

MID-OREGON

RS-6

RE-RIPSAW

RIGHT HAND



AfterMarket Parts
Custom Design Equipment
New & Used Equipment
Installation & Training

LENT'S MACHINERY LLC

We are your Problem Solvers...

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SERIAL NO. 1995001-37905

MODEL NO. RS-6-460-6KA-ND

CUSTOMER: _____

DATE SHIPPED: 6-3-85

WARNING !!

NEVER PLACE ANY PART OF BODY UNDER SAW GUARD OR OPERATE SAW WITHOUT ALL GUARDS IN PLACE.

DO NOT OPEN COVERS OR WORK ON MACHINE WITHOUT FIRST SWITCHING OFF ELECTRICAL POWER.

DO NOT REMOVE INSPECTION PLATES, CHUTES OR GUARDS UNTIL MACHINE COASTS TO A FULL STOP AND POWER IS TURNED OFF AND TAGGED.

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PRE START-UP SAFETY CHECK

1. WORK AREA SHOULD BE CLEAN AND FREE OF DEBRIS.
2. ALWAYS WEAR EYE AND EAR PROTECTION.
3. REMOVE ALL LOOSE CLOTHING, TIES, RINGS, WATCHES, AND OR OTHER JEWELRY. ROLL UP LONG SHIRT SLEEVES.
4. DO NOT OPERATE ANY PIECE OF EQUIPMENT WHILE UNDER THE INFLUENCE OF ANY TYPE OF MEDICATION, ALCOHOL OR DRUGS.
5. DO NOT WORK WITH MATERIAL THAT IS TOO LARGE OR TOO SMALL TO HANDLE SAFELY.
6. GUARDS AND OTHER SAFETY DEVICES SHOULD BE IN PLACE AND USED AT ALL TIMES.
7. DISCONNECT THE MACHINE FROM ALL POWER SOURCES AND WAIT FOR BLADES TO COME TO A COMPLETE STOP BEFORE MAKING REPAIRS OR PERFORMING MAINTENANCE.
8. SHUT OFF ALL POWER SOURCES AND CLEAN THE MACHINE BEFORE YOU LEAVE IT.
9. ALWAYS USE A PUSH STICK OR AIR NOZZLE TO CLEAR AWAY KNOTS, CHIPS, AND SAWDUST.
10. NEVER PUT HANDS UNDER YELLOW GUARDS WHILE THE MACHINE IS RUNNING.
11. KEEP HANDS OUT OF PATH OF SAW BLADES.

PRE START-UP SAFETY CHECK

12. ALWAYS CHECK MACHINE FOR DAMAGED PARTS BEFORE USING IT. REPORT ANY PROBLEMS TO YOUR SUPERVISOR.
13. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
14. KEEP KICKBACK FINGERS CLEAN AND IN OPERATING POSITION. DO NOT OIL.
15. DO NOT STAND IN FRONT OF THE MACHINE WHILE MATERIAL IS BEING RIPPED.
16. NEVER LEAVE THE MACHINE RUNNING UNATTENDED. TURN OFF THE POWER AND DO NOT LEAVE MACHINE UNTIL THE BLADES COME TO A COMPLETE STOP.
17. NEVER ATTEMPT TO FREE JAMMED MATERIAL WITHOUT FIRST TURNING THE SAW OFF.
18. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF THE EQUIPMENT, OBTAIN ADVICE FROM YOUR SUPERVISOR, INSTRUCTOR OR OTHER QUALIFIED PERSONNEL.

INSTRUCTIONS

TO ADJUST ROLL HEIGHT

1. TURN OFF POWER TO SAW CAUTION: DO NOT ADJUST ROLL HEIGHT WITH SAW ARBOR SLAT BED ON. ALLOW SAW BLADE TO COAST TO A COMPLETE STOP !!!
2. REMOVE FRONT GUARD BY LIFTING UP AND OUTWARD.
3. SET BOARD OF DESIRED THICKNESS TO SIDE OF HOLD DOWN ROLLS.
4. LOOSEN BOTH HOLD DOWN ASSEMBLY LOCK HANDLES AT INFEED AND OUTFEED ENDS OF THE SAW. ADJUST TOP HAND CRANK HANDLES UP OR DOWN SO THAT THE BOTTOM OF THE HOLD DOWN ROLLS ARE BELOW THE TOP OF THE BOARD 1/8" MAX.
5. TIGHTEN BOTH HOLDDOWN LOCK HANDLES AND REPLACE GUARD.

REMOVAL OF SAW BLADE:

1. DISCONNECT POWER TO RERIP SAW AND ALLOW BLADE TO COAST TO A COMPLETE STOP !
2. REMOVE FRONT GUARD BY LIFTING UP AND OUTWARD.
3. REMOVE SIDE BAR ON THE HOLD DOWN ROLLS BY REMOVING THE (2) 1/4-20 NC SOCKET HD. SCREWS AND THE (2) 1/2 x 4 1/2 SHOULDER BOLTS AT THE OUTFEED END OF THE HOLD DOWN ROLL ASSEMBLY.
4. REMOVE SAW BLADE GUARD FRONT COVER BY REMOVING THE (3) SCREWS LOCATED ON FACE OF COVER.
5. TURN LOCK NUT ON SAW BLADE CLOCKWISE TO REMOVE SAW BLADE
6. REASSEMBLE IN REVERSE ORDER.
7. NOTE: INSTALL ALL GUARDS BEFORE OPERATION.

SLAT DRIVE PAD REMOVAL AND INSTALLATION

1. DISCONNECT AND LOCK OUT 480 VAC POWER SUPPLY.
2. REMOVE SIDE GUARDS AND SAW BLADE.
3. USE 5/32 ALLEN WRENCH TO REMOVE THE TWO (2) ALLEN HEAD SCREWS FROM THE FACE OF EACH EXPOSED PAD ON THE SLAT CHAIN.
4. RECONNECT POWER SUPPLY AND JOG THE BELT TO EXPOSE REMAINING PADS USING THE STOP/START PUSH/PULL BUTTON.
5. DISCONNECT AND LOCK OUT POWER SUPPLY. RETURN TO STEP 3. REPEAT UNTIL ALL PADS ARE REMOVED.
6. USING THE ABOVE METHOD INSTALL NEW PADS ON THE SLAT CHAIN. BE SURE TO LEAVE ONE PAD OFF FOR SAW BLADE INSTALLATION.
7. LOCATE THE LAST BARE PART OF THE SLAT CHAIN DIRECTLY BENEATH THE SAW BLADE SHAFT.
8. WITH THE POWER SOURCE DISCONNECTED AND LOCKED OUT REPLACE THE SAW BLADE AND SAW BLADE GUARD.
9. DO NOT RUN CHAIN BED UNTIL RUNNING GROOVE IS CUT INTO SLAT CHAIN PADS OR ELSE THE CHAIN, BLADE, AND MOTOR WILL BE DAMAGED!!!
RAISE HOLD DOWN WHEELS AND INSERT A 9' PIECE OF STOCK MATERIAL INTO THE FEED WORKS NO LESS THEN 1/2" FROM THE SAW BLADE. LOWER AND LOCK HOLD DOWN ASSEMBLY.
10. WITH THE HELP OF A CO-WORKER RECONNECT POWER SUPPLY. ONE WORKER MUST OPERATE THE START/STOP BUTTON WHILE THE OTHER CONTROLS THE M-1 AND M-2 FUSE BLOCKS LOCATED IN THE JUNCTION BOX. WORK ONE MUST OPEN THE M1 FUSE BLOCK DISARMING THE SLAT CHAIN DRIVE. WORKER TWO THEN STARTS THE SAW. WHEN THE BLADE HAS REACHED RUNNING SPEED WORKER ONE WILL CLOSE THE M1 FUSE BLOCK ENGAGING THE SLAT CHAIN FEED.
11. JOG AS REQUIRED TO EXPOSE THE FINAL MISSING PAD. DISCONNECT AND LOCK OUT POWER SUPPLY. INSTALL FINAL PAD.

RS-6 SUGGESTED MAINTENANCE SCHEDULE

1. BLOW DOWN MACHINE EVERY FOUR (4) PRODUCTION HOURS.
2. CHECK HOLD DOWN ASSEMBLY FOR EXCESSIVE LOOSENESS / PLAY EVERY 80 HOURS.
3. CHECK HOLDDOWN ROLLS FOR FREE ROTATION AND EXCESSIVE WEAR OR SLOP EVERY 80 HOURS.
4. CHECK KICKBACK FINGERS FOR FREE MOVEMENT, SHARPNESS AND LENGTH. R & R FINGERS WHEN WEAR EXCEEDS 1/8" ABOUT EVERY 300 HOURS.
5. CHECK DRIVE CHAIN TENSION EVERY 160 HOURS.
6. CHECK SLAT BED CHAIN FOR TENSION AND EXCESSIVE WEAR EVERY 160 HOURS
7. CHECK THE SLAT BED CHAIN RACEWAY FOR WEAR AND ADJUST WHEN SIDE PLAY EXCEEDS .015
8. CHECK SLAT BED INSERT FOR WEAR EVERY 160 HOURS.
9. CHECK AIR CYLINDER PISTON NUTS FOR TIGHTNESS EVERY SIX (6) MONTHS.
10. CHECK FOR SAW BLADE SHARPNESS EVERY 8,000 TO 15,000 LINEAL FEET.
11. PNEUMATIC SYSTEM LUBRICATION NEEDS TO BE REFILLED APPROXIMATELY EVERY 80 HOURS. THE SLAT BED CHAIN NEEDS TO BE LUBRICATED EVERY 40 HOURS. THE HEAD AND TAIL SHAFT BEARINGS NEED TO BE LUBRICATED EVERY 200 HOURS.

RS-6 SUGGESTED SPARE PARTS

<u>DESCRIPTION</u>	<u>PART NO.</u>	<u>QTY.</u>
SAW BLADE 12" DIA. 36T	4.26.1	1
SLAT BED INSERT	26.13.28.3	24
KICKBACK FINGERS	4.26.13.57.8	13
HOLD DOWN ROLL	4.26.31.187	7
HOLD DOWN ROLL	4.26.13.183	10
HOLD DOWN ROLL	4.26.13.184	10
PISTON CUP (1c OF 2c)	4.13.78.96	1
"O" RING	# 112	2
"O" RING	# 324	2
BULB, SYLVANIA	# 85	6
BULB, 120mb	# 120 MB	1
OUTPUT MODULE	# 1746-0B16	1
LASER	4.26.51	1

RS-6 TROUBLESHOOTING

A. NO POWER:

1. CHECK FUSES AT TRANSFORMER
2. CHECK FOR 480 VC AT TERMINAL STRIP

B. NO VDC POWER:

1. TRANSFORMERS FUSES MAY BE BLOWN
2. TRANSFORMER MAY BE BAD
3. FUSE MAY BE BAD AT TOP OF TERMINAL STRIP

C. SLAT BED CHAIN WILL NOT RUN:

1. TEST FOR POWER AT TRANSFORMER
2. CHECK TRANSFORMER FUSES
3. CHECK OVERLOAD
4. CHECK FOR BROKEN DRIVE CHAIN
5. CHECK FOR MISSING SPROCKET KEYS

D. ARBOR MOTOR WILL NOT RUN:

1. TEST FOR POWER AT TRANSFORMER
2. CHECK TRANSFORMER FUSES
3. CHECK CURRENT OVERLOADS
4. CHECK FOR BAD MOTOR BEARINGS
5. CHECK FOR SAW BLOCKAGE, BINDING
6. CHECK FOR 24 VDC POWER: BETWEEN THE RED & BLACK WIRES ON THE D.C. TERMINAL STRIP.
7. BAD PROCESSOR: CHECK ALL VOLTAGES, FUSE AND COMMUNICATION SIGNAL ON PROCESSOR.
8. BAD OUTPUT MODULE
9. BAD SOLENOID / VALVE
10. FENCE PHYSICALLY BOUND UP BY FOREIGN MATERIAL

RS-6 TROUBLESHOOTING

F. CUT PROBLEMS (SAW CUT ANGLED):

1. SAW ARBOR MOTOR NOT LEVEL OR SQUARE
2. HOLD DOWN ASSEMBLY LOOSE
3. SLAT BED INSERTS WORN
4. SLAT BED CHAIN GUIDES WORN

G. FENCE OFF BY SOME FIXED INCREMENT:

1. BAD MODULE - REPLACE
2. LASER NOT ALIGNED WITH SAW
3. FENCE NOT SET TO SAW

H. TAPERED:

1. AIR CYLINDERS HAVE EXCESSIVE SLOP
CHECK FOR WEAR IN CYLINDERS
CHECK FOR LOOSE PISTON NUTS
CHECK FOR WEAR AT CLEVIS
CHECK FOR LOOSE ANCHOR BOLTS
2. SAW MOTOR MIS-ALIGNED WITH STRAIGHT EDGE
3. STRAIGHT EDGE NOT ALIGNED WITH SAW
CHECK FOR LOOSENESS AT LOCK COLLARS
CHECK FOR LOOSE MOUNTING BOLTS ON GUIDE BOLTS
4. HOLD DOWN ASSEMBLY TENSION TOO LOOSE
TENSION ROLLS ON MATERIAL
5. EXCESSIVE SLAT BED CHAIN
ADJUST OR REPLACE GUIDES
6. HOLD DOWN ROLLS NOT MOVING FREELY



