



## 722 Sawmill With 7.0 HP Kohler Engine

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### OWNER'S MANUAL



#### **WARNING:**

Read carefully and understand all **INSTRUCTIONS** before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

**Model # 722**

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Thank you very much for choosing the Woodland Mills 722 Portable Sawmill. For future reference, please complete the owner's purchase date: \_\_\_\_\_

Save the receipt for warranty and these instructions. **It is important that you read the entire manual to become familiar with this product before you begin using it.**

This machine is designed for certain applications only. We strongly recommend this machine is not modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the machine until you have first contacted us to determine if it can or should be performed on the product.

For technical questions and replacement parts, please contact **Woodland Mills Inc.** at **1-855-476-MILL (6455)**

## INTENDED USE

This sawmill is designed for sawing logs while the mill is firmly supported on the ground.

## TECHNICAL SPECIFICATIONS

Item	Description
Gasoline Engine	7.0 HP Kohler
Maximum log diameter	22" (559mm)
Maximum Board Width	18" (457mm)
Blade Size	1-1/4 x 125" (32 x 3175mm)

## GENERAL SAFETY RULES



### WARNING!

Read and understand all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.



### WARNING!

The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.



### WARNING!

Only operate the engine in a well ventilated area. Carbon Monoxide produced by the engine during use can kill. Do not use indoors, near windows or in other sheltered areas.

NOTE: All Federal and State laws and any regulation having jurisdiction covering the safety requirements for use of the machine take precedence over the statements in this manual. Users of this machine must adhere to such regulations.

## SAVE THESE INSTRUCTIONS

### WORK AREA

- **Keep work area clean**, free of clutter and well lit. Cluttered and dark work areas can cause accidents.
- **Do not use your sawmill where there is a risk of causing a fire or an explosion**; e.g. in the presence of flammable liquids, gasses, or dust. Power tools create sparks, which may ignite the dust or fumes.
- **Keep children and bystanders** away while operating a power tool. Distractions can cause you to lose control, so visitors should remain at a safe distance from the work area.
- **Be aware of all power lines, electrical circuits**, water pipes and other mechanical hazards in your work area, particularly those hazards below the work surface hidden from the operator's view that may be unintentionally contacted and may cause personal harm or property damage.
- **Be alert of your surroundings**. Using power tools in confined work areas may put you dangerously close to cutting tools and rotating parts.

### INTERNAL COMBUSTION ENGINE SAFETY



#### WARNING!

Internal combustion engines present special hazards during operation and fueling. Read and follow the warning instructions in the engine Owner's Manual and the safety guidelines below. Failure to follow the warnings and safety standards could result in severe injury or death.

- **DO NOT** run the machine indoors or in an enclosed area such as a deep trench unless adequate ventilation, through such items as exhaust fans or hoses, is provided. Exhaust gas from the engine contains poisonous carbon monoxide gas; exposure to carbon monoxide can cause loss of consciousness and may lead to death.
- **DO NOT** smoke while operating the machine.
- **DO NOT** smoke when refueling the engine.
- **DO NOT** refuel a hot or running engine.
- **DO NOT** refuel the engine near an open flame.
- **DO NOT** spill fuel when refueling the engine.
- **DO NOT** run the engine near open flames.
- **ALWAYS** refill the fuel tank in a well-ventilated area.
- **ALWAYS** replace the fuel tank cap after refueling.
- **ALWAYS** check the fuel lines and the fuel tank for leaks and cracks before starting the engine. Do not run the machine if fuel leaks are present or the fuel lines are loose.
- **ALWAYS** avoid contact with hot fuel, oil, exhaust fumes.

## PERSONAL SAFETY

- **Stay alert**, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
- **Dress properly**. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts. Air vents often cover moving parts and should be avoided.
- **Use safety apparel and equipment**. Use safety goggles or safety glasses with side shields which comply with current national standards, or when needed, a face shield. Use as dust mask in dusty work conditions. This applies to all persons in the work area. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate.
- **Do not over reach**. Keep proper footing and balance at all times.
- **Remove adjusting keys or wrenches** before connecting to the power supply or turning on the tool. A wrench or key that is left attached to a rotating part of the tool may result in personal injury.
- **Never make blade guide adjustments, remove or install blades or conduct any other maintenance or make any other adjustments when the engine is running**. Always shut the engine off, remove the ignition key, and keep the engine off before carrying out any of the aforementioned procedures. Consult your engine manual for safe shutdown procedures to prevent accident ignition.

## TOOL USE AND CARE

- **Always** be sure operator is familiar with proper safety precautions and operation techniques before using machine.
- **Never touch** the engine or muffler while the engine is on or immediately after it has been turned off. These areas get hot and may cause burns.
- **Always** close fuel valve on engines when machine is not being operated.
- **Do not force the tool**. Tools do a better and safer job when used in the manner for which they are designed.
- **Never use the sawmill** with a malfunctioning switch or throttle. Any power tool that cannot be controlled with the switch is dangerous and must be repaired before using.

- **Turn off the engine** and place the switch in the locked or off position before servicing, adjusting, installing accessories or attachments, or storing. Such preventive safety measures reduce the risk of starting the power tool accidentally.
- **Secure logs** with the log screw clamping device instead of with your hand or another individual's help. This safety precaution allows for proper tool operation using both hands.
- **Storing sawmill.** When the sawmill is not in use, store it in a dry, secure place or keep well covered and out of the reach of children. Inspect the sawmill for good working condition prior to storage and before re-use.
- **Maintain your sawmill.** It is recommended that the general condition of the sawmill be examined before it is used. Keep your sawmill in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. If any abnormal vibrations or noise occurs, turn the sawmill off immediately and have the problem corrected before further use.
- **Keep saw blades sharp and clean.** Properly maintained bandsaw blades are less likely to bind and are easier to control.
- **Cleaning and Lubrication.** Use only soap and a damp cloth to clean your sawmill. Many household cleaners are harmful to plastic and rubber components on the sawmill.
- **Use only accessories that are recommended** by the manufacturer for your model. Accessories that may be suitable for another sawmill may create a risk of injury when used on the HM126 sawmill.
- **Always** operate machine with all safety devices and guards in place and in working order. DO NOT modify or make changes to safety devices. DO NOT operate machine if any safety devices or guards are missing or inoperative.
- **Never leave sawmill running unattended.**
- **Coiled blades can spring apart with considerable force and unpredictably in any direction.** Always deal with coiled blades, including those packaged in boxes, with the utmost care.
- **Never use the equipment to cut anything other than lumber** or for any purpose other than cutting lumber as described in this manual.

## EQUIPMENT OPERATION

1. Wear heavy-duty work gloves, ANSI-approved goggles behind a full face shield, steel-toed work boots, and a dust mask.
2. Operate only with assistance.
3. Fill the lubrication tank with clean water and liquid soap.
4. Start and operate the engine according to the provided engine manual.

5. Depress the throttle to bring the blade up to speed.
6. Throttle should be fully depressed when the saw is under load.
7. Cut branches off the lumber to be processed.
8. Place the lumber to be cut on the supports.
9. Move the saw head slowly along the track and against the lumber to make the cut.
10. Trim off the rounded sides of the log.
11. When the log is squared-off, boards or posts can be cut to custom specifications.
12. To prevent accidents, turn off the engine and disconnect its spark plug wire after use. Wait for the engine to cool, clean external parts with a clean cloth, then store the equipment out of children's reach.



## WARNING!

To avoid death or serious injury. Do not cut lumber with foreign objects in it such as nails, any metal pieces, etc.



## WARNING!

The operator and any assistants must stay clear of the front and back of the blade whenever the engine is on.

## MAINTENANCE

Proper and routine maintenance is critical to operator safety, achieving good milling results and to prolonging the life of your investment.

1. **Bandwheel Bearings** — Should be inspected before use to ensure they are not worn. Bearings are sealed and do not need to be greased.
2. **Blade Guide Bearings** — Inspect before use for excessive grooves or scoring in the bearing case. Replace if necessary.
3. **Blade Tension** — Grease threads of tensioning "T" handle when dry or as required. Use multi-purpose, extreme-pressure grease.
4. **Log Screws** — Grease frequently.
5. **Belts** — Periodically check the condition and wear of the drive and idler belt. Ensure that the blade does not ride on the bandwheels.
6. **Drive Belt** — Periodically check the tension of the drive belt. It should deflect by no more than 1/2".
7. **Sawhead Vertical Posts** — Spray posts before use with a silicone spray lubricant such as 3-in-1 or Jig-A-Loo.

8. **Bandwheel Guards** — Routinely remove any build-up of sawdust that may collect inside the bandwheel guards.
9. **Lubrication Tank** — Only fill with a water/dish soap mixture or in winter months, use windshield washer fluid. Do not leave lubricant in tank if temperatures fall below 0 degrees Celsius.
10. **Blade Lubricant** — Never use diesel fuel or kerosene as blade lubricant. These substances lead to premature wear of your belts and poor sawing performance. For winter operations, replace the water lubricant with windshield washer fluid.
11. **Engine** — Check the engine oil level before each use and maintain the engine as per the instructions set out by the engine manufacturer in the engine manual.
12. **Sawhead Lifting Cables** — Regularly before, during and after operations, inspect the cables for any wear or kinks. Ensure that the cables are in perfect condition. Oil coiled part of cable often to prevent premature wear. Replace with new cables as necessary.



# SAWMILL ASSEMBLY

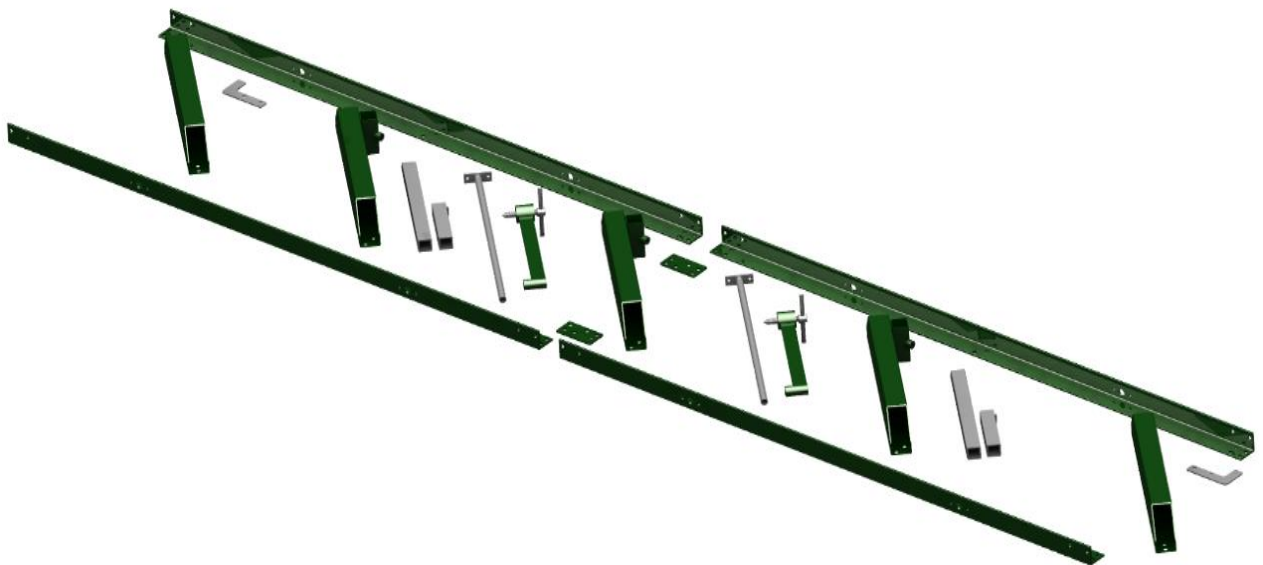
## #1 – INSPECTION

Take all of the parts out of the shipping crate and lay them out. Check for any damage or missing parts.



## #2 – TRACKS

Assemble track system and secure loosely with provided nuts & bolts. It is important not to fully tighten the bolts at this stage. This will be done after the head is assembled and rolled along the track. It is ideal to assemble the tracks on a solid and level footing that is a minimum of 4" off of the ground. This will allow for easy cleanup of sawdust from under the tracks and height adjustment of the log supports.

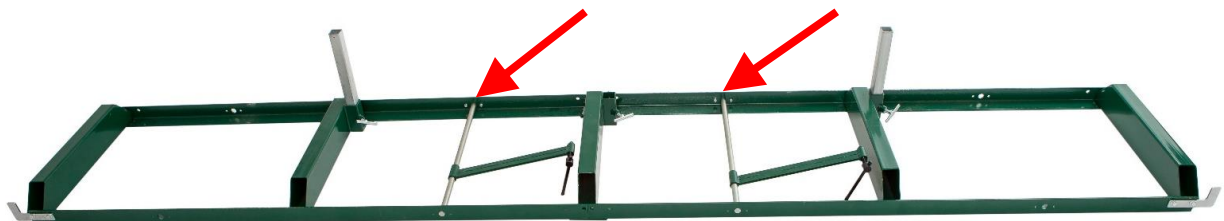




Attach track cross supports to “L” channel with the provided nuts & bolts. The joining plate is used at the seam joint to join the two sections together (shown in top right image). Ensure to only hand tighten at this stage. The bolts will be fully tightened once the head assembly is free to roll on the tracks and provide the correct track width.

### **#3 – LOG DOG & SUPPORTS**

The sawmill comes equipped with two log dog clamp assemblies. Assemble log dog pieces as shown below and use water proof grease on threads. Attach assembly to the track using the provided bolts and washers in the end of the round rod.



Attach log dog assembly to track as shown above. The rods are secured in place using the 4 nuts and bolts provided. Note that there are various locations along the track where this assembly can be bolted. Depending on how many track sections are being used, select a log clamp position that will secure the log firmly against the log supports.



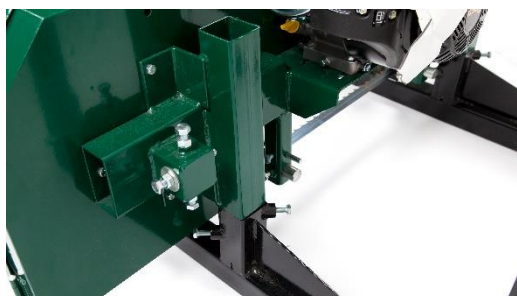
Insert log supports into track cross supports and secure with “T” handles. The “T” handle threads should be coated with grease. The sawmill includes two sets of log supports – a short set and a long set. The longer set is ideal for larger logs and the shorter set is ideal for small logs and square cants.

Now that the track assembly is assembled, it will need to be set on a very firm and level base. Different methods include gravel bed foundations and wood 6”x6” cross supports, concrete pads and trailers. As you roll the head up and down the track system, it is important to ensure the track is not deflecting due to inadequate supports or soft ground supports.

#### **#4 – CARRIAGE ASSEMBLY**



Insert the rear push handle into the left and right side carriage base as shown above.



With a minimum of two people, lift and rest the head onto the carriage bases so that the head is resting on the two vertical square posts as shown in above pictures.



Right Side



Left Side

While one person is holding the head in place, have the other person insert both square posts through the head and into the carriage base on both sides. Note that the square post with the two



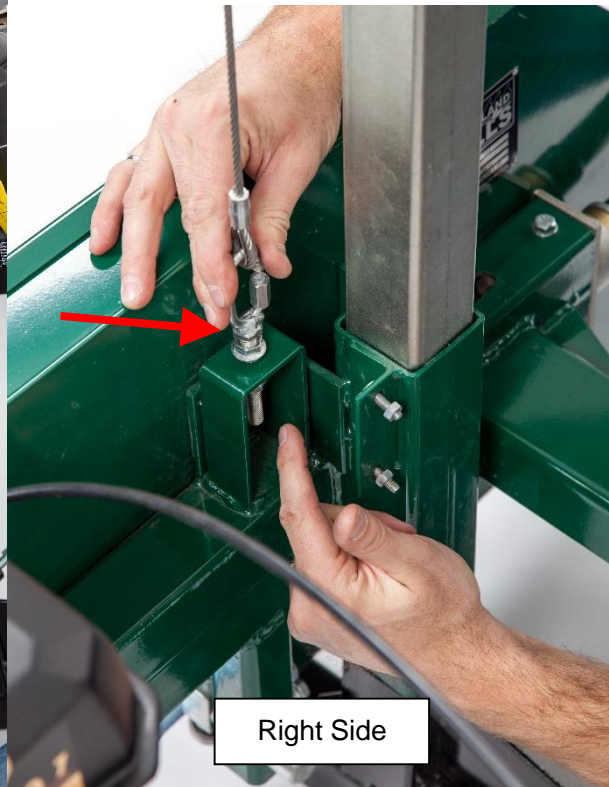
holes and bolt circled above needs to be installed on the right side of the mill (when standing behind it). Also note on the picture on the next page the orientation of the bolt holes at the top of the square posts. These are the holes that the top cross support mounts to.



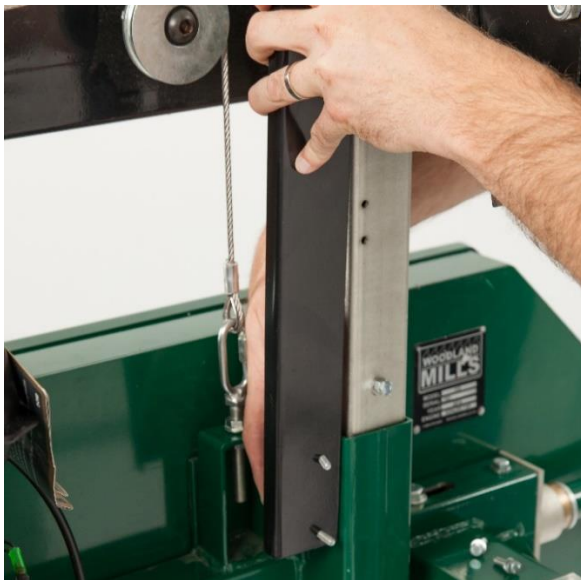
Assemble the top cross support to the square posts. Note the location and direction of the holes in the posts as shown by the arrows above. Insert and hand tighten the 4 bolts that hold the cross support to the posts. These bolts will be properly tightened properly once the head is on the track system and the head is “squared” up.



Route the lifting cables as shown in above two images.

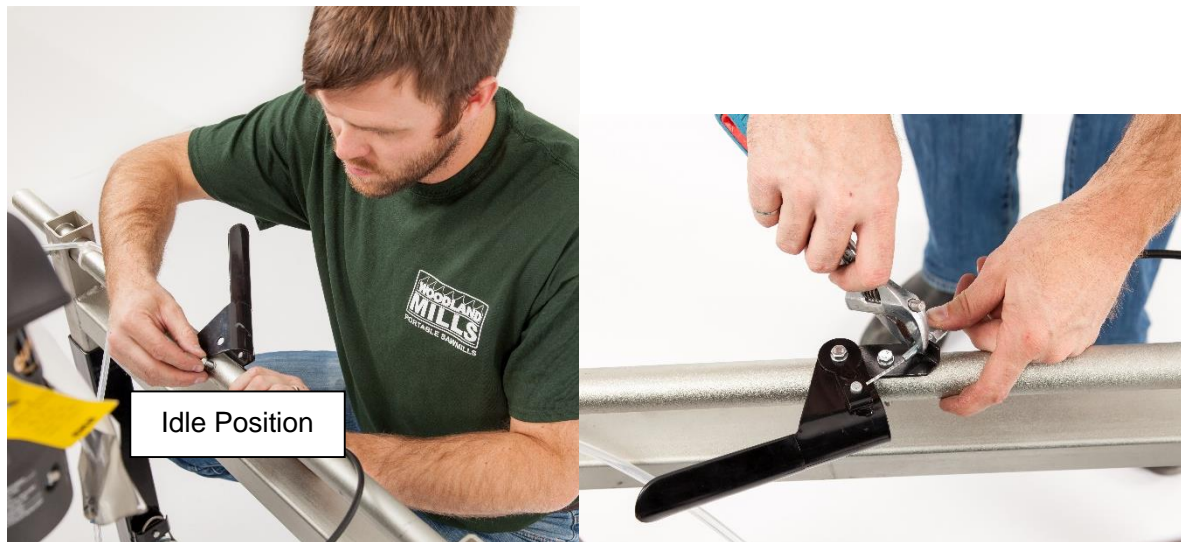


Attach cable ends to head on both sides as shown above. These are adjustable so that the blade/head assembly can be leveled to the log bunks. This will be shown and done at a later step.

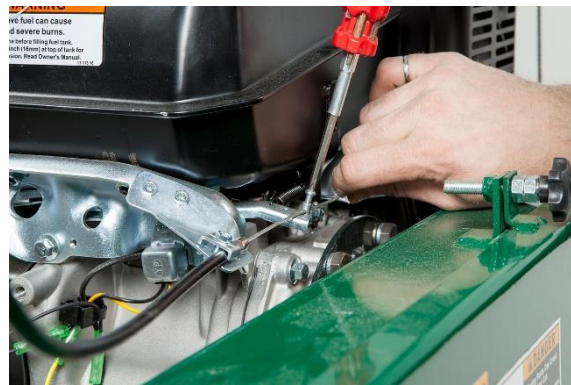


Attach the metal scale bracket to the sawmill head using the two nuts and bolts provided. Use a 10mm socket to tighten. Attach the scale indicator to the post with the two bolts provided and tighten with a 10mm socket. The magnetic log scale can also be placed on the bracket.





Attach the throttle handle to the rear round bar as shown in the above two images.

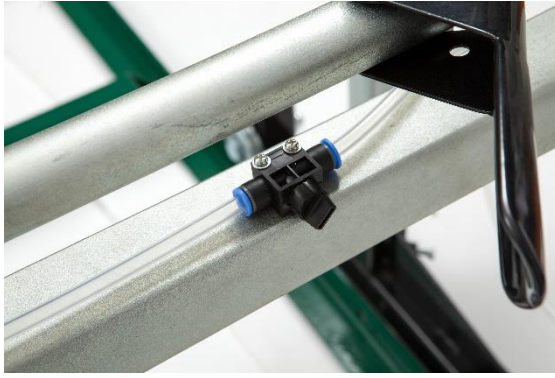


With the throttle lever in the idle position/fully open, pull the cable tight at the engine and tighten the screw to hold it in place. This will take all of the slack out of the cable.



Attach lubrication tank bracket to the left side of the sawmill cross support using the two bolts provided and tighten with a 10mm socket. The lube tank and hose can also be rested into the bracket.

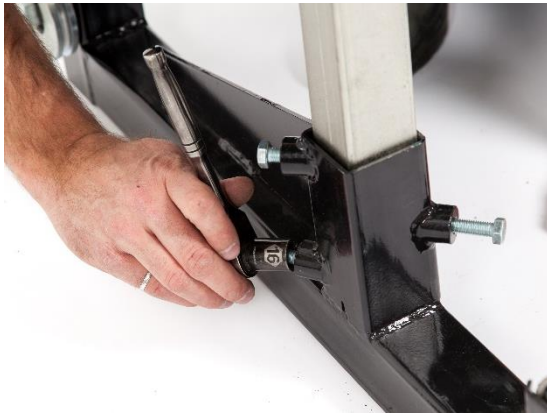




Using the bolts and nuts provided, attach the water valve to the square bar. The end of the hose can be attached to the copper pipe at the blade guide location. Insert the lube tank line through the hole in the bottom of the saw head as shown in above right image. Use a 16mm socket to secure the copper end in position. Do not over tighten or crush the copper end.



At this point, the saw head should be fully assembled, but not rigidly bolted together. The head can now be set on the tracks as shown above. The following steps will square the head and also firm it up.



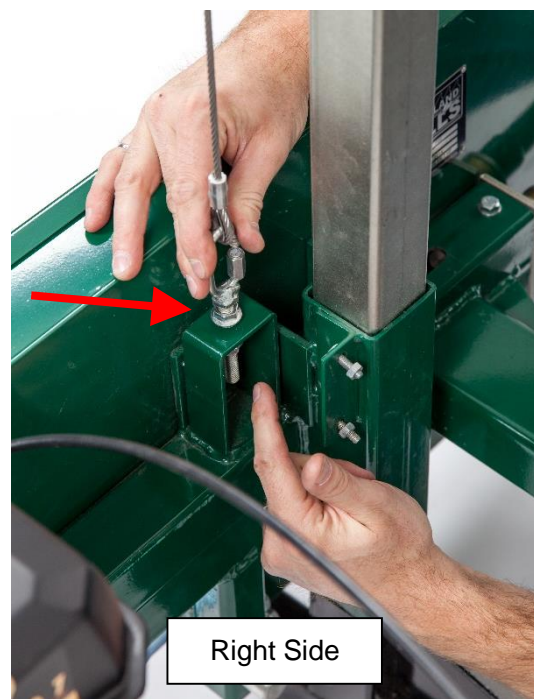
Begin tightening the carriage base bolts that hold the square post in place. Using a 16mm socket, begin tightening all three bolts against the square post. It is important to tighten each bolt a few turns at a time to ensure that the post becomes straight up and down and parallel to the post on the other side. If these bolts are tightened in a manner that cause the post to become out of square to the carriage base and top cross support, the wheels that ride on the track may not ride squarely or evenly on the track system. If this happens, you can adjust these bolts until the wheels are sitting firmly on the track system.



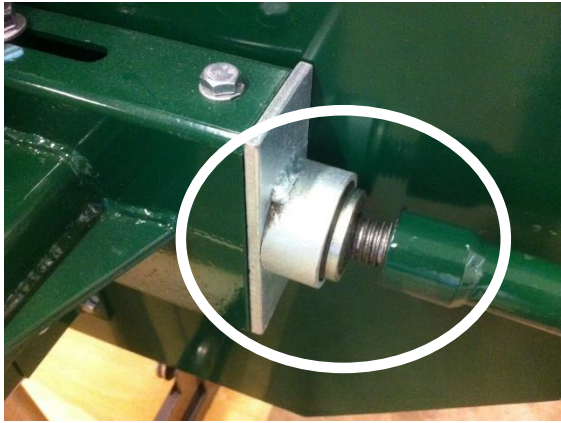
Using a socket, tighten the four bolts that hold the square posts to the top cross support. Note that the bolts go through slots on the two posts. These slots allow for adjustment if needed to align the posts to one another. Again, if you tighten these bolts and the carriage wheels that ride on the track are not sitting evenly, you can loosen the bolts and reposition the post until the wheels are sitting squarely on the track. These top four bolts and the six at the bottom may need to be adjusted a few times to completely square the head to the track.



Once the head is square to the track, it can be leveled left to right to ensure the blade is sitting level to the log bunks. Using a tape measure, take a measurement from the blade to the top of the log bunk on both the left and right side. The distance should be equal on both sides. If it isn't, you will need to adjust the cable ends at the rear handle to either raise or lower one side. Refer to below step for adjustment instructions.

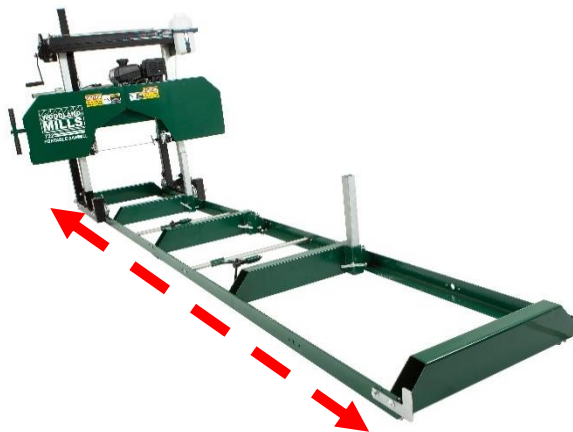


To adjust the head/blade to be level to the cutting deck, the above threaded bolt can be adjusted. The right side of the mill can be lowered by unthreading the bottom nut. To raise the right side of the saw head, the bottom nut can be threaded (up). Once the head is level, the top nut can be tightened to secure the adjuster in place.



Add grease to the threads of the blade tension “T” handle and to the washer face that it meets before use. Proper blade tension is achieved with a 24mm socket on a torque wrench and is used to tighten the “T” handle to 30-35 ft-lbs torque. See above right image.

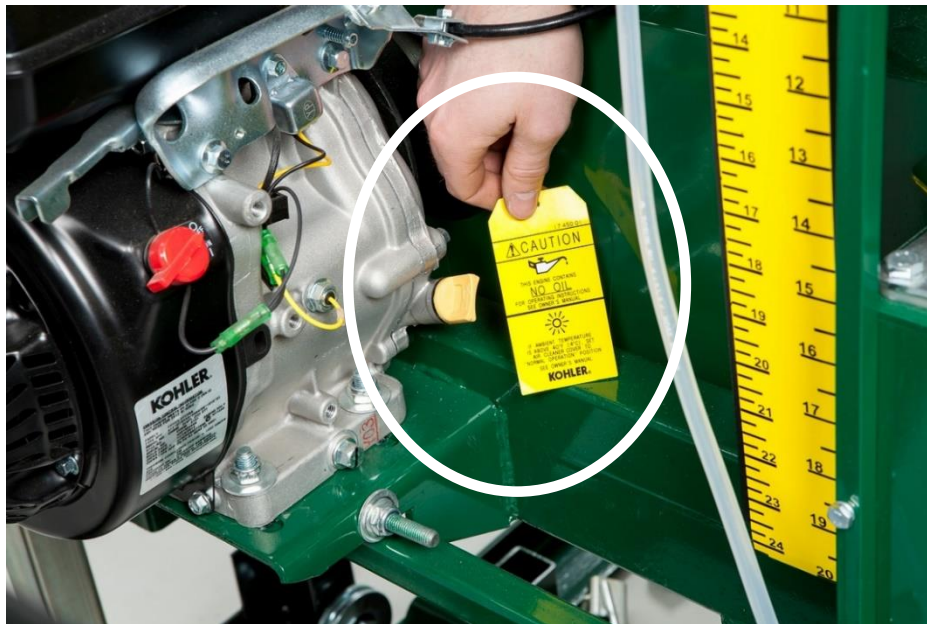
***\*Note – It is very important to take the tension off of the blade by turning the “T” handle in the counter-clockwise direction when the sawmill is not in use. Failure to do so, will result in flat spots on the rubber belts. These flat spots will cause the mill to vibrate excessively during next use.\****



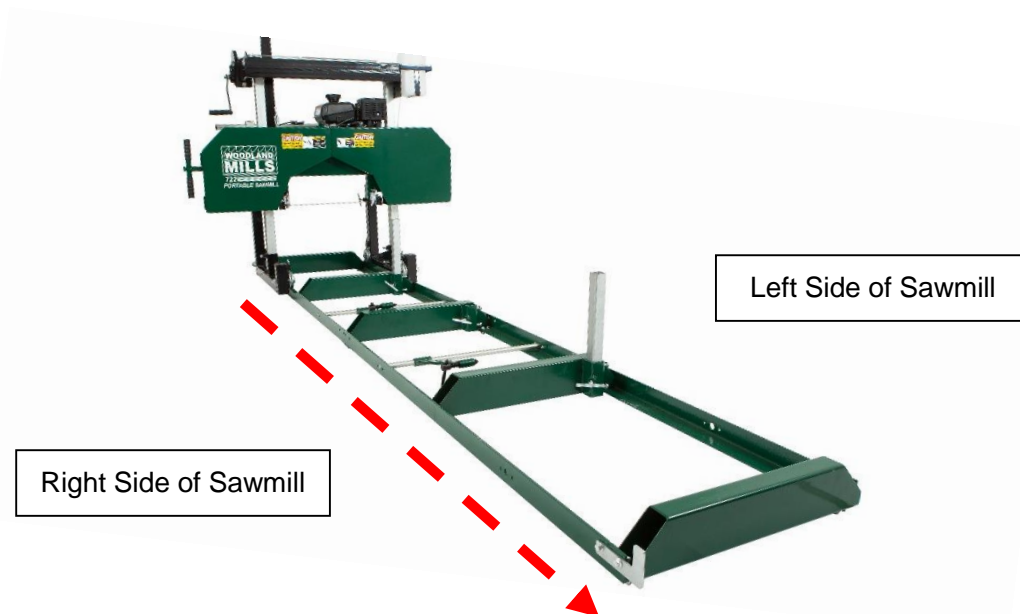
Push the saw head up and down the track system to ensure that the width of the track allows for the saw head to move freely. If it binds, the “L” rails will need to be set further or closer together to achieve a consistent width along the entire track system. Once the desired width is achieved, all nuts and bolts can be tightened to the log bunks as shown in above right image using a 14mm socket.



## #5 – ENGINE



Refer to the engine manual before using your sawmill. Please note that the engine does not contain any gasoline or engine oil when it is shipped. Furthermore, the engine is equipped with an oil alert system, meaning that if the crankcase oil level is low or empty, the power is cut to the spark plug and it will not start.

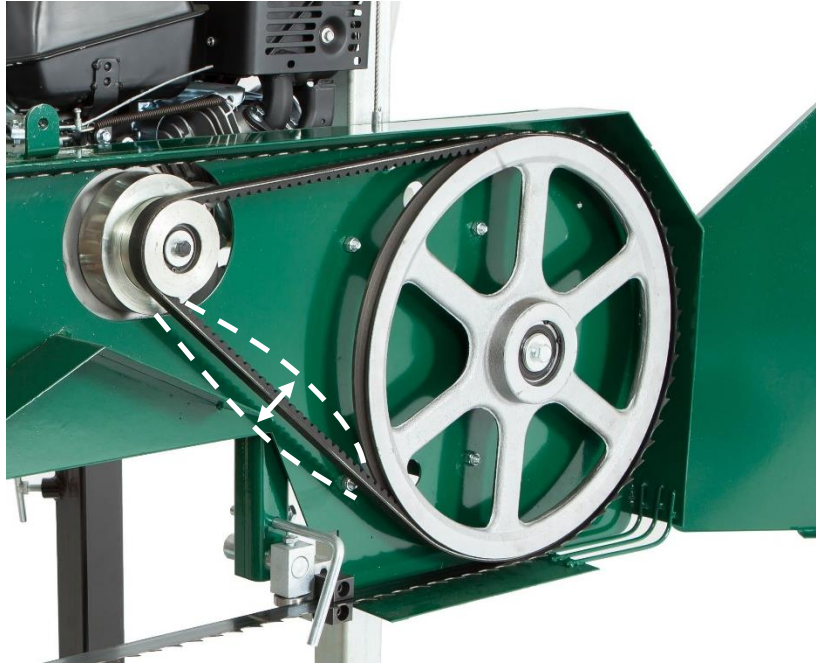


Always cut in the direction shown above. The log clamp should always be on the right side of the log and the log supports should always be on the left. Failure to cut in this direction can cause the log to come loose and possibly even cause damage or injury.

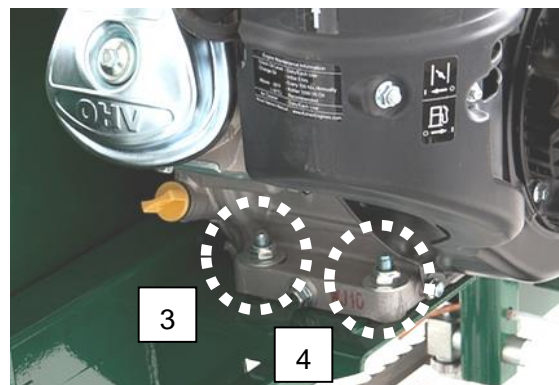
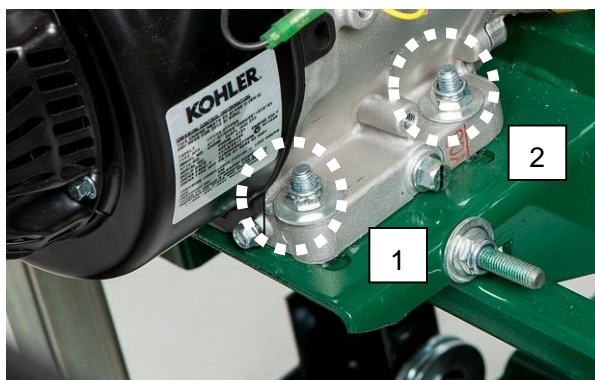
***\*Now that your sawmill is now assembled, but please run through the “SAWMILL SET-UP PROCEDURES” in the following section. Failure to do so may result in poor sawing performance, damage or injury. See next page.\****

# SAWMILL SET-UP PROCEDURES

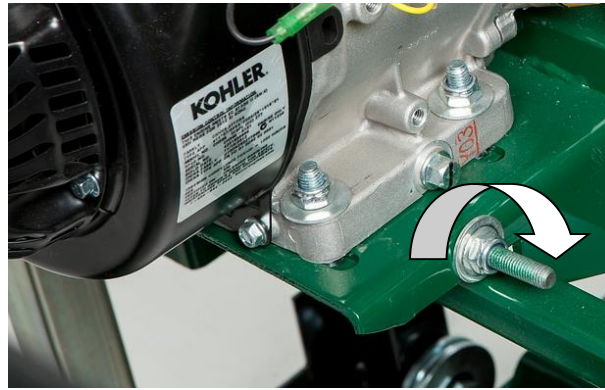
## #1 – BELT TENSION



To check the belt tension, with your hand, firmly try to deflect the belt up and down. There should be no more than 1/4" of deflection in both directions (1/2" total). If the belt deflects more than this, it will need to be tightened as described below.



To tighten the drive belt, start by loosening the four bolts that secure the engine to the engine mount.

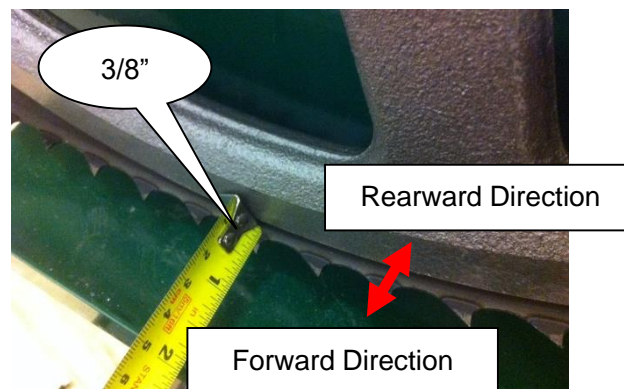


Now that the engine is free to slide on the engine mounting plate, turn the nut on the horizontal stud in the clockwise direction. This will pull the engine towards the stud and apply more tension on the belt. Do this step incrementally while checking the belt for proper deflection. It is also important to ensure that the engine remains perpendicular to the drive belt. Over tightening can cause the engine to twist on the mounting plate, resulting in belt alignment issues and premature wear. Once the desired belt tension is set, tighten the four engine bolts.

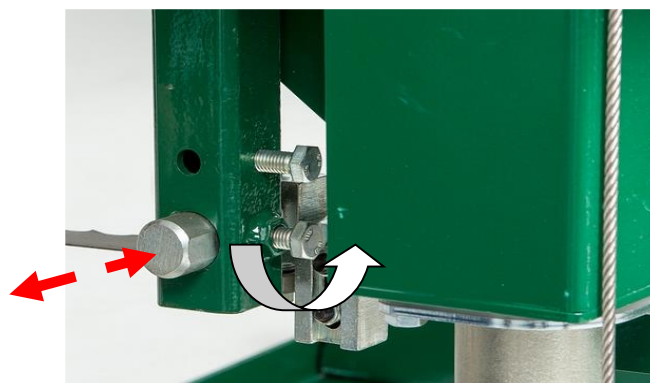
Alternatively, if the drive belt is too tight, the nut on the horizontal stud can be turned counter-clockwise.

## #2 – BLADE TRACKING

Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. It is also advised to wear gloves and safety glasses when working with the blade as it is extremely sharp.



The blade should run with the same tooth to bandwheel face distance on both sides. 3/8" is ideal. Measure the distance from the tip of the blade tooth to the front face of the bandwheel on both sides. If an adjustment on either side is required, the below steps will detail this procedure.



Loosen the blade guide assembly bolt with a 16mm socket. The round shaft should now be free to slide rearward and out of the way. Perform this step on both guide assemblies. This will ensure that the guide bearings do not influence tracking of the blade while adjusting.



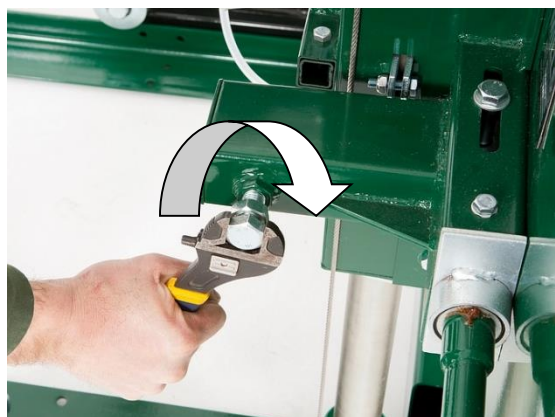


Take some tension off of the blade by turning the “T” handle in the counter-clockwise direction one full turn from full tension position.

### **Adjusting the Right Hand Side**



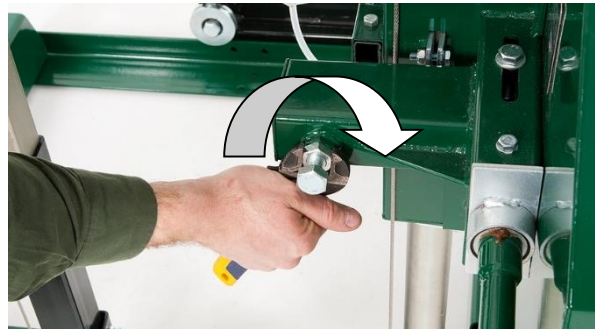
Loosen the tracking alignment locking nut with an adjustable wrench.



The alignment bolt can now be turned to change the angle of the bandwheel and track the blade. To move the blade more rearward on the bandwheel, this bolt will need to be turned clockwise. Alternatively, turning the bolt in the counter-clockwise direction would force the blade to run more forward on the bandwheel. Turn the bolt a 1/2 turn and re-tension the blade.

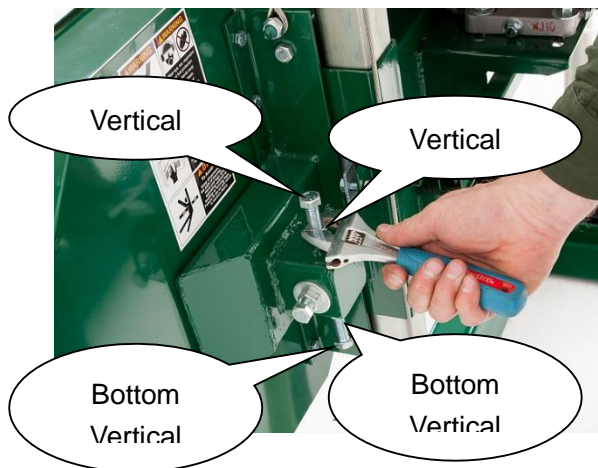


Wearing gloves, spin the bandwheel with your hand and observe how the blade has changed tracking. Measure the distance again and repeat the above step to further compensate if required. The ideal measurement is 3/8".

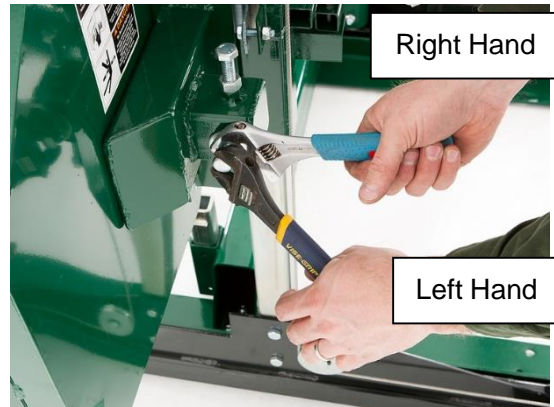
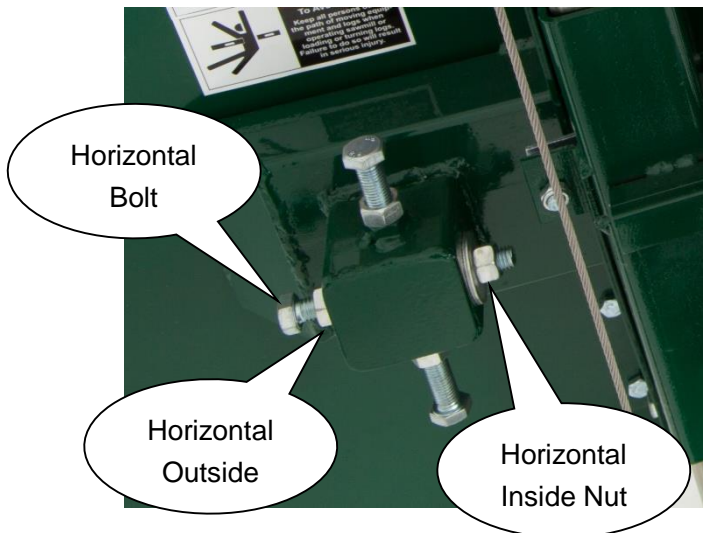


Once satisfied with the measurement, tighten the locking nut clockwise.

### Adjusting The Left Hand Side



To adjust the left side of the sawmill, again start by taking the tension off of the blade by turning the "T" handle one turn in the counter-clockwise direction. Using a 16mm wrench, loosen the "**vertical nut**" a ½ turn. Do the same on the "**bottom vertical nut**". Next, loosen both "**vertical bolts**" a ½ turn. This will take the clamping force off of the bandwheel shaft caused by these two bolts and allow it to move freely in the following steps.



#### Moving The Blade Forward

Using a 16mm wrench, hold the **“horizontal bolt”** stationary with a wrench and turn the **“horizontal inside nut”** counter-clockwise a  $\frac{1}{2}$  turn. Still holding the **“horizontal bolt”** stationary, turn the **“horizontal outside nut”** clockwise a  $\frac{1}{2}$  turn. This has now shifted the **“horizontal bolt”** and bandwheel shaft, causing the blade to track more forward.

#### Moving The Blade Rearward

Using a 16mm wrench, hold the **“horizontal bolt”** stationary with a wrench and turn the **“horizontal outside nut”** counter-clockwise a  $\frac{1}{2}$  turn. Still holding the **“horizontal bolt”** stationary, turn the **“horizontal inside nut”** clockwise a  $\frac{1}{2}$  turn. This step has now shifted the **“horizontal bolt”** and bandwheel shaft, causing the blade to track more rearward.

Tighten the vertical bolts, then nuts to clamp the bandwheel shaft back into vertical position.



Re-tension the blade by turning the “T” handle a full turn in the clockwise direction. Wearing gloves, spin the bandwheel with your hand and observe how the blade has changed tracking. Measure the distance again and repeat the above step to further compensate if required. The ideal measurement is  $\frac{3}{8}$ ”.

Once the blade is tracking true, bring the blade guide assemblies back up to the blade. Keep a paper width distance between the blade guide bearing and the back of the blade. More information on this set up can be found in the next section – **“BLADE GUIDE ADJUSTMENT”**

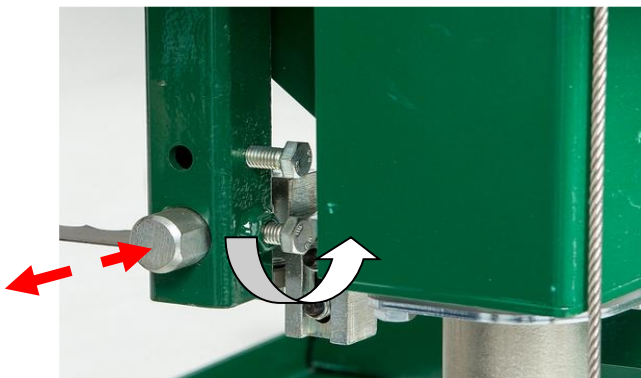


### **#3 – BLADE GUIDE ADJUSTMENT**

Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. It is also advised to confirm that the blade is tracking properly before performing the below. Blade tracking is covered in the previous page.



Using a 6mm allen key, loosen the blade guide blocks on both the left and right sides. They should be free to slide up and down.

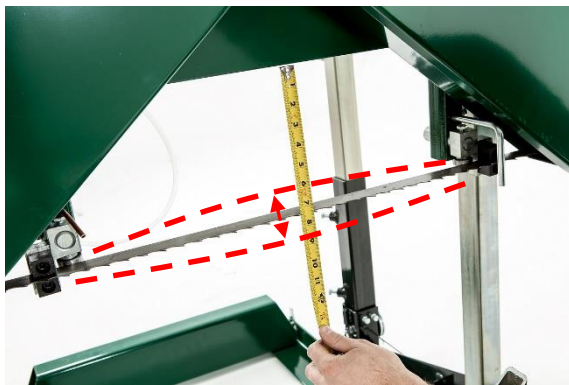


Loosen the blade guide assembly bolt with a 16mm socket. The round shaft should now be free to slide back and forth. Position it so that there is a paper width gap between the bearing and the back of blade. Tighten bolt against the flat on the shaft to secure assembly back in position.



Using a piece of paper in between the blade and blade guide blocks, tighten the allen key bolts.

#### **#4 – BLADE TENSION**



Proper blade tension is achieved when the blade deflects no more than a total of 1/8" - 1/4" up/down when it is firmly moved by hand at the center location of the blade guide blocks. Turning the blade tension "T" handle in the clockwise direction will add tension to blade. Alternatively, a 24mm socket on a torque wrench may be used to tighten the "T" handle to 35 ft-lbs torque. See above right image.

# SAWMILL MAINTENANCE

## #1 – CHANGING THE BLADE

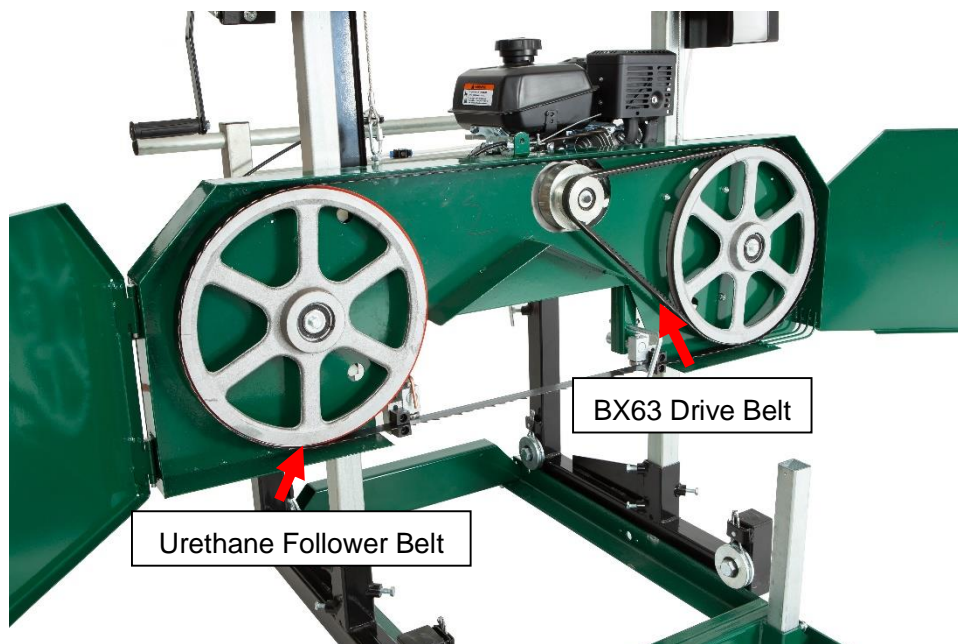
Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. Gloves and safety glasses must be worn when changing the blade.



Remove the tension in the blade by turning the “T” handle in the counter-clockwise direction and then open the blade guard cover. The blade should now be loose and free to pull straight out the front. The new blade can now be installed, guards closed and proper blade tension set.

## #2 – REPLACING BELTS

Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. Gloves and safety glasses must be worn when replacing the belts.

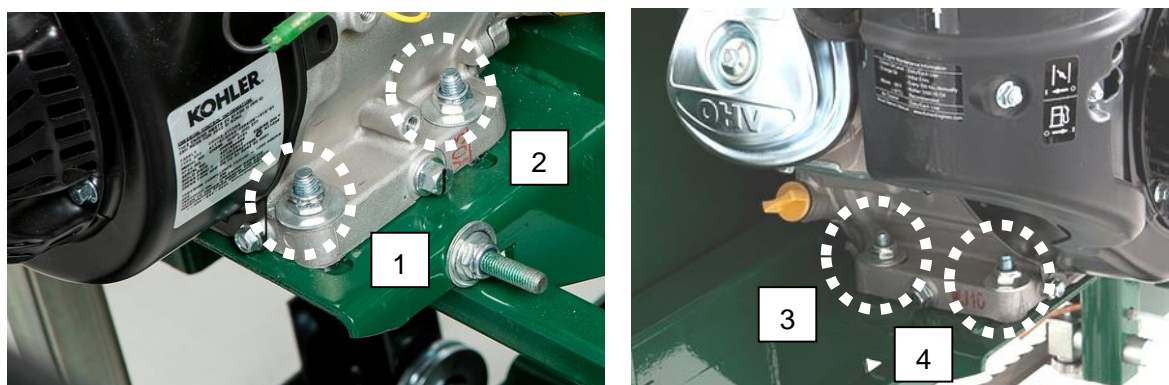


There are two rubber “V” belts on the sawmill and they should be replaced as a set. It is not advised to replace individual belts separately. It is recommended to use a BX63 cogged belt for the drive side and a urethane follower belt.

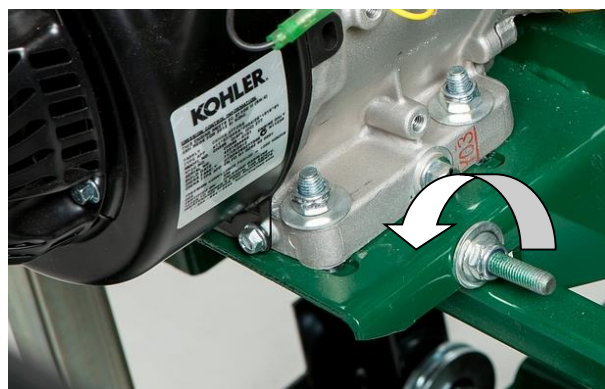




Remove the tension in the blade by turning the “T” handle in the counter-clockwise direction and then open the blade guard cover. The blade should now be loose and free to pull straight out the front.



To change the drive side belt, loosen the four bolts that secure the engine to the engine mount using a 16mm wrench.



Now that the engine is free to slide on the engine mounting plate, turn the 16mm nut on the horizontal stud in the counter-clockwise direction. This will allow the engine to move and will also take the tension off of the belt. The old belt can be removed and the new belt can be installed. Tension the new belt and refer to the **BELT TENSION** instructions described in the sawmill set up section of the manual.

The follower belt can now be changed by simply pulling it off and installing the new one. The blade can now be re-installed, guards closed and proper blade tension set.

***\*Note that blade tracking is likely to change and need adjusting when new belts are installed. Refer to “BLADE TRACKING” for more information.\****

## TROUBLESHOOTING

Problem/Issue	Possible Causes	Resolution Options
Producing wavy cuts.	<ol style="list-style-type: none"> <li>1. Inadequate blade tension.</li> <li>2. Improper blade guide set up.</li> <li>3. Improper blade tracking.</li> <li>4. Sap build up on blade.</li> <li>5. Dull blade.</li> <li>6. Pushing mill too quickly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten blade. Refer to page 29.</li> <li>2. Gap between guide blocks and blade are incorrect. Refer to page 28.</li> <li>3. Adjust blade tracking. Refer to page 24.</li> <li>4. Install new blade. Refer to page 30. Always use blade lubricant.</li> <li>5. Install new blade. Refer to page 30.</li> <li>6. Slow feed rate down and push head slower through log.</li> </ol>
Last board is tapered or narrow in middle.	<ol style="list-style-type: none"> <li>1. Tracks are not level.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tracks need to be checked with level and adjusted to be square. They also need to be set up on firm, sturdy ground/base so deflection does not occur from logs or sawmill head.</li> </ol>
Blade dulls quickly.	<ol style="list-style-type: none"> <li>1. Logs are not clean.</li> <li>2. Foreign objects in log.</li> </ol>	<ol style="list-style-type: none"> <li>1. Logs may contain dirt/sand causing them to wear prematurely.</li> <li>2. Tree may contain nails, staples, old fencing etc.</li> </ol>
Blade comes off of bandwheels.	<ol style="list-style-type: none"> <li>1. Inadequate blade tension.</li> <li>2. Improper blade guide set up.</li> <li>3. Improper blade tracking.</li> <li>4. Belts are worn.</li> <li>5. Dull blade.</li> <li>6. Pushing mill too quickly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten blade. Refer to page 29.</li> <li>2. Gap between guide blocks and blade are incorrect. Refer to page 28.</li> <li>3. Adjust blade tracking. Refer to page 24.</li> <li>4. Install new belts. Refer to page 30.</li> <li>5. Install new blade. Refer to page 30.</li> <li>6. Slow feed rate down and push head slower through log.</li> </ol>
Blades are breaking.	<ol style="list-style-type: none"> <li>1. Too many blade sharpenings.</li> <li>2. Inadequate blade tension.</li> <li>3. Improper blade guide set up.</li> <li>4. Improper blade tracking.</li> <li>5. Pushing mill too quickly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace blade. Refer to page 30.</li> <li>2. Binding between guide blocks when blade is too loose. Tighten blade. Refer to page 29.</li> <li>3. Gap between guide blocks and blade are incorrect. Refer to page 28.</li> <li>4. Adjust blade tracking. Refer to page 24.</li> <li>5. Slow feed rate down and push head slower through log.</li> </ol>
Blade is slowing down or stopping when milling.	<ol style="list-style-type: none"> <li>1. Inadequate blade tension.</li> <li>2. Improper drive belt tension.</li> <li>3. Pushing mill too quickly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten blade. Refer to page 29.</li> <li>2. Belts are worn or too loose. Replace. Refer to page 30.</li> <li>3. Slow feed rate down and push head slower through log.</li> </ol>
Mill is not cutting/cutting very slowly.	<ol style="list-style-type: none"> <li>1. Dull blade.</li> <li>2. Blade is on backwards.</li> </ol>	<ol style="list-style-type: none"> <li>1. Install new blade. Refer to page 30.</li> <li>2. Remove blade and flip it inside out. The teeth should be facing in the direction of the log supports.</li> </ol>
Mill is vibrating excessively.	<ol style="list-style-type: none"> <li>1. Log is not clamped securely.</li> <li>2. Belts are deformed.</li> <li>3. Bandwheel bearing issue.</li> <li>4. Pushing mill too quickly.</li> <li>5. Loose bolts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure log is clamped firmly resting on log bunks and against log supports.</li> <li>2. Belts may have flats in them from leaving blade tension tight when not in use. Replace them. Refer to page 30.</li> <li>3. Inspect and replace the bandwheel bearings if worn.</li> <li>4. Slow feed rate down when milling.</li> <li>5. Check all bolts to ensure they are tight.</li> </ol>



## DIAGRAM & PARTS LIST

Part No.	Description	Specification	Quantity
1	Tracking Wheel		4
2	Locking Nut	M20	4
3	Left Carrier Assembly		1
5	Locking Nut	M12	6
6	Hex Bolt	M20 x 110	4
7	Right Carrier Assembly		1
11	Hex Bolt	M8 x 20	13
14	Tension Handle		1
15	Flat Washer	M12	2
16	Hex Bolt	M12 x 120	1
23	Cross Beam Assembly		1
25	Locking Nut	M8	15
28	Thread Rod		1
35	Pulley Wheel		4
37	Circlip	ø28	4
42a	Ball Bearing	6001	4
42b	Short Spacer	ø19x5	1
44	Hex Bolt	M10 x 30	10
45	Flat Washer		2
46	Wiring Hook		1
47a	Log Bunk		2
48	Square Post		2
49	Bolt	M12 x 70	4
50	Band Wheel Cover (Back)		1
51	Bolt	M12 x 45	2
52	Nut	M12	4
53	Bolt	M12 x 100	1
54	Grommet		1
55	Hex Bolt	M8 x 35	4
57	Saw Head Frame		1
60	Hex Bolt	M10 x 25	8
61	Spring Washer	M10	2
62	Flat Washer	M10	2
63	Circlip	ø62	2
64	Ball Bearing	6305	4
65	Cog Belt	BX64	1
66	Band Wheel		2
67	Clutch Housing		1
68	Pin		1
69	Saw Blade	125"	1
70	Inner Hex Bolt	M8 x 45	4
71	Blade Guide Block		4
72	Blade Guide Holder (Right)		1
73	Insert Pin		2
74	Drive Shaft		1

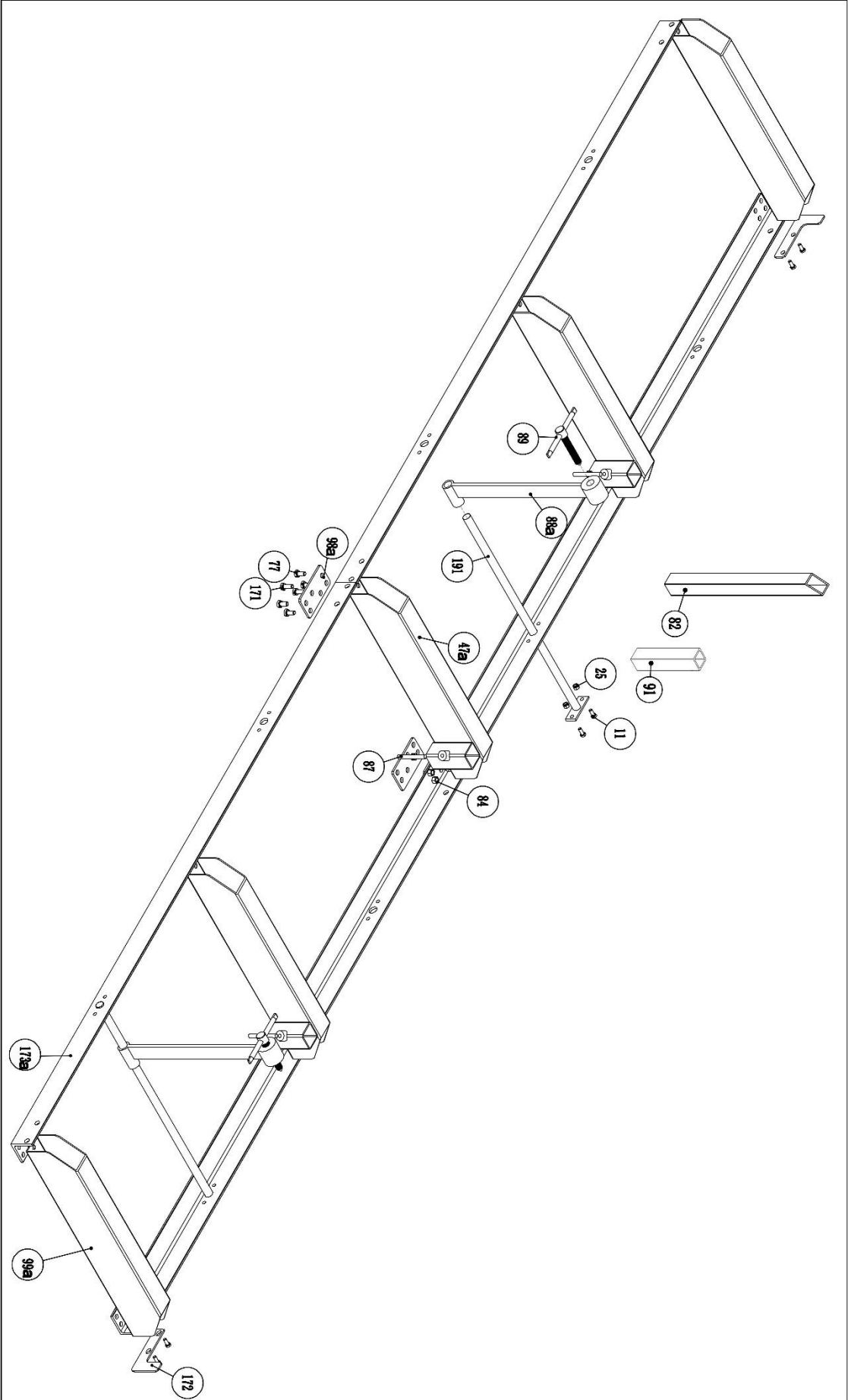
Part No.	Description	Specification	Quantity
104	Ball Bearing	6200	2
105	Flat Washer	M10	10
107	Band Wheel Cover (Right)		1
108	Band Wheel Cover (Left)		1
109	Wing Bolt	M8 x 30	1
112	Bolt	M6 x 20	
116	Water Tank		1
120	On/off Valve	SLS-04-8	1
121	Water Hose	ø8	1
122	Inline Valve	HVFF8-8	1
123	Water Hose	ø8	1
124	Drip Nozzle	ø6	1
125	Scale Tape		1
126	Scale Tape Bracket		1
127	Hand Grip	ø20	2
132	Spacer	ø20x6	8
133	Circlip	ø42	5
134	Ball Bearing	6004	4
135	H Frame		1
136	Joint Log Bunk		1
137	Throttle Cable		1
138	Mounting Plate		1
139	Bolt	M6 x 55	1
140	Locking Nut	M6	2
141	Throttle Handle		1
145	Track Sweeper		4
153	Wiring Cable		1
155	Bolt	M6 x 10	4
156	Flat Washer	M6	4
157	Scale Indicator Plate		1
159	Screw	M4 x 12	1
165	End Insert		4
171	Flange Bolt	M10 x 30	8
172	End Stop		2
173a	Rail		4
176	Spacer		1
177	Fasten Plate		1
178	Saw Blade Stopper		1
179	Throttle cable clamp		1
182	End Guide Insert		1
183	Centrifugal Clutch		1
184	Thrust Bearing	8024	1
185	Flat Washer		
186	Track Sweeper		4
187	Hex Bolt	M12 x 30	1

## DIAGRAM & PARTS LIST - CONTINUED

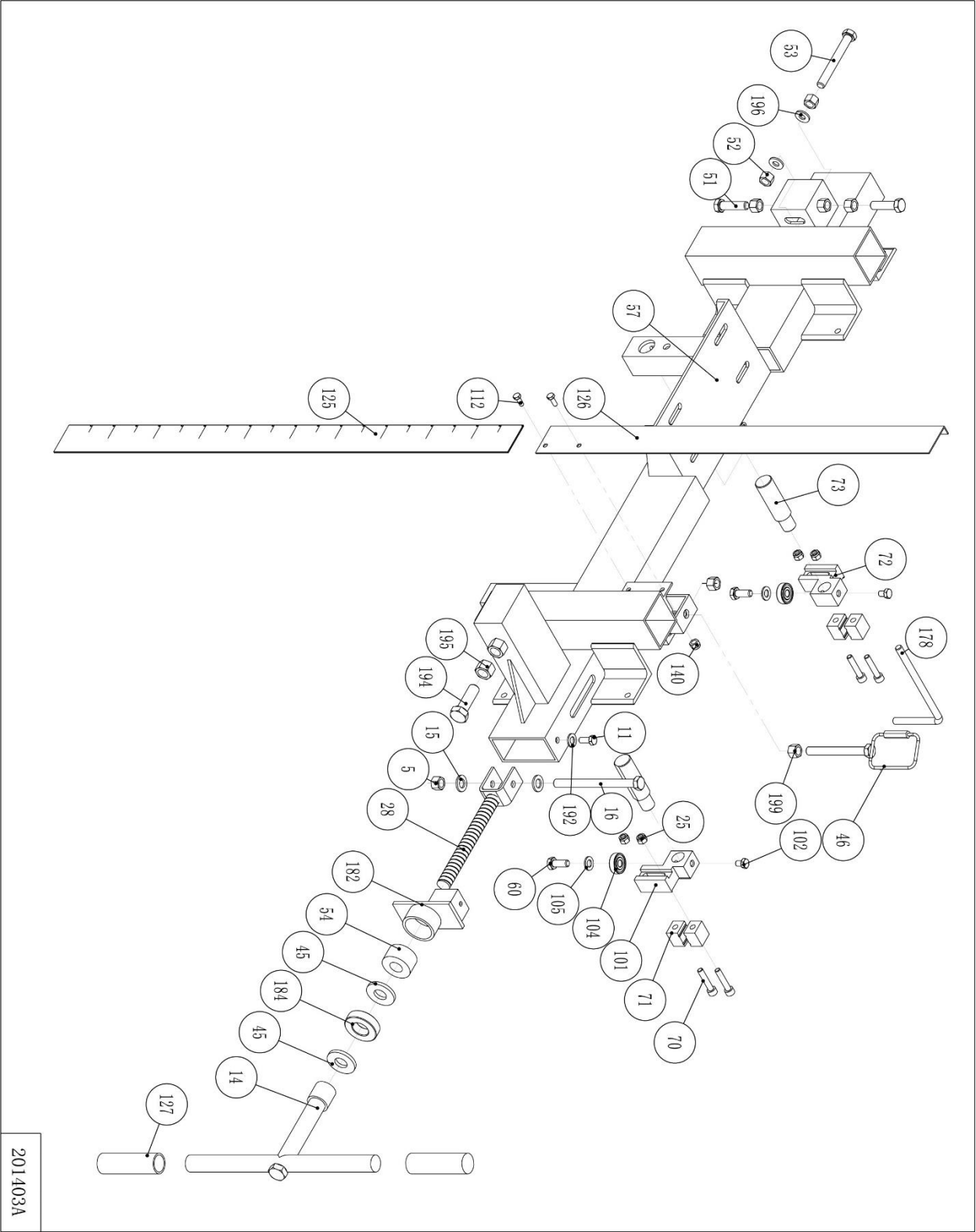
75	Driven Shaft		1
76	Cog Belt	BX48	1
77	Flange Bolt	M10 x 25	24
82	Long Log Post		2
84	Flange Locking Nut	M10	32
87	T Bolt		5
88a	Log Clamp Holder		2
89	Log Clamp		2
91	Short Log Post		2
98a	Reinforce Plate		2
99a	Log Support		2
101	Guide Block Holder(Left)		1
102	Hex Bolt	M8 x 12	2

188	Hex Bolt	M12 x 20	2
189	Pushing Handle		1
190	Bolt	M6 x 50	1
191	Log Clamp Shaft		2
192	Flat Washer	M8	10
193	Nut	M8	2
194	Bolt	M16 x 80	1
195	Nut	M16	1
196	Flat Washer	M12	6
197	Winch	1200 lb	1
198	Water Tank Holder		1
199	Nut	M10	2

DIAGRAM

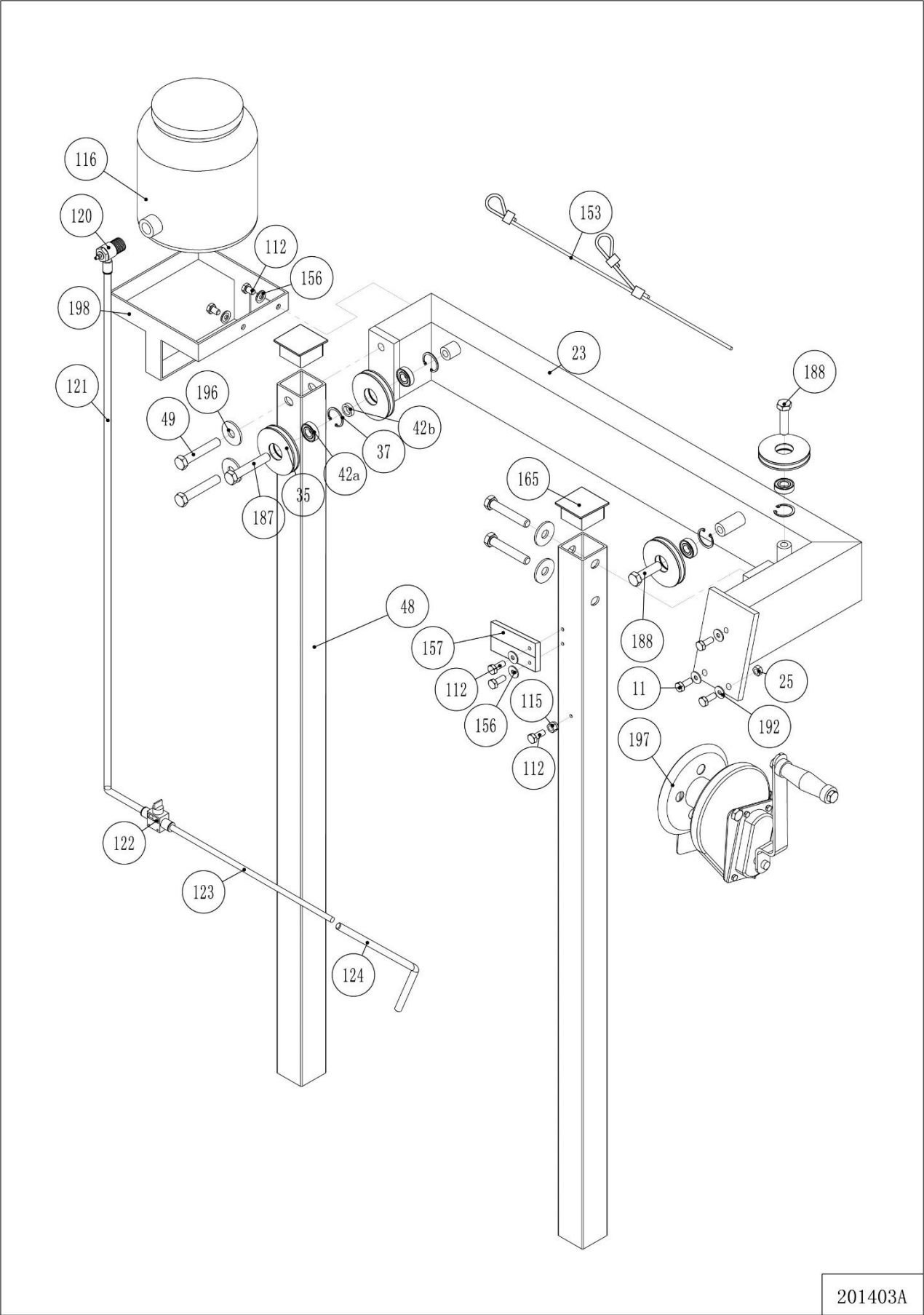


DIAGRAM



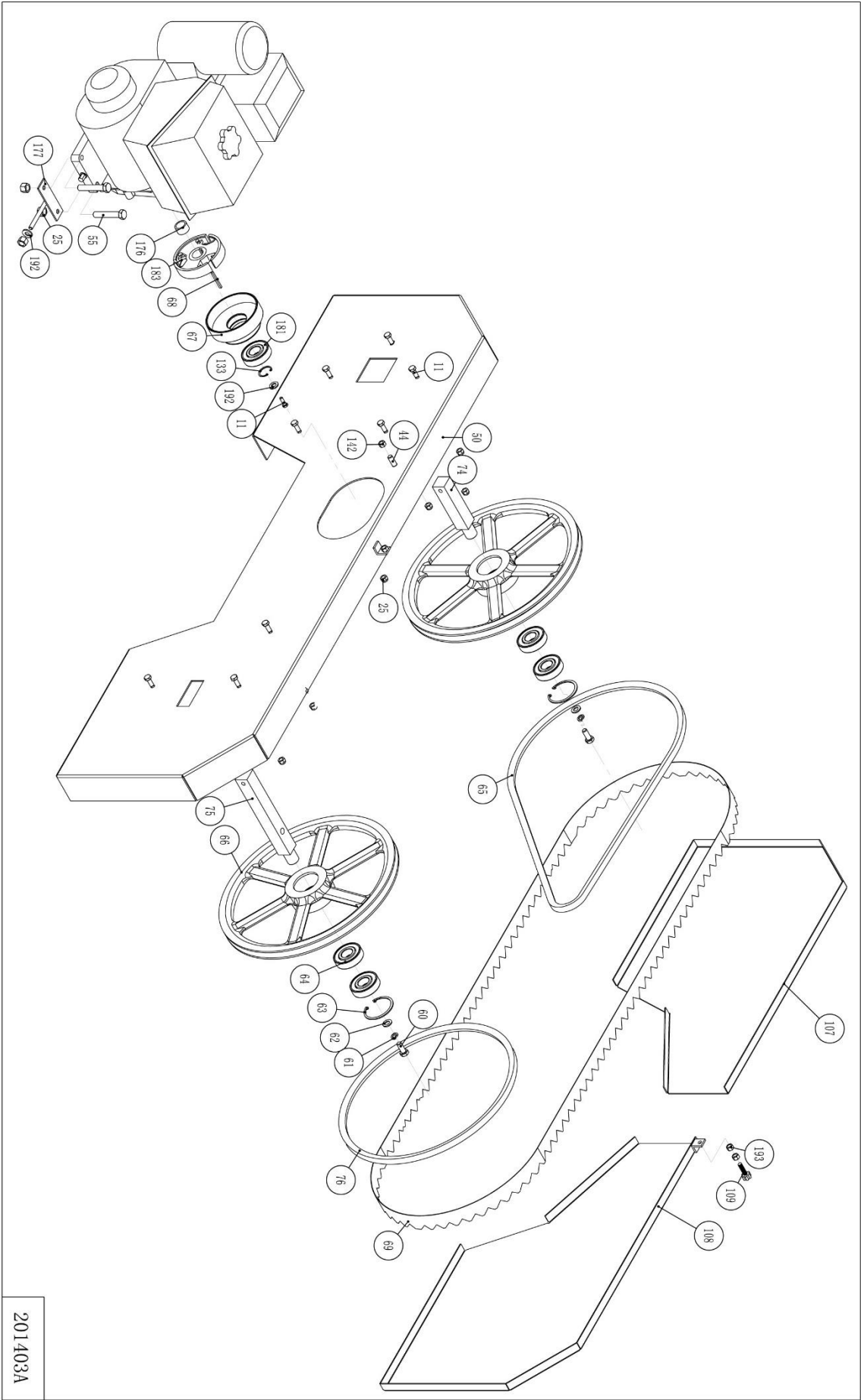
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DIAGRAM



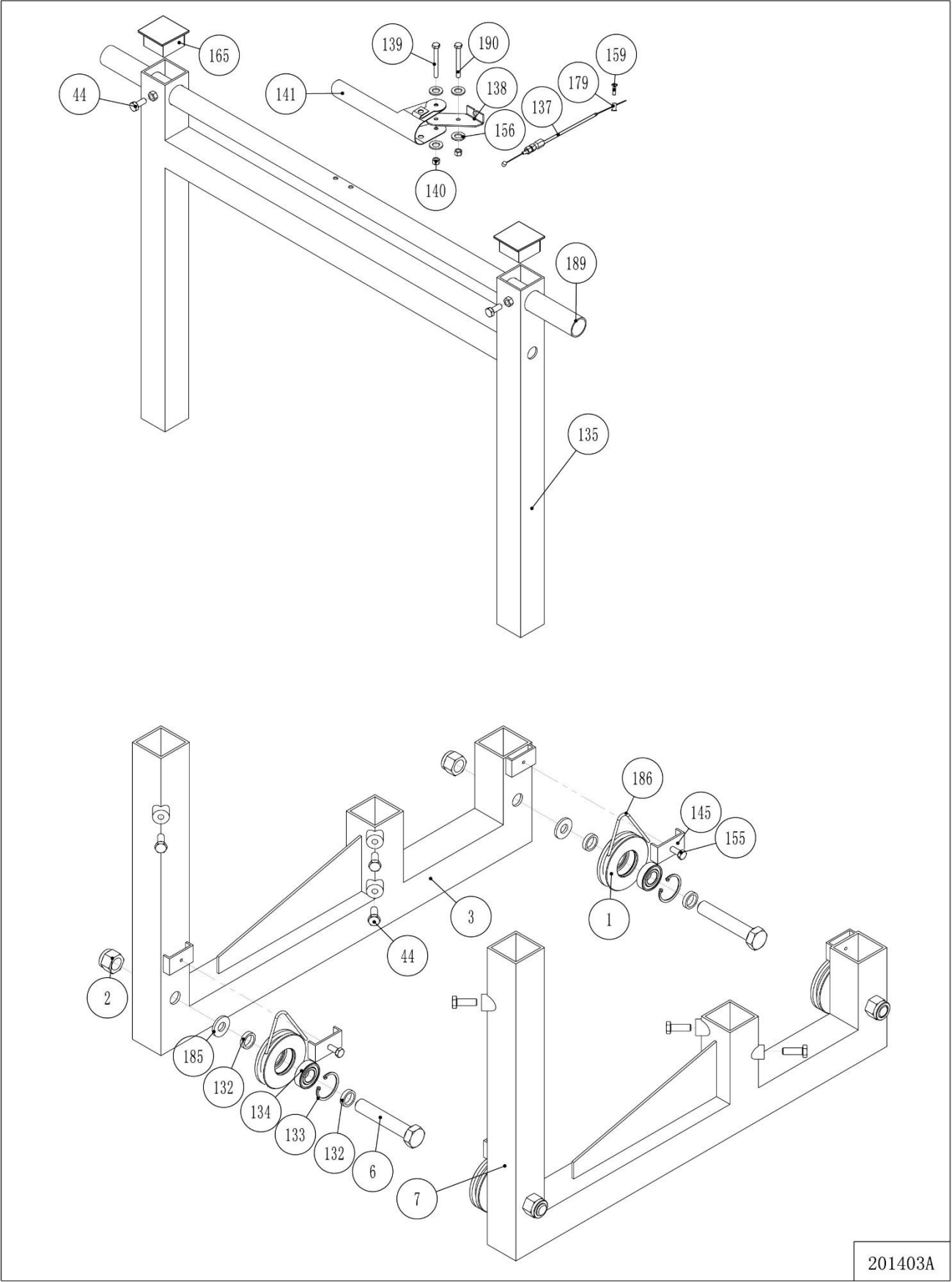
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DIAGRAM



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DIAGRAM



## NOTES

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