 x 20mm long	2

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FIG 43 XE E-UNIT (SECOND BOTTOM HEAD JOINTER)



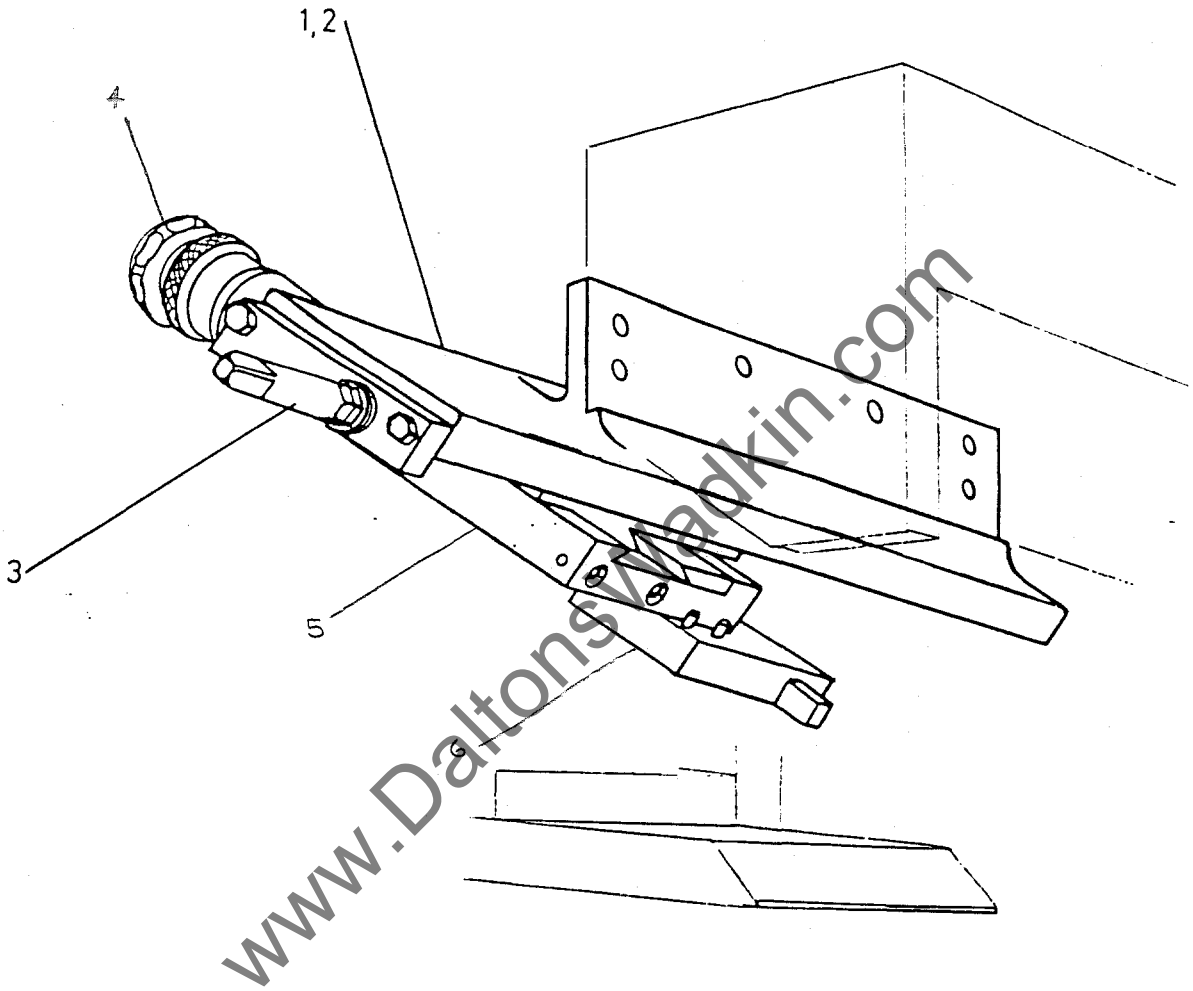
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43 XE E-UNIT (TOP HEAD JOINTER)

Ref No.	Description	No. Off
1	Slide for jointer	1
2	Wear strip	1
3	Traverse screw	1
4	Index feed screw	1
5	Clamp block	1
6	Stone cartridge	1

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FIG 43 XE E-UNIT (TOP HEAD JOINTER)