

SHOP ORDER				<b>PORTLAND IRON WORKS</b>			PARTS LIST A 24362	
CUSTOMER				TITLE RIPSAW GENERAL ASSEMBLY - Nominal			DATE Aug. 9, 1984	
				RH Zero - Dual 8 1/2 Dia. Cutter - 5 saw			SHEET 1 OF 7	CODE 206
QTY	DED. PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE	
A		1	1	A 24362-D	Ripsaw General Assembly			
A		2	1	A 24373-D	Infeed Pressroll Assembly (See PL A 24373)			
A		3	1	A 24374-D	Outfeed Pressroll Assembly (See PL A 24374)			
A		4	1	A 8261-B	Anti-Kickback Assembly (See PL A8261)			
A		5	1	A 8922-D	Lubrication Cabinet Assembly (See PL A8922)			
S		6	1	8329-B	Lubricator Connecting Rod			
S		7	1	8330-B 1-& 2	Lubricator Crank Arm			
S		8	1	8677-B	Lubricator Drive Guard			
S		9	1	8166-B	Arbor Motor Base			
S		10	2	10322-B	Adjustment Block (Part of 8166-B)			
S		11	1	15003-B	Motor Base			
P		12	1		Motor, 75 HP, 3600 RPM, Frame #364-TS, Std Ball Bearing ODP, Elect Conn on Left (Facing Shaft End) 440 B, 3 PH, 60HZ			
P		13	1		Sheave, #3V-6.9, 10 Groove, HI-CAP w/QD bushing Type SK, 1-15/16" Bore			
		14	1		Sheave, #3V-6.0, 10 Groove, HI-CAP w/QD Bushing Type SK, 1 7/8" Bore			
P		15	2		Belt, 5 x 3V-850 Powerband			
F		16	1	24368-D	Arbor Drive Belt Guard			
S		17	1	8229-B	Setworks Support Bracket			
P		18	1		Gearmotor, Morse 3/4 HP, 58.4 RPM #20GCT30LF, TEFC, 440 V, 3 PH, 60 HZ			
P		19	1		Sprocket, DS 424-432, 1 7/16 Bore w/KS & 2 SS B 424#A93 MAKE FROM			
P		20	1		SPROCKET TLB 424			
P		20a	1		Bushing #1610, 1 7/16 Ø			
P		21	1		Sprocket, TBL-424			
P		22	1		Bushing, #1610, 1" Bore			
P		23	1		Chain, RC 40, 60 Pitch Loop			
P		24	1		Chain, RC 40, 64 Pitch Loop			
P		25	1		Chain, RC 50, 68 Pitch Loop			
S		26	2	7712-B	Solid Pillow Block			
P		27	2		Bronze Bushing, 1 15/16 OD x 1 7/16 x 1"			
		28						
F		29	1	24375-B	Front Eye Bracket			
F		30	1	20687-B	Rear Eye Bracket			
P		31	2		Proximity Head, OPCON #1370A-6501			
P		32	2		Demodulator, OPCON #8171B-6501			

SHOP ORDER		<b>PORTLAND IRON WORKS</b>			PARTS LIST A 24362	
CUSTOMER		TITLE RIPS AW GENERAL ASSEMBLY - Nominal RH Zero, - Dual Cutter - 5 Saw			DATE Aug. 9, 1984	
					SHEET 2 OF 7	CODE 206
CHK DED. PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
P		33	2			
				TRANSISTOR, OPKON 8586A-6501		
				<del>Guide Rod, OPKON 8586A-6501</del>		
				<del>Cable, OPKON 8586A-6501</del>		
S		35	2	20225-B		Step
P		*36	1			Sprocket, B620, 1 3/4" Bore, 1 1/4" LTB (*OPT)
P		*37	1			Bearing, Torrington #HJ-202920 (*OPT)
P		*38	1			Inner Race, TORRINGTON #IR-162020 (*OPT)
P		*39	1			Set Collar, 1" ID
P		*40	1			Chain, RC 60, 62 Pitches (*OPT)
S		*41	1	8231-B		Idler Bracket (*OPT)
S		*42	1	8238-B		Idler Sprocket Bracket (*OPT)
			43			
S		44	1	11536-B		Guide Rod Support Bearing, Pattern E-723
S		45	2	5694-8-C		Guide Rod Support Bracket
			46			
			47	24415-B		Top Cover, Infeed Safety Shroud
P		48	2			BUTT Hinge 4" x 3" lg (For 24415-B)
A		49	1	A 24363-D		Base Assembly Plan
A		50	1	A 24364-D		Base Assembly Sections
S		51	1	A 8160-B		Main Frame
A		52	1	24365-B		Hole Pattern - Infeed Side
A		53	2	8162-B		Hole Pattern - Outfeed Side
PT of 51		54	2	8163-B		Sawdust Chute (Part of 8160-B)
F		55	1	24366-D		Infeed Frame
S		56	1	9354-B		Formed Skirt
S		57	1	9355-B		Waste Chute
F		58	1	9653-B		Outfeed Frame
S		59	1	20278-B		Drive End Plate
PT of 51		60	1	A 9871-B		Trunion End Plate
S		61	1	8567-B		Removable End Plate
S		62	1	8568-B		Swinging Arbor Plate
S		63	1	20008-B		Support Bar RS-9 LH (opposite zero)
of 63		64	2	5718-B		Support Bar Casting (Part of 20008-B)
S		65	1	20009-B		Support Bar RS -9RH
PT of 65		66	*	5718-B		Support Bar Casting (Part of 20009-B)
			67			
S		68	1	8154-B		Outfeed Guide Shoe

SHOP ORDER			<b>PORTLAND IRON WORKS</b>			PARTS LIST 24362		
CUSTOMER			TITLE			DATE August 9, 1984		
			RIPSAW GENERAL ASSEMBLY - Nominal			SHEET 3 OF 7 CODE 206		
			RH Zero - Dual 8 1/2 Dia. Cutter - 5 saw					
CK	DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
S			69	1	8170-B	Zero Guide Shoe		
S			70	1	8597-B	Infeed Skid Plate		
S			71	1	8522-B	Front Bed Skids		
S			72	1	24176-B	Front Bed Plate		
S			73	1	19354-B	Center Bed Plate		
S			74	1	19357-B	Dust Deflector		
S			75	1	8173-B	Rear Bed Plate		
S			76	1	20274-B	Driven Bed Roll Assembly		
S			77	2	20276-B	Mount Block		
PT of 76			78	1	20275-B	Bed Roll (Part of 20274-B)		
P			79	2		Bearing, FAFNIR #GC1107KRRG-2		
PT of 76			80	1		Shaft, 1 7/16" Diameter x 6'5" long (Part of 20274-B)		
P			81	1		Bearing, FAFNIR #RCJTC1 7/16"		
P			82	1		Sprocket B518, 1 7/16" Bore w/KW & 2 SS @ 90°		
A			83	1	A 11720-B	Bed Roll Assembly		
S			84	1	11721-B	Roll		
			85	2		Bearing, FAFNIR #GC1115KRRG-2		
S			86	2	11722-B	Mount Block		
P			87	1	8177-2-B	Outfeed Belt Pulley, 10" Dia 32" CR Face 1 15/16 Diameter; ONE SIDE FINISHED BO	VAN GORD w/XT HUB	
S			88	1	8177-1-B	Shaft, 1 15/16" x 57 1/2"		
P			*89	1		Sprocket, #632 TLB		(*Optional)
P			*90	1		Bushing, #2012, 1 15/16" Bore		(*Optional)
P			91	4		Bearing, Flanged, FAFNIR #RCJTC1 7/16"		
S			92	1	8188-B	Infeed Roll		
P			93	*		Bearing, Flanged, FAFNIR #RCJTC1 7/16"		
			94					
F			95	1	24090-1-D	RH Dust Hood Base		
F			96	1	24367-2-D	RH Dust Hood (detailed on 24395-D)		
F			96a	1	24096-1-B	Hold Down Bar (R.H.)		
S			97	1	8533-B	Dust Collector Transition		
F			98	1	24090-2-D	LH Dust Hood Base		
F			99	1	24367-1-D	LH Dust Hood (Detailed on 24395-D)		
			99a	1	24096-2-B	LH Hold Down Bars		
			99b	1	24096-3-B			
S			100	1	8531-B	Telescoping Dust Tube - Male End		
S			101	1	8532-B	Telescoping Dust Tube - Female End		
S			102	1	8204-B	Dust Tube Bracket		
F			103	1	20115-B	Dust Tube Support Base		

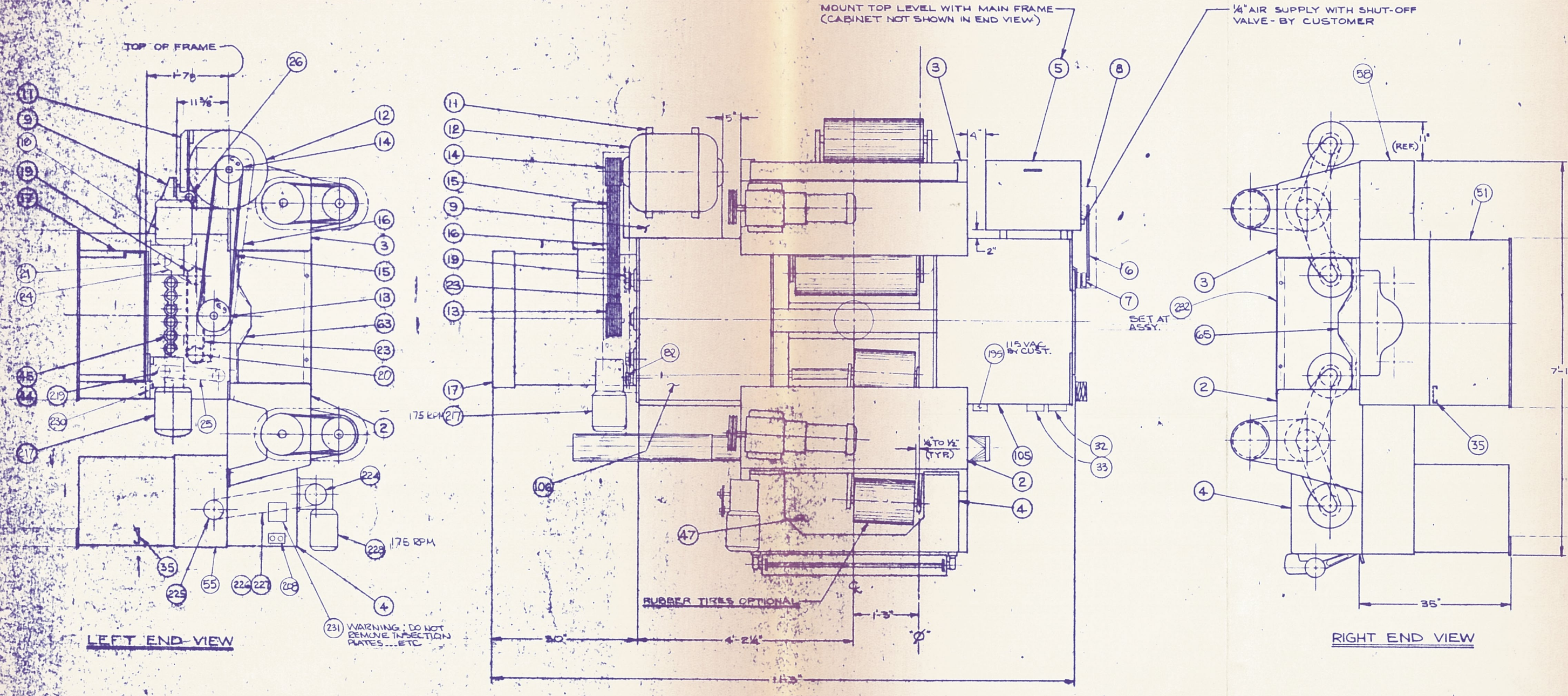
SHOP ORDER		<b>PORTLAND IRON WORKS</b>				PARTS LIST A 24362		
CUSTOMER		TITLE RIPSAW GENERAL ASSEMBLY - Nominal RH Zero - Dual Cutter - 5 saw				DATE August 9, 1984		
						SHEET 4 OF 7	CODE 206	
QTY	DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
			104	1	8203-B	Setting Cutter Cover Plate		
			105	1	8190-B	Cover Plate - Zero Side		
			106	1	8191-B	Cover Plate - Opposite Side Zero		
			107					
			108	1	24369-D	Carriage Assy. for Fixed Cutter		
			108a	1	24370-D	Carriage Weldment for Fixed Cutter		
			108b	2	24097-B	Support Bar		
			109	1	8192-B	Fixed Cutter Adj. Nut		
			110	1	70725-B	Flat Washer, 5/8" ID		
			111	1	16733-B	Fixed Cutter Lock Bracket		
			112	2	9801-B	Handle, REID TOOL		
			113	1	24124-2-B	Cutterhead Stop Block		
			114	1	24371-D	Carriage for Moving Cutter		
			114a	1	24372-D	Carriage Weldment for Moving Cutter		
			114b	*	24097-B	Support Bar		
			115	4	8195-B	Carriage Wheel Fender		
			116	8	8196-B	Carriage Rail Wiper, CHICAGO RAWHIDE #22002		
			117	4		Cam Roller, TORRINGTON #CRS20		
			118	1	16635-D	Cutter Cylinder Carriage		
			PT of 118	1	16585-D	Carriage Casting (Part of 16635-D)		
			120	1	16661-B	Bearing Block, UHMW (Carriage Shoe)		
			A/S	1		Socket Head Cap Screw w/nut 3/8" x 1 1/2" long		
			122	1	16636-B	Guide for Moving Cutter		
			PT of 122	1	16584-B	Guide Casting (Part of 16636-B)		
			PT of 122	2		Bronze Bushing 3 3/8" OD x 3" ID x 2 1/2" long (Part of 16636)		
			A			Moving Cutter Cylinders (See Setworks P. List)		
			126	2	8180-B	Cutter Head Rails		
			127	1	15157-B	Cutter Head Spacer		
			128	2		Cutter Head, Disston #908P 2 1/4 w/#3811 sleeve, 8 1/2" Cutting Circle, 8 knife, 2 1/4" long, 1 13/16" Spindle w/Spanner Wrench ONE L.H. & ONE R.H.		
			129	2		Cutter Head Motor, BALDOR - 3600 RPM, 10 HP, 60HZ TEFC, 6260 M Frame 460V		
			130					
			131	1	12525-B	Arbor, 2 15/16" Dia x 8'-10 1/2" long stressproof		
			132	1		Bearing, LINK-Belt #FC-331, 1 15/16" Bore		
			133	2	8571-B	Shifter Support Guide Shaft, 3" diameter x 8'-11"		
			134	4		Bearing LINK-BELT #FC 323, 1 7/16" Bore		

SHOP ORDER			<b>PORTLAND IRON WORKS</b>				PARTS LIST A 24362	
CUSTOMER			TITLE RIPS AW GENERAL ASSEMBLY - Nominal RH Zero - Dual Cutter - 5 saw				DATE August 9, 1984	
							SHEET 5 OF 7	CODE 206
CK	DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
			135					
A			136	5	A 8194-D	Bridge Tree Assemblies		
S			137	2	A 9873-B	Bridge Tree Assembly		
S			138	3	A 9875-B	Bridge Tree Assembly		
PT OF 137			139	5	8184-B	Shifter Support		
/			140	10	9874-B	Bushing, Bronze MASTEN #SL-3001-32		
/			141	5	8232-B	Bearing Housing		
/			142	10	8233-B	Tie Bolt, 3/4" NC w/nut		
PT OF 137			143	5	13-24	"O"-Ring" Seal, VALVAIR #H-134-66		
P			144	5		Bearing, SKF #6017 or FAFNIR #9117		
S			145	5	8595-B	Bearing Retainer, Lock Nut Side, Pattern RS-14AL.		
S			146	5	8596-B	Bearing Retainer w/oil groove, Pattern RS-12-AL		
S			147	5	16-4	Lockwasher, SKF #W-17		
S			148	5	7243-A	Dust Shield (Spot Weld to SKF #AN-17)		
PT OF 148			149	5		Locknut, SKF #AN-17		
S			150	4	8588-B	Bearing Collar, Plain		
			151	8	10530-B	Bearing Collar Key w/(8) Soc. HD. Cap Screw 5/16 NC x 1" long)		
S			152	1	*A 9597-B	* Saw Collar Assembly, Spool Type *Change to 20138-B for 13/16 Nominal		
S			153	1	9045-B	Saw Collar, Spool Type (Part of 9597-B)		
PT OF 153			154	1	9718-B	Bearing Collar, Spool Type (Part of 9597-B)		
PT OF 153			155	2	9601-1-B	Key, Saw Collar (Part of 9597-B)		
S			156	4	*A 9598-B	* Saw Collar Assembly, Plain *Change to 20137-B for 13/16 Nominal		
PT OF 156			157	4	9044-B	Saw Collar (Part of 9598-B)		
PT OF 156			158	8	9601-2-B	Key, Saw Collar (Part of 9598-B)		
S			159	5	* 9046-B	* Saw Collar Clamp Ring *Change to 14670-B for 13/16 Nominal		
A/S			160	30	*	Cap Screw, *Socket Head, 5/16 NC x 5/8" long *Change to Flat Head for 13/16 Nominal		
S			161	5	16152-D	Carbide Saws, 12" Diameter, 36 Tooth "No Bind"		
S			162	4	8580-1-B	Shifter Bar, 15 5/8" C-C, Spring Steel		
			163	2	8580-2-B	Shifter Bar, 28 1/4" C-C, Spring Steel		
S			164	2	8580-7-B	Shifter Bar, 3" C-C, Spring Steel		
S			165	8	7310-B	Cap Screw, Allen Head Special		
			166					
A			167	1	6909-D	Arbor Assembly Reference Drawing		

SHOP ORDER		<b>PORTLAND IRON WORKS</b>				PARTS LIST A 24362
CUSTOMER		TITLE RIPSAW GENERAL ASSEMBLY - Nominal RH Zero - Dual Cutter - 5 Saw				DATE August 9, 1984
						SHEET 6 OF 7 CODE 206
CK DED. PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
A	168	1	15831-D	Arbor Assembly Reference Drawing		
S	169	6	8235-B	Hose Assembly		
	170					
S	171	1	8193-1-B	Shifter Rod "A" 76"		
S	172	1	8193-2-B	Shifter Rod "B" 88"		
S	173	1	8193-3-B	Shifter Rod "C" 99 1/2"		
S	174	1	8193-4-B	Shifter Rod "D" 51"		
S	175	1	8193-5-B	Shifter Rod "E" 62 1/2"		
S	176	1	8193-6-B	Shifter Rod "F" 43"		
	177					
	178					
S	179	1	8534-B	Saw Cover Plate		
	180					
S	181	1	8536-B	Lower Sawdust Hopper (Details 24413-D)		
S	182	1	8537-B	Dust Hopper Inspection Door		
S	183	1	8538-B	Dust Hopper Side Plate		
	184	1	8579-B	Infeed Chip Hopper		
F	185	4	7274-B	Screen for Sawdust Hopper (Ship Loose)		
F	186	2	8587-B	Screen for Chip Hopper (Ship Loose)		
F	187	1	19946-B	Transition Dust Hood		
A/S	188	1		Cable, Type SO 14 Ga, 3 Conductor x 6'0" long		
A/S	189	1		Flex Conduit, 3/4" x 6'0" long		
P	190	2		Box, Cal w/ 3/4" Thread Conn - Bell #252L		
P	191	1		Box, Cal w/ 1/2" Thread Conn - BELL #251L		
P	191	3		Box Covers, BELL #240AL		
A/S	193	2		Connectors, C-H #CAB 195		
A/S	194	2		Connectors, APPLETON #ST75		
P	195	1		Box, HOFFMAN A-806LP		
P	196	1		PANEL A-8PG		
S	197	6	20026 B	SPRAY NOZZLE PIPE <small>1/2" brass</small>		
PT of 197	198	6		NOZZLE, ALEMITE, Z737 <small>1/2" brass</small>		
PT of 197	199	6		PIPE NIPPLE 3/8 x 7		
A/S	200	6		Pipe Coupling, 3/8"		
	201	6		Pipe Reducer, 3/8" x 1/4"		
	202	18		Elbow Adapter, 90°, 1/4" NPT to 7/16 - 20 SAE		
	203	12		Swivel Push-on, 7 1/6 - 20 SAE to 1/4" hose		
	204	6		Elbow, 90°, 1/4" ST		
A/S	205	6		Pipe Coupling, 1/4"		



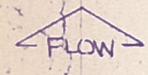
SYM.	NO. REQD.	DESCRIPTION



LEFT END VIEW

RIGHT END VIEW

PLAN



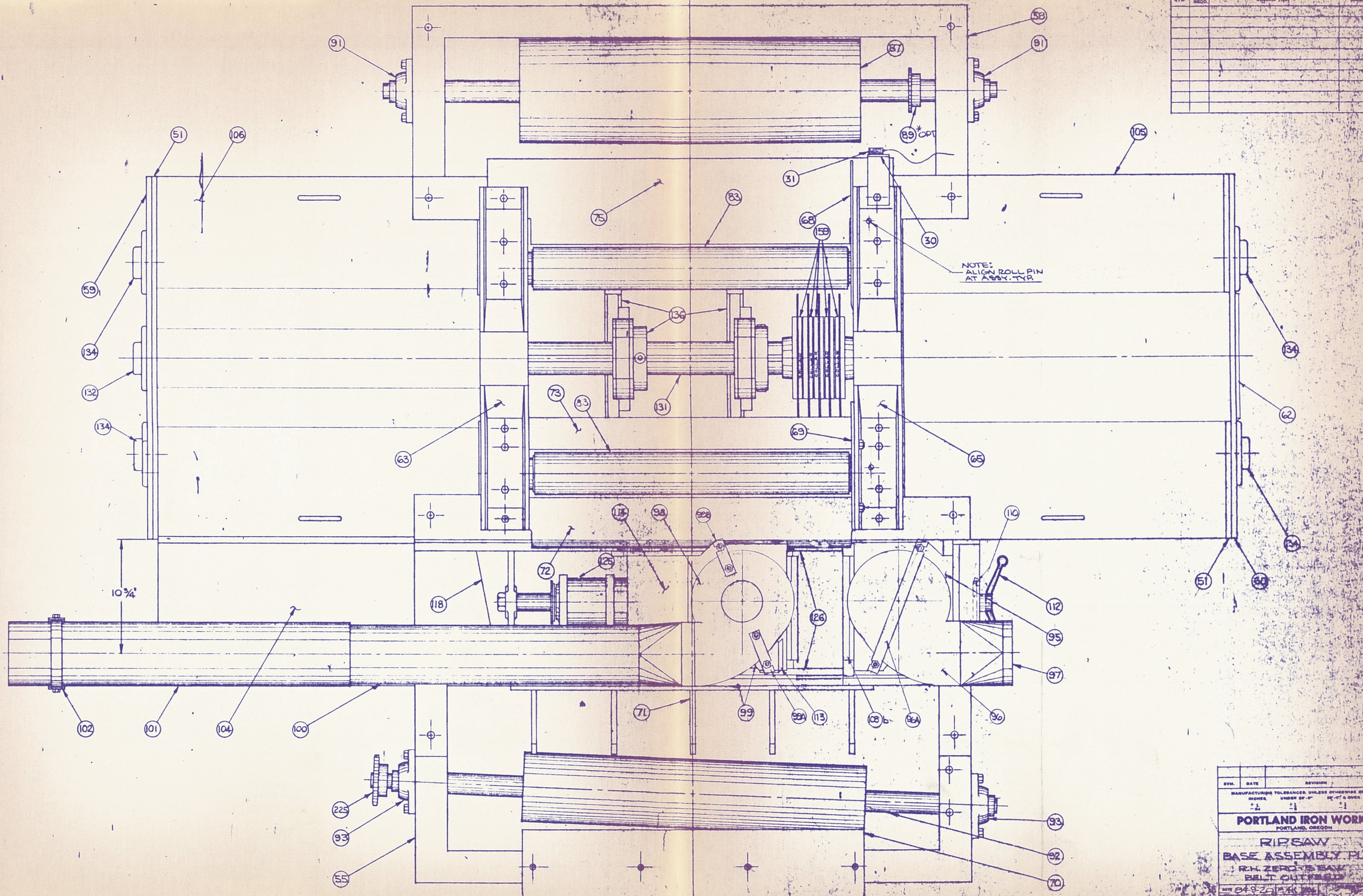
WARNING: DO NOT REMOVE INSPECTION PLATES...ETC

U.S. PATENT NO. 3,202,189  
 SWEDISH PAT NO 212,631  
 CANADIAN PAT NO. 742,508

SYM.	DATE	REVISION	BY
MANUFACTURING TOLERANCES UNLESS OTHERWISE STATED			
INCHES		UNDER .01"	.01" & OVER
+		-.001	-.002
<b>PORTLAND IRON WORKS</b> PORTLAND, OREGON			
<b>RIPSAW</b> GENERAL ASSEMBLY R.H. ZERO-5 SAW-BELT-CUT WITH DUAL CUTTER			
REV. 6-12-89		MAK	206
PART NO. 11-1-0		B/A 24362	



SYM.	NO.	DESCRIPTION	DATE



SYM.	DATE	REVISION

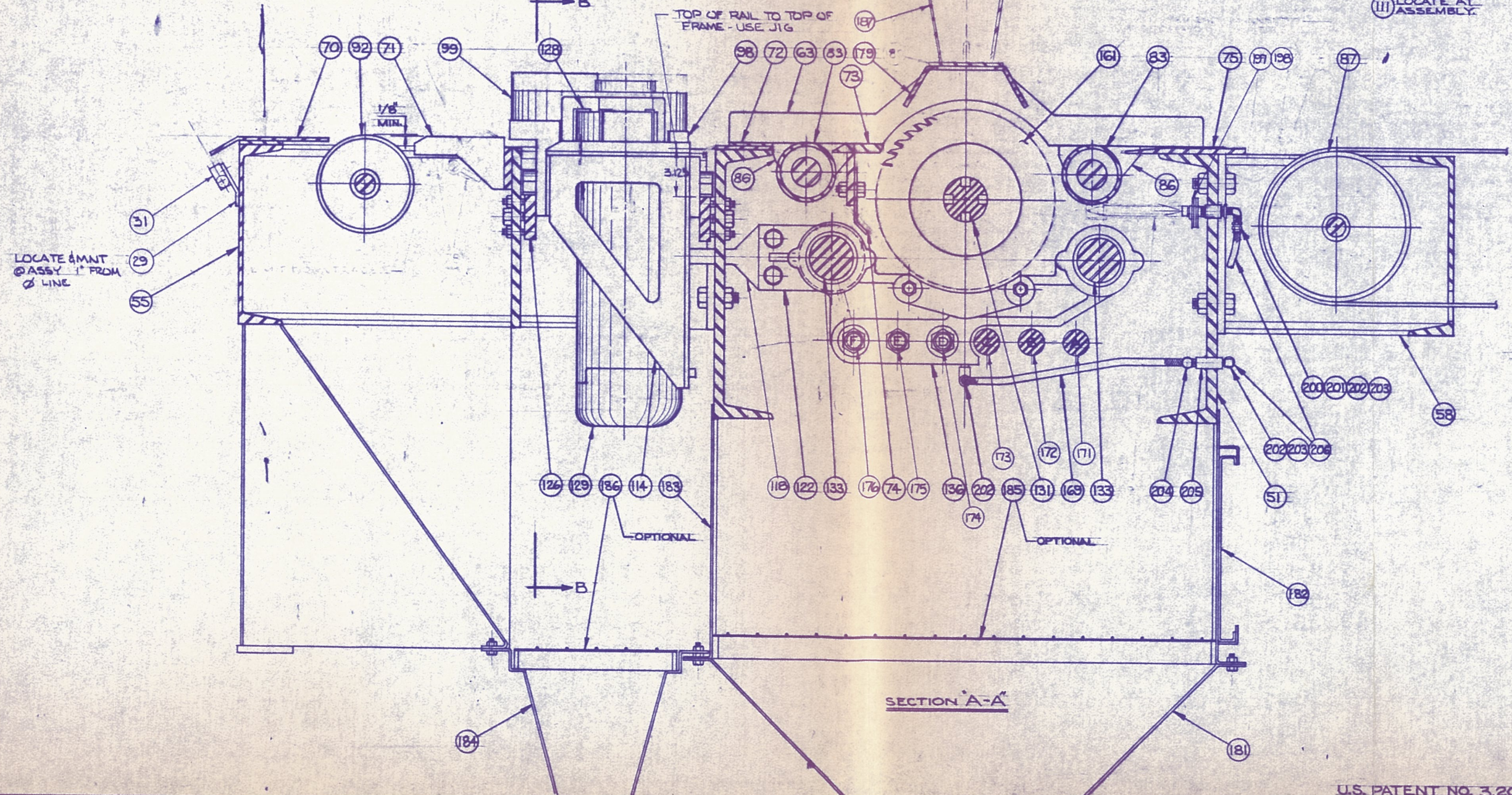
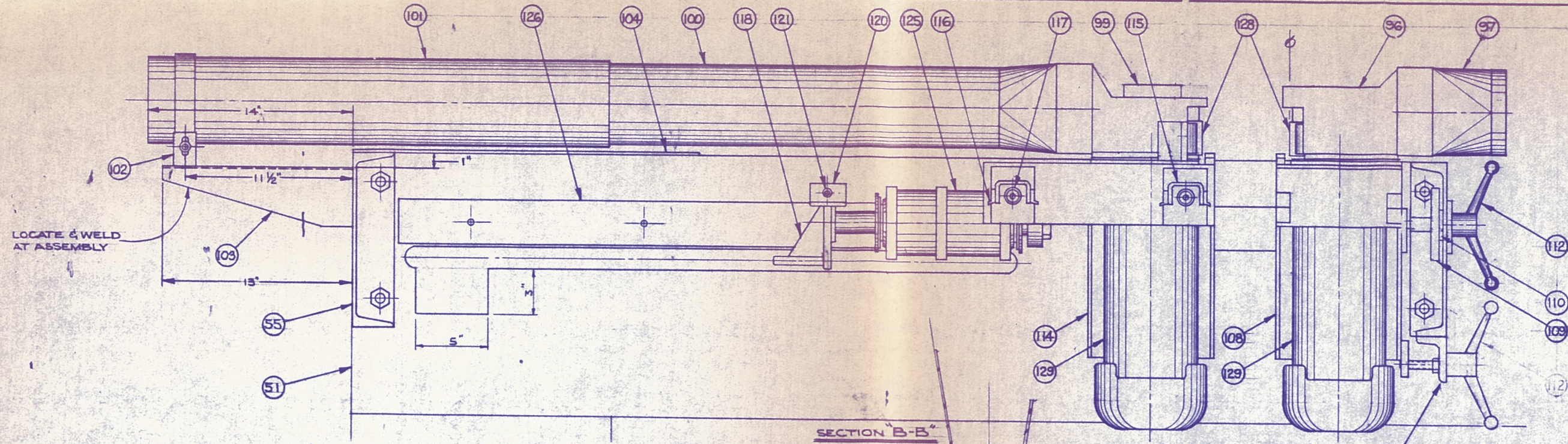
MANUFACTURING TOLERANCES, UNLESS OTHERWISE STATED:  
 HIGHER UNDER 20" 24" & OVER  
 .0005 .0010 .0015

**PORTLAND IRON WORKS**  
 PORTLAND, OREGON

**RIPSAW**  
 BASE ASSEMBLY PLAN  
 R.H. ZERO'S SAW  
 BELT OUTFEED

848-291248  
 24363

SYM.	NO.	DESCRIPTION	DWG. NO.



SYM.	DATE	REVISION	BY
MANUFACTURING TOLERANCES, UNLESS OTHERWISE STATED			
INCHES UNDER .50" .50" & OVER			
$\frac{.015}{16}$	$\frac{.031}{32}$	$\frac{.062}{64}$	$\frac{.125}{16}$
<b>PORTLAND IRON WORKS</b>			
PORTLAND, OREGON			
<b>RIPSAW</b>			
<b>BASE ASSEMBLY SECTIONS</b>			
<b>R.H. ZERO-5 SAW</b>			
<b>BELT OFFFEED</b>			
DATE 04-9-21	BY AK	206	DRAWING NUMBER

U.S. PATENT NO. 3,202,189

SHOP ORDER

12982

## PORTLAND IRON WORKS

PARTS LIST A24373

CUSTOMER

HARRIS

TITLE

RIPSAW INFEED PRESSROLL ASSEMBLY  
RH Ø with Rubber Rolls

DATE February 25, 1986

SHEET 1 OF 2 CODE 206

STOCK	DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
A			1	1	A24373	RIPSAW INFEED PRESSROLL ASSEMBLY		
A			2	1	A18755-B	Infeed Pressroll Frame Assembly		
F			3	1	A18700-B	Infeed Pressroll Frame Weldment		
PART OF 3			4	2	18701-B	Frame Support		
PART OF 3			5	1	18375-2-B	Frame Top A=18-1/8"		
S			6	1	21383-B	Moton Adjusting Base		
F			7	2	24539-B	Lifting Bracket		
PART OF 3			8	1	18382-1-B	Gusset A=18-1/8 B=18-5/8 (Part of 18700)		
S			9	2	18396-B	Lifting Bracket		
A			10	1	A24230	Infeed Front Roll Assembly		
S			11	2	A15167-B	Infeed Roll Assembly, COLUMBIA #1092R Cover		
PART OF 11			12	2		Set Collar 1 1/2" w/2 SS @ 90 Deg.		
PART OF 11			13	2		Weld Hub, BROWNING #HCQ-1		
PART OF 11			14	2		Bushing, BROWNING #Q-1, 1 1/2" Bore w/KS		
P			15	4		Bearing, DODGE SCM - 1 1/2" Piloted Flange		
PART OF 11			16	2	18392-B	Roll Shaft, 1 1/2" Ø x 24 1/2" long		
F			17	2		Sprocket, BROWNING #60 Q20		
P			18	2		Bushing BROWNING Q-1 x 1 1/2 Bore w/KS		
			19					
S			20	2	18393-B	Front Pressroll Arm Weldment		
PART OF 20			21	4	8213-B	Pressroll Arm		
S			22	2	8547-1B	Lift Ear (Part 1)		
			23					
A			24	1	A24231-B	Infeed Back Roll Assembly		
S			25	*	A15167-B	Roll Assembly, COLUMBIA #1092R Cover		
PART OF 25			26	*		Set Collar 1 1/2" Bore w/2SS @ 90 deg.		
PART OF 25			27	*		Weld Hub, BROWNING # HCO-1		
PART OF 25			28	*		Bushing, BROWNING #Q-1, 1 1/2" Bore w/KS		
P			29	*		Bearing, DODGE SCM-1 1/2" Piloted Flange		
PART OF 25			30	*	18392-B	Roll Shaft, 1 1/2" Ø x 24 1/2" long		
P			31	*		Sprocket, BROWNING #60 Q20		
P			32	*		Bushing, BROWNING Q-1 x 1 1/2 Bore w/KS		
			33					
S			34	*	18393-B	Infeed Back Roll Arm Weldment		
PART OF 34			35	*	8213-B	Pressroll Arm		
S			36	*	8547-B	Lift Ear		

SHOP ORDER

12982

# PORTLAND IRON WORKS

PARTS LIST A24373

CUSTOMER

HARRIS

TITLE

RIPSAW INFEED PRESSROLL ASSEMBLY

DATE February 25, 1986

RH Ø with Rubber Rolls

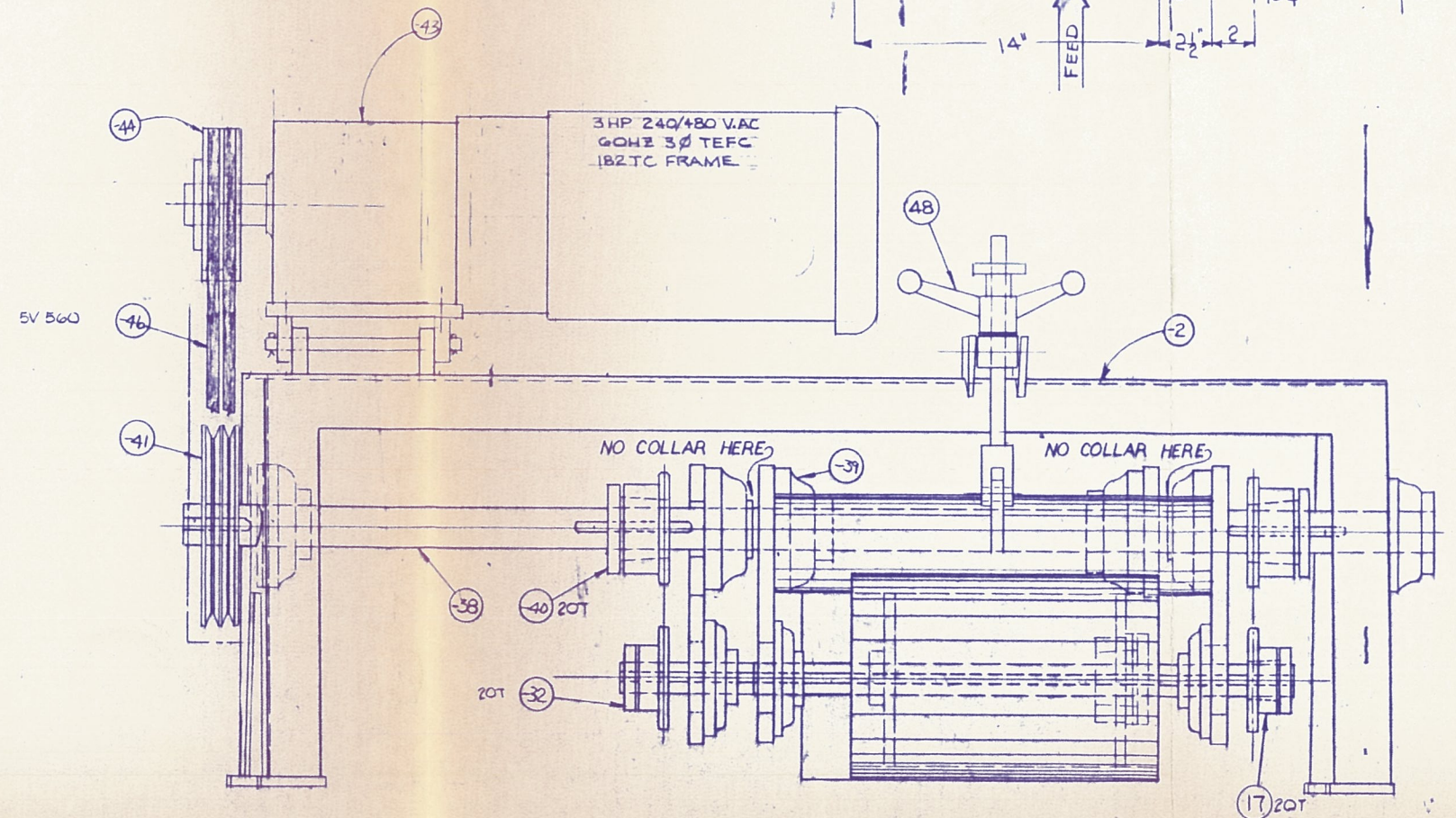
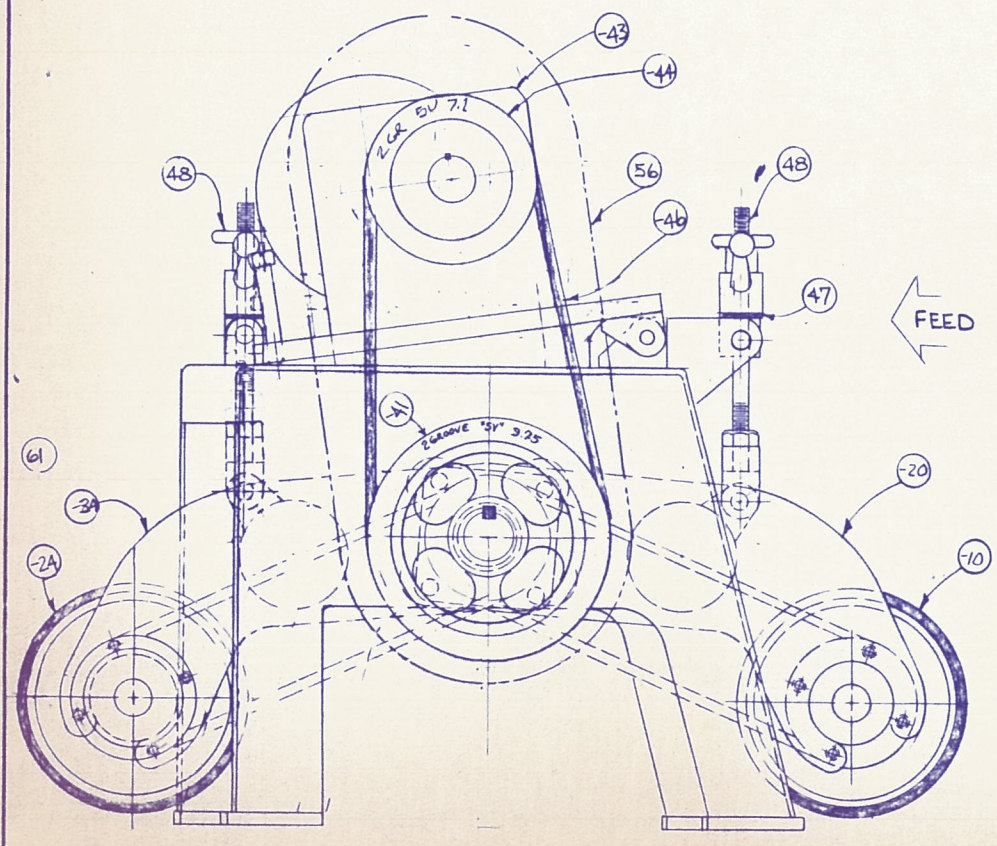
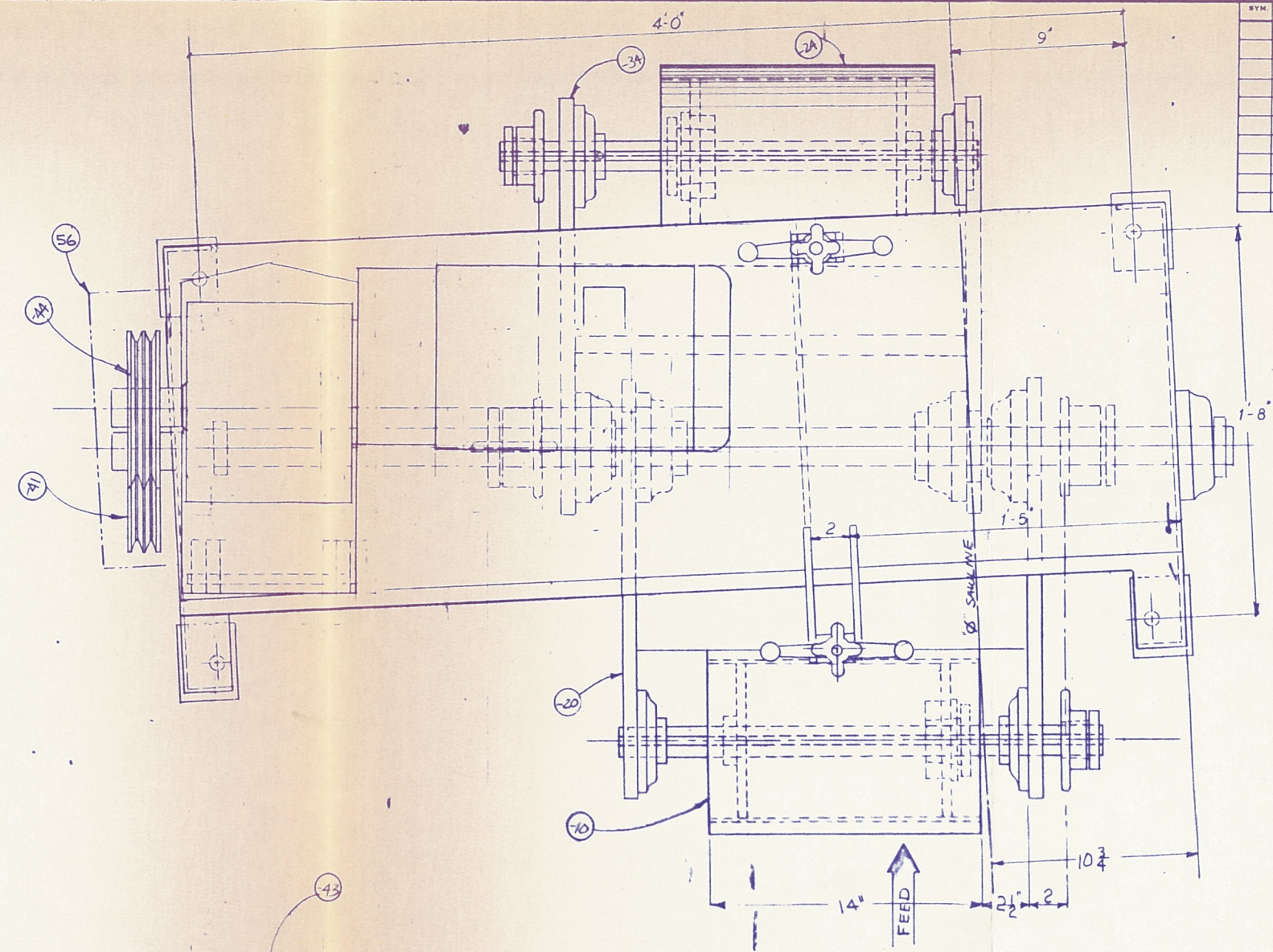
SHEET 2 OF 2 CODE 206

STOCK DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
------------	------	----------	-----------	----------	-------------	------	------

			37				
F			38	1	A18395		Pivot Shaft Assembly, 1-15/16" x 57/8" long
P			39	6			Bearing, FAFNIR #RCJ, 1-15/16"
P			40	2			Sprocket, BROWNING #60 Q 20
P			41	1			Sheave, 2 Groove "5V", 9.75" OD w/ QD Hub
							& #SK, Bushing, 1-15/16" Bore w STD KS
P			42	2			Q-1 Bushing 1 15/16 Bore w/KS (No sub)
P	*		43	1			Gearmotor, 3HP, 155 RPM, US Hercules Integral Gearmot
							.182T-12, TFGD19 TEFC Mod 764 440V AC, 60 HZ, 3PH
P			44	1			Motor Sheave, 2 Groove "5V" 7.1 OD w/QD Hub
P			45	1			QD Bushing #SK, 1 7/8" Bore w/STD KS
P			46	2			Belts #5V560 (Matched Set)
F			47	2			Washer, Cover Belting 1 3/4 Ø x 1/4 thk w/ 3/4 Ø in cen
A			48	2	A18384-B		Support Hanger Assembly
S			49	2	10001-B		Clevis
S			50	2	9801-B		Malleable Ball Handle
S			51	2	9802-B		Hand Knob
S			52	2	8545-B		Spacer Block
S			53	4	8546-B		Spacer Block Set Screw
S			54	2	11005-B		Bolt, 5/8" Ø x 10" long
S			55	2			Pin, 5/8" Ø x 2 1/2" long (Dorman, Clevis)
F			56	1	18385-B		Drive Guard
P			57	2			Riveted Roller Chain, #RC60, 62 Pitches long

\* PRE ORDERED

SYM.	NO.	RECD.	DESCRIPTION	DWG. NO.



SYM.	DATE	REVISION	BY
MANUFACTURING TOLERANCES, UNLESS OTHERWISE STATED			
INCHES UNDER .001" .001" & OVER			
+ .001 / - .001    + .001 / - .001    + .001 / - .001			
<b>PORTLAND IRON WORKS</b>			
PORTLAND, OREGON			
RIPSAW INFEED PRESSROLL ASSY. (R.H. ASSY.)			
DATE	BY	DRAWING NUMBER	DWG. NO.
8-15-57	M.S.	206	A24373
SCALE 3" = 1'-0"			

SHOP ORDER		PORTLAND IRON WORKS				PARTS LIST A24374	
12982		TITLE RIPSAW OUT FEED PRESSROLL ASSEMBLY				DATE February 25, 1986	
CUSTOMER		RH Ø with Rubber Rolls				SHEET 1 OF 2 CODE 206	
HARRIS							
STOCK DED.	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
		A	1	A24374-D	RIPSAW OUTFEED PRESSROLL ASSEMBLY		
		A	2	A18757-B	Outfeed Pressroll Frame Assembly		
		S	3	18374-B	Outfeed Pressroll Frame Weldment		
	PART OF 3		4	18375-1-B	Frame Top A = 16 1/4"		
	PART OF 3		5	18377-B	Frame Support		
	PART OF 3		6	18382-2-B	Gusset A = 16 1/4" B = 16- 3/4"		
		S	7	21383-B	Motor Adjusting Base		
		F	8	24539-B	Lift Bracket		
		S	9	18396-B	Lift Bracket		
		A	10	A24232	Outfeed Front Roll Assembly		
		S	11	A15171-B	Roll Assembly, COLUMBIA #1092R Cover		
	PART OF 11		12		Set Collar, 1 1/2" w/ 2 SS @ 90 deg.		
	PART OF 11		13		Weld Hub, BROWNING #HCQ1		
	PART OF 11		14		Bushing, BROWNING #Q-1, 1 1/2" Bore w/KS		
		P	15		Bearing, DODGE SCM-1 1/2" Piloted Flange		
		P	16		Sprocket, BROWNING #60 Q 20		
		I	17		Bushing, BROWNING Q-1 x 1 1/2		
		S	18	A18379-B	Front Pressroll Arm Weldment		
	PART OF 18		19	8213-B	Pressroll Arm		
		S	20	8547-B	Lift Ear		
			21				
		A	22	A24233-B	Outfeed Back Roll Assembly		
		S	23	10800-B	Roll Weldment		
		P	24	*	Bearing, DODGE SCM - 1 1/2" Piloted Flange		
		P	25	1	Sprocket, BROWNING #60 P22, 1 1/2" Bore w/STD KS		
		S	26	A18380-B	Outfeed Back Roll Arm Weldment		
	PART OF 26		27	* 8213-B	Arm		
		S	28	* 8547-B	Lift Ear		
			29				
		F	30	A18381-B	Pivot Shaft Assembly, 1 15/16" dia. x 5 7/8"		
		P	31	6	Bearing, FAFNIR #RCJ - 1 15/16"		
		P	32	2	Sprocket, BROWNING #60Q20		
		P	33	1	Sheave, FORT WORTH, 2 Groove "5V", 9.75" OD		
					w/ SK Bushing, 1 15/16" Bore w/ STD KS		
			34				

SHOP ORDER

12982

CUSTOMER

HARRIS

## PORTLAND IRON WORKS

PARTS LIST A 24374

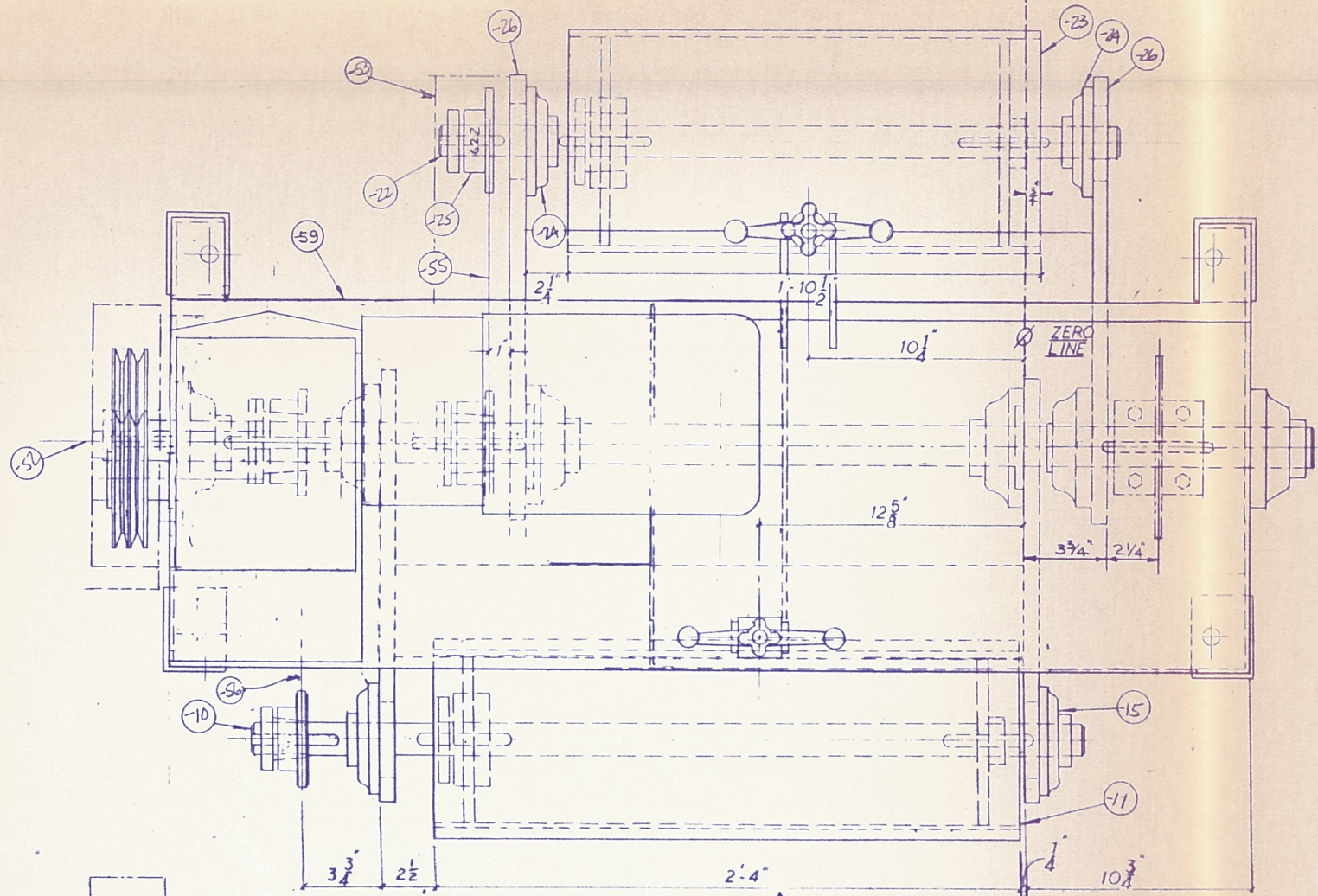
TITLE RIPSAW UTFEED PRESSROLL ASSY.  
R.H. Ø WITH RUBBER ROLLS

DATE February 25, 1986

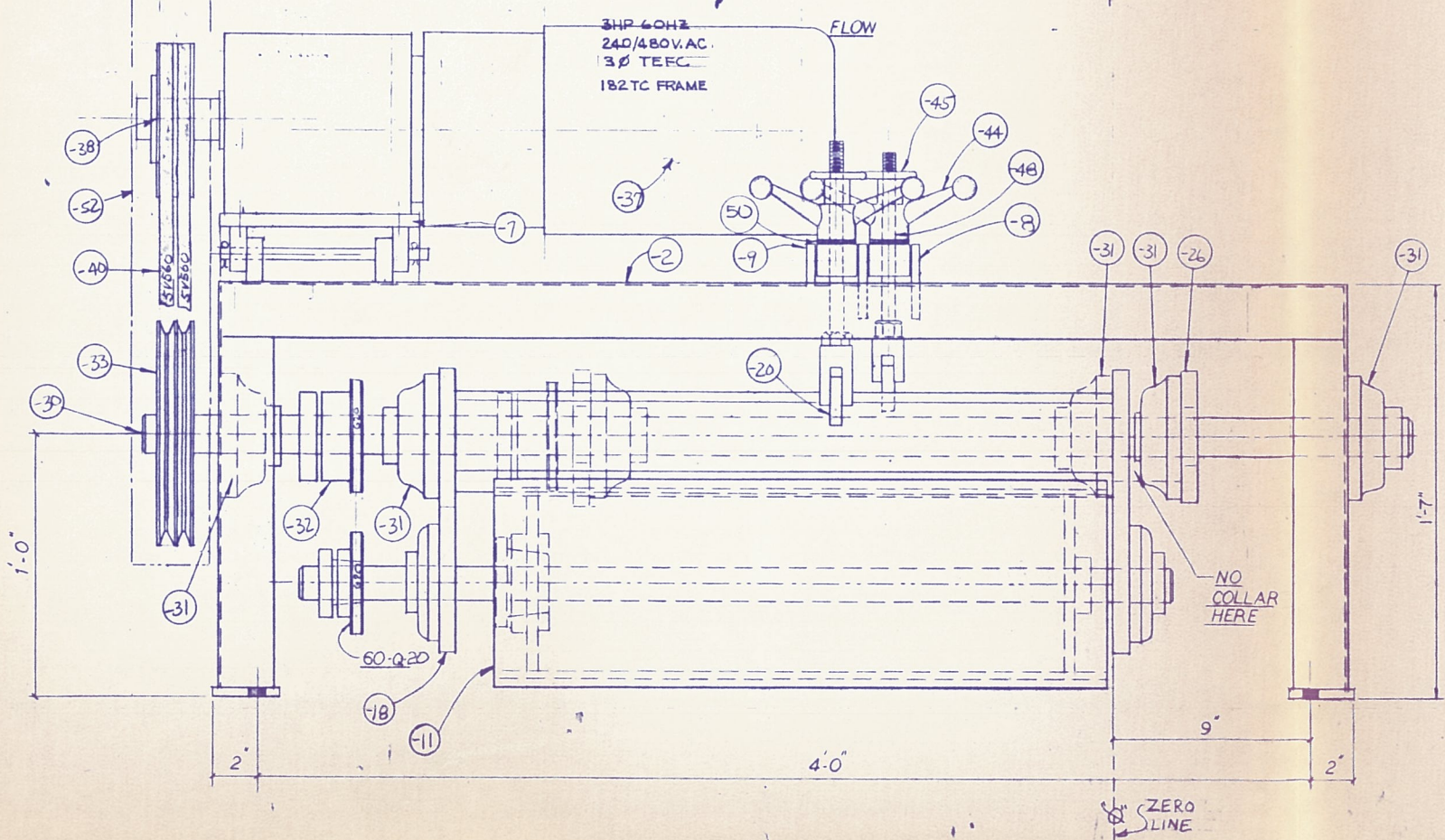
SHEET 2 OF 2 CODE 206

CHK DED. PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
P		36		Bushing, Q-1 x 1 15/16 (For #32 No Sub)		
P	*	37	1	Gearmotor, 3HP, 155 RPM, US 12 HERCULES INTEGRAL Gearmotor, 182T-12, TFGDM, TEFC Mod 7611, 240/440V AC, 60 HZ, 3PH		
P		38	1	Motor Sheave, 2 Groove "5V" 7.1" OK w/QD Hub		
P		39	1	QD Bushing #SK, 1 7/8" Bore w/KS		
P		40	2	Belts, #5V560 (Matched Set)		
		41				
A		42	2	18384-B Support Hanger Assembly		
S		43	2	10001-B Clevis		
S		44	2	9801-B Knob Handle		
S		45	2	9802-B Hand Knob		
S		46	2	8545-B Spacer Block		
S		47	4	8546-B Spacer Block Set Screw		
S		48	2	11005 Support Bolt, 5/8" Ø Thread, Rod 10" long		
S		49	2	Pin 5/8" Ø x 2½" long (Dorman, Clevis)		
		50	2	Washer Conveyor Belting: 1 3/4 Ø, ¼ thk, 3/4 Ø in center		
		51				
F		52	1	18385-B Drive Belt Guard		
S		53	2	8228-1-B Back Roll Chain Guard A = 3 ¼"		
S		54	2	9813-1-B Chain Guard Support A = 3 ½"		
P		55	1	Riveted Roller Chain RC-60, 61 Pitches long		
P		56	1	Riveted Roller Chain RC-60, 62 Pitches long		
		57				
		58				
F		59	1	17195-B Outfeed Side Shield		
F		60	3	17197-B Clip		
				* PRE ORDERED		

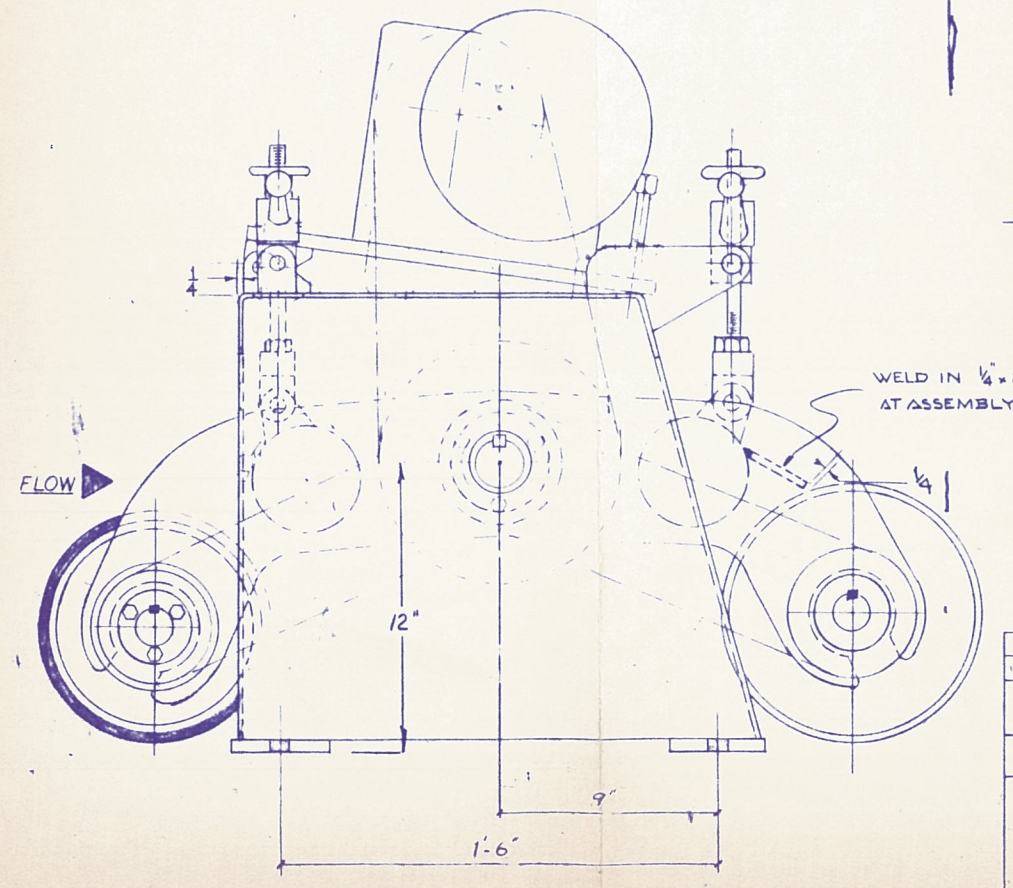
SYM.	NO.	DESCRIPTION	DWG. NO.



NOTE: THIS ASSEMBLY MAY BE USED IN PLACE OF ASSEMBLY #18924-D. COMPATIBLE INFEED ASSY. IS SHOWN ON DRWG. #24373-D



U.S. PATENT NO. 3,202,189



SYM.	DATE	REVISION

MANUFACTURING TOLERANCES, UNLESS OTHERWISE STATED  
INCHES UNDER 28"-0" 28"-0" & OVER  
+ .01 - .02 + .01 - .01

**PORTLAND IRON WORKS**  
PORTLAND, OREGON

RIPSAW OUTFEED  
PRESSROLL ASSY.  
R.H. ZERO-RUBBER RO  
R.H. 1936-D

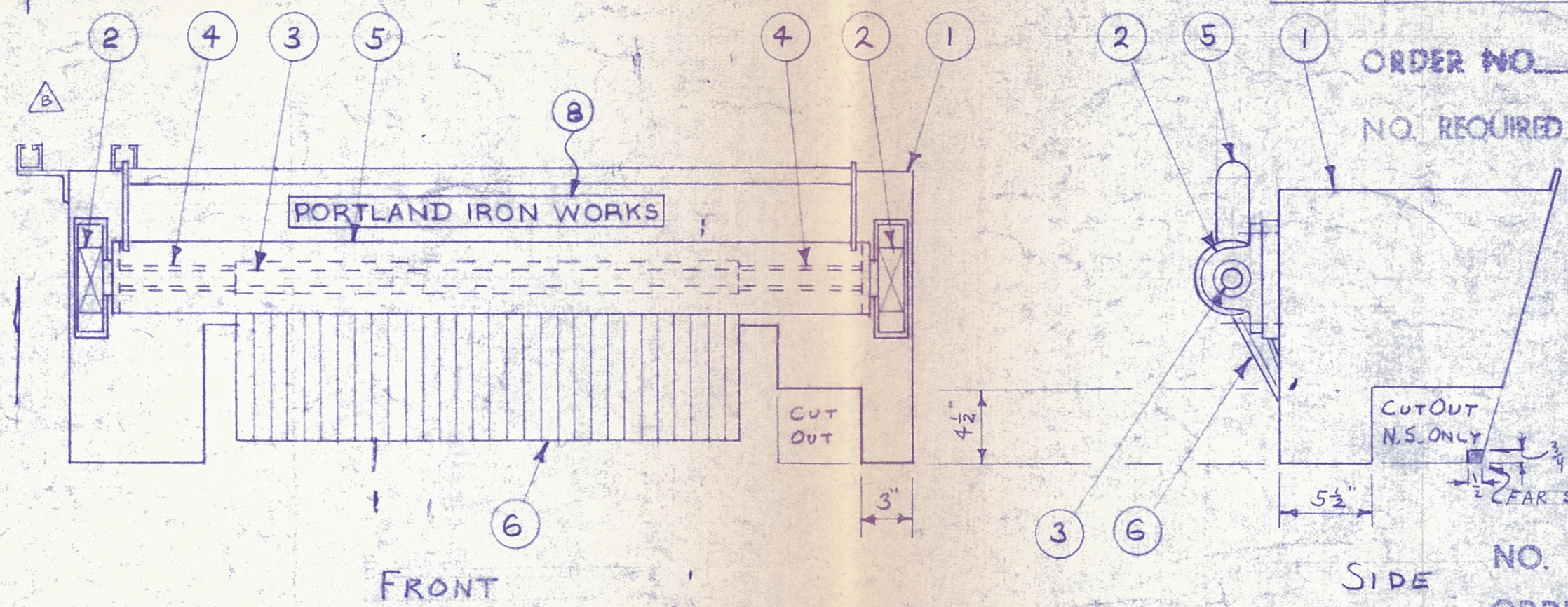
DATE 11-25-75 BY CHEP/206 DRAWING NUMBER  
SCALE 3" = 1'-0" CK 3 A24374-1





B

SYM.	NO. REQD.	DESCRIPTION	DWG. NO.
1	1	INFEED SAFETY SHROUD	8262-B
2	2	BEARING, FAGIR RAS 1 $\frac{3}{16}$ "	
3	1	SHAFT, 1 $\frac{3}{8}$ " DIA x 49 $\frac{1}{2}$ " T&P	
4	2	SPACER, 1 $\frac{1}{4}$ " X ST. PIPE 7 $\frac{1}{4}$ " LONG	
5	1	ANTI-KICKBACK HOUSING	8266-B
6	28	ANTI-KICKBACK FINGER	8236-B
8	1	NAME PLATE	9494-B



ORDER NO. \_\_\_\_\_

NO. REQUIRED \_\_\_\_\_

NO. REQUIRED \_\_\_\_\_

ORDER NO. \_\_\_\_\_

SYM.	DATE	REVISION	BY
B	24 APR 86	ADDED VIEW OF MOTOR MNT.	NORM
A	1-19-77	OMIT BRG. SPACER	12H.

**PORTLAND IRON WORKS**  
PORTLAND, OREGON

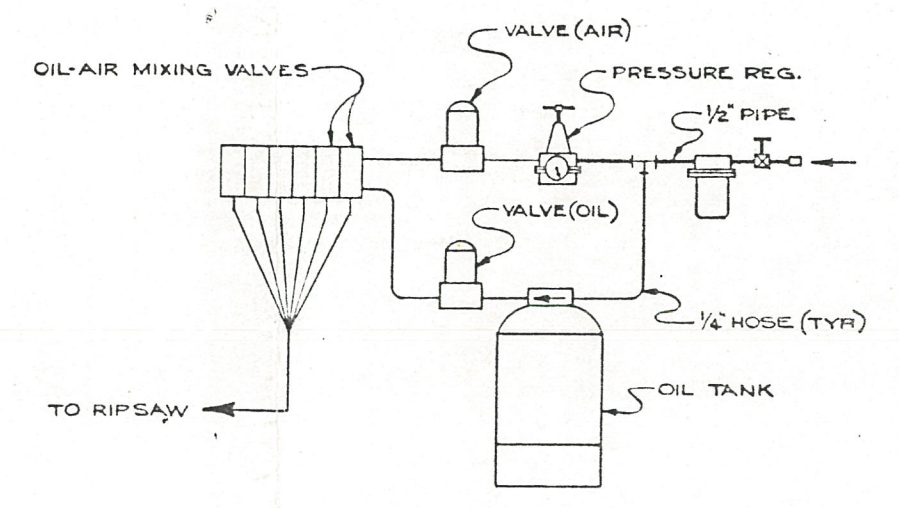
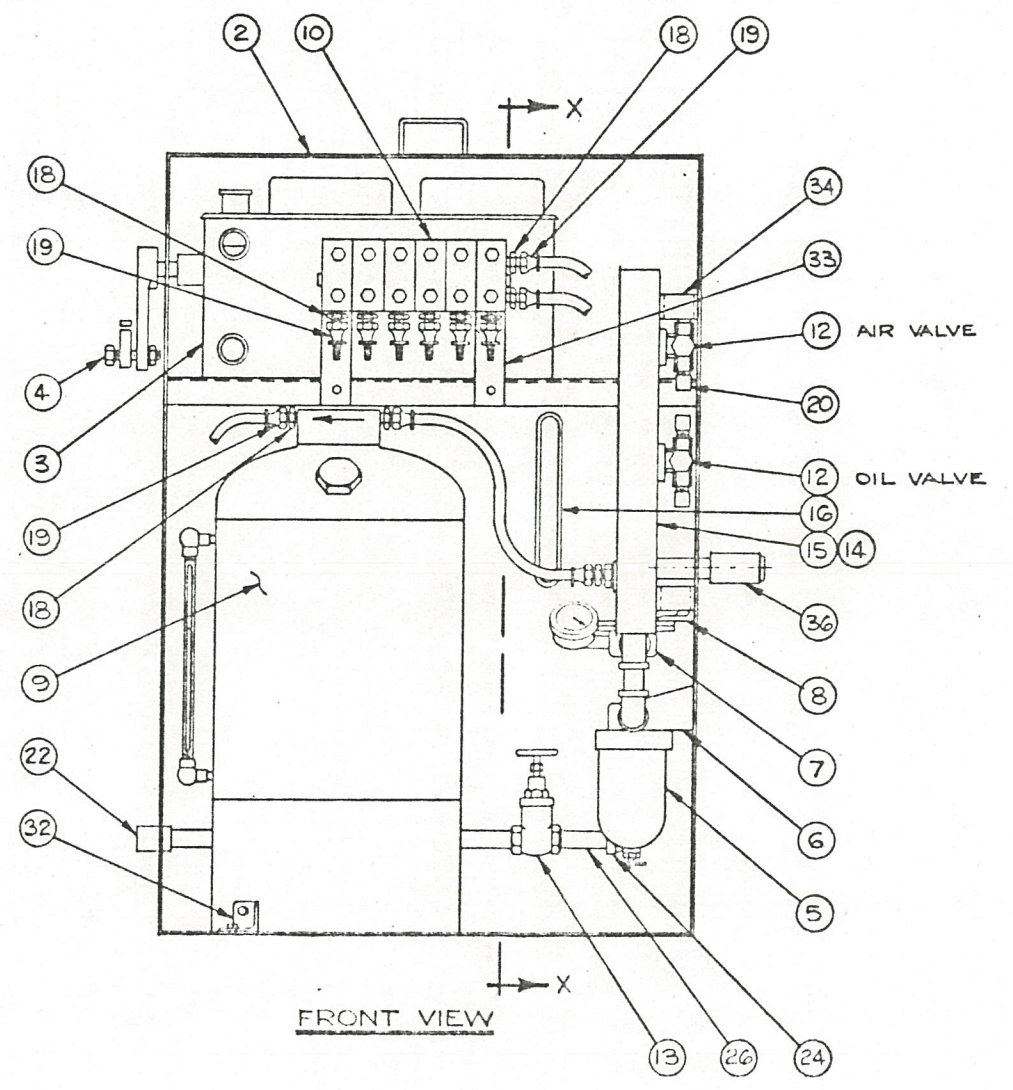
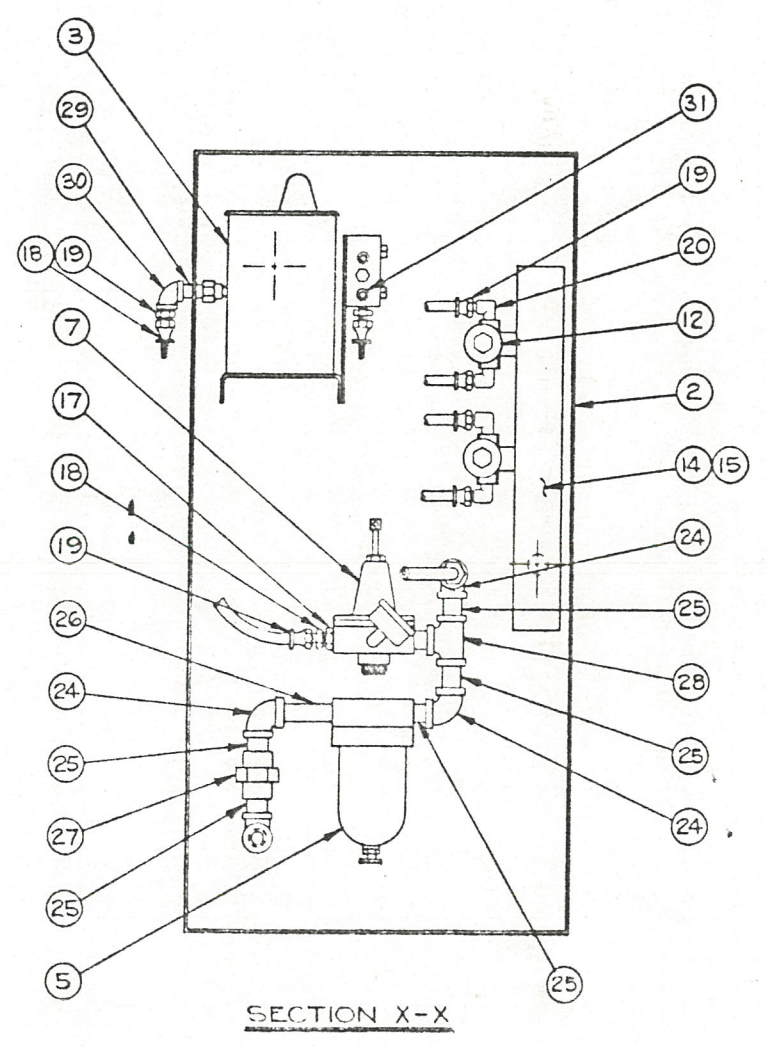
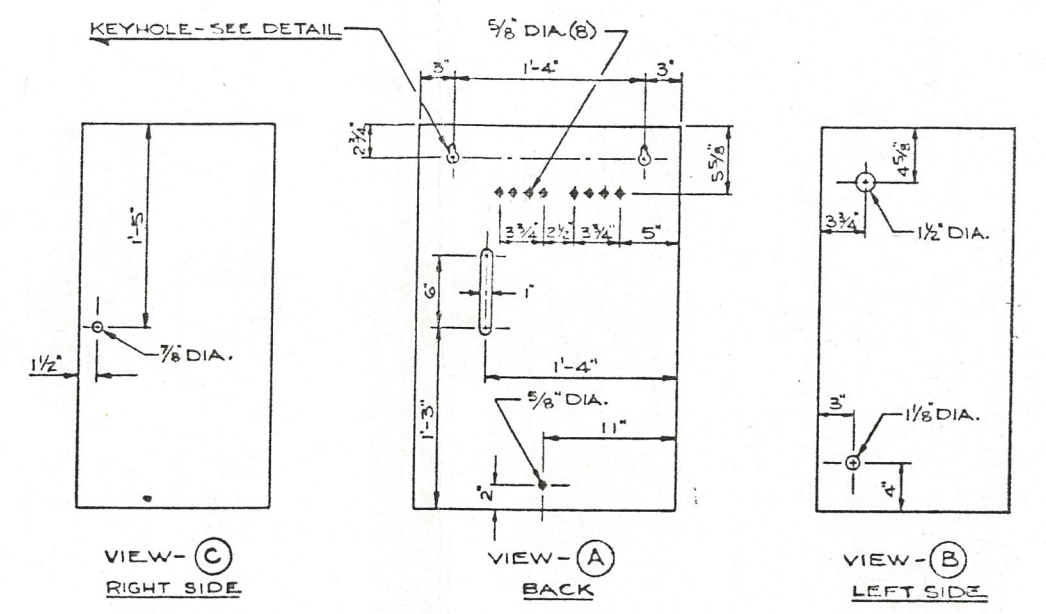
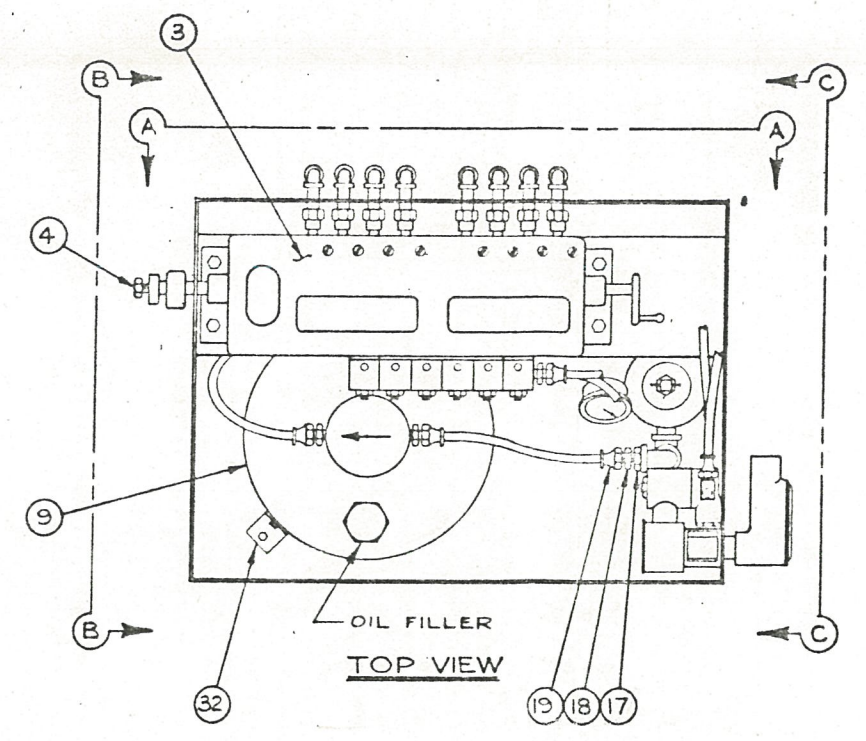
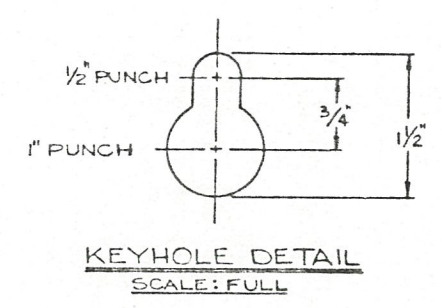
RIPSAW  
ANTI-KICKBACK DEVICE ASSEMBLY  
RT HAND 'O' MACH.

DATE	10-7-65	DR	AHK	DRAWING NUMBER	A-8261-B
SCALE	1/2"=1'-0"	CK			

SHOP ORDER			PORTLAND IRON WORKS				PARTS LIST A8922-D	
CUSTOMER			TITLE RIPSAW LUBRICATION CABINET ASSEMBLY - RH Zero				DATE July 26, 1967	
							SHEET 1 OF 2	CODE 206
STOCK	DED:	PULL	ITEM NO.	TOTAL QTY	PART NO.	DESCRIPTION	REV.	DATE
P			1	1	A8922-D	LUBRICATION CABINET ASSEMBLY		
S			2	1	8674-D	Cabinet		
9			3	1	<del>8674-D</del>	Lubricator, MADISON-KIPP Model 50, Figure 8A, LH Ratchet Drive, 4-Hole Drive Arm, 3-Hole End Bolting Bracket		
9			4	1		Drive Arm Bolt, MADISON-KIPP #C1251		
P			5	1		Filter, NORGREN # <del>12-002-017</del> F12-400-MATA		
			6	1		Bracket, NORGREN # <del>18-001-032</del> 5532-04		
P			7	1		Regulator, NORGREN # <del>11-002-067</del> R12401R26LA		
			8	1		Bracket, NORGREN # <del>18-001-003</del> 5514-06		
P			9	1		Reservoir, NORGREN #15-052-001, 5 Gal.		
P			10	6		Mixing Valve, NORGREN #15-003-001, less tubing, nozzle and fittings		
P			11	1		Manifold Kit, NORGREN #15-006-003		
P			12	2		Solenoid Valve, SKINNER #R2LB2200, 24V DC		
			13	1		Gate Valve, 1/2"		
			14	1		Service Duct, 2" x 2" x 15", NATIONAL #1700 w/Cover		
			15	2		Duct End Cap, NATIONAL #1780		
			16	1		Hole Gasket, 1'-3" Long		
			17	2		Bushing, Hex, LENZ #8-4HB-B		
			18	20		Male Adapter, LENZ #5105-1/4-4		
			19	24		Swivel Hose Fitting, LENZ #301-4-4		
			20	4		Male Elbow Adapter, LENZ #5405-1/4-4		
			21			Hose, 1/4", LENZ #4 YR		
			22	1		Coupling, 1/2" Steel		
			23	1		Pipe, 1/2" STD x 1'-3" Long		
			24	4		Elbow, 1/2" x 90°, 200 #		
			25	6		Nipple, 1/2" x 2" Long, Steel		
			26	2		Nipple, 1/2" x 3" Long, Steel		
			27	1		Union, 1/2", 200 # FS		
			28	1		Tee, 1/2", 200 #		
			29	8		Nipple, 1/4" x Close, Steel		
			30	8		Elbow, 1/4" x 90°, 200 #		
			31	2		Plug, 1/4" Pipe		
			32	2		Clip, 1 1/4" x 1 1/4" x 1/8" L x 1 1/4" Long (Drill at Assy)		



REV.	DESCRIPTION	DATE



D 20670 REVISED & REDRAWN 2/24

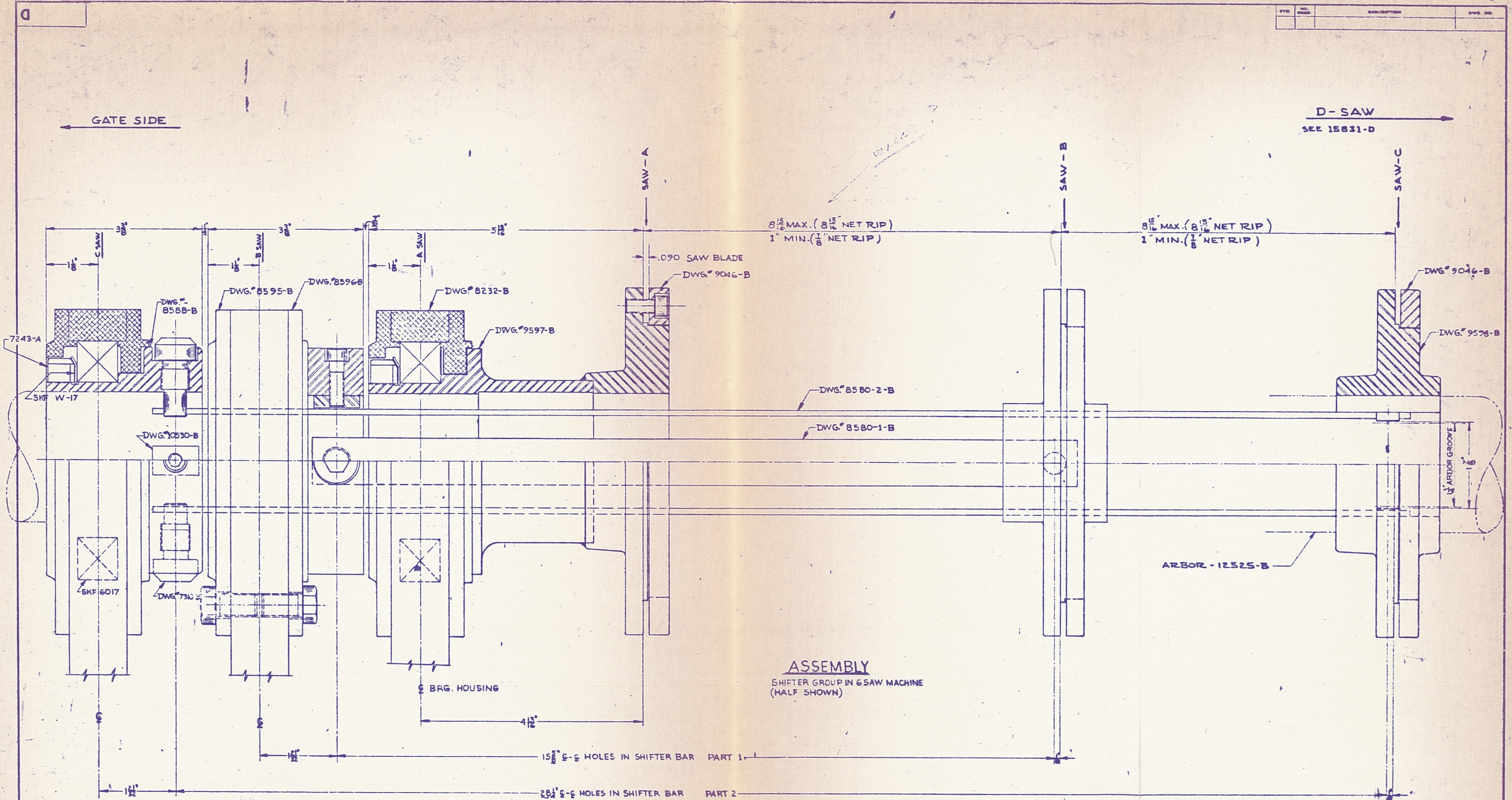
MANUFACTURED UNDER U.S. PATENT OFFICE PATENT NO. 2,121,818

**PORTLAND IRON WORKS**

RIPSAW  
LUBRICATION CABINET  
R.H. ZERO

17 A8922-D

REV.	NO.	DESCRIPTION	DWG. NO.



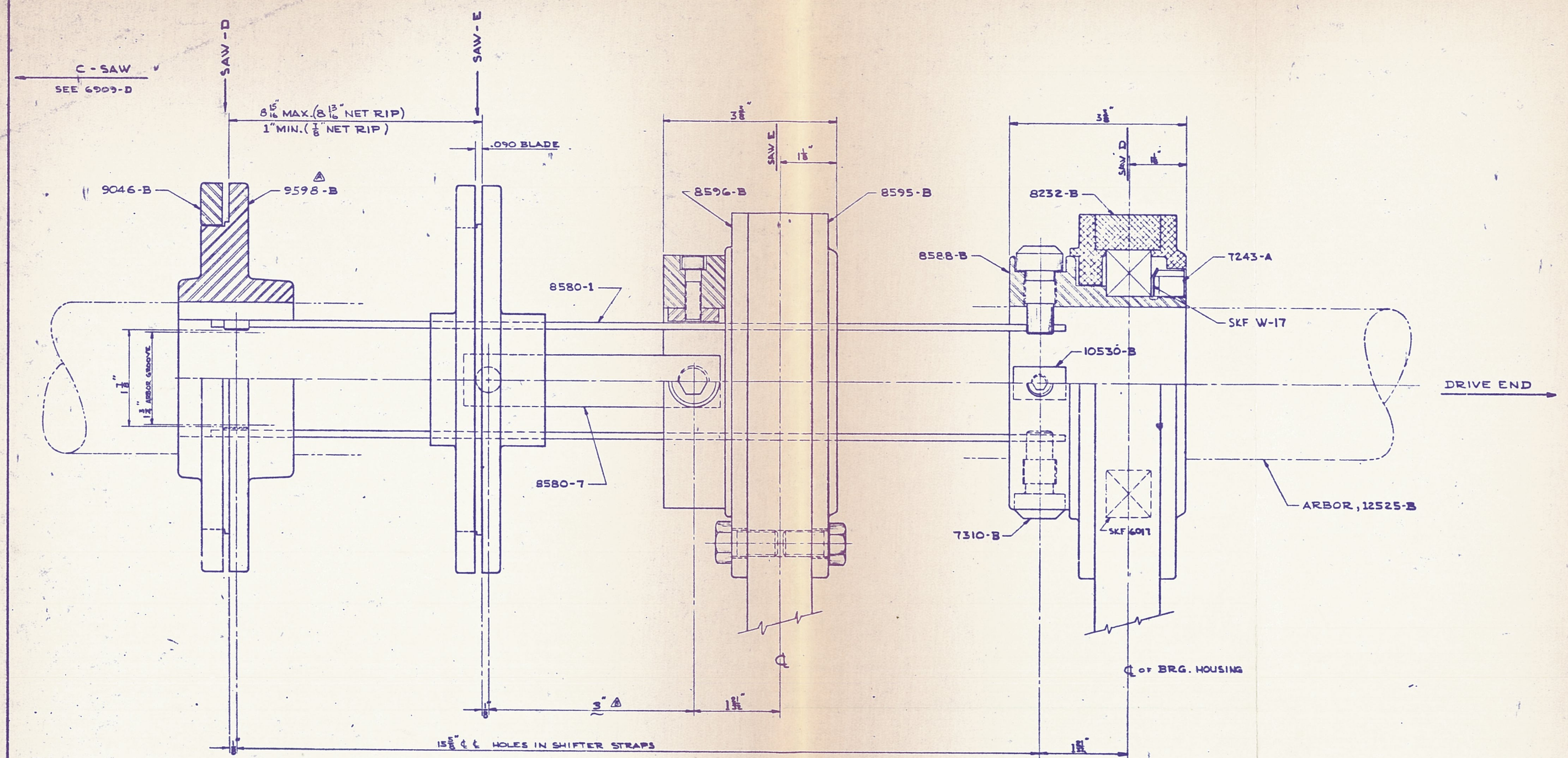
**ASSEMBLY**  
 SHIFTER GROUP IN 6 SAW MACHINE  
 (HALF SHOWN)

ORDER NO. \_\_\_\_\_

F	7-7-68	9598B WAS 9098B	608
E	3-29-68	REDRAWN SAME NO	AM
REV.	DATE	REVISION	BY
<b>PORTLAND IRON WORKS</b> PORTLAND, OREGON			
<b>Rip Saw</b>			
BRIDGE TREE BRG. SHIFTER- BAR & SAW COLLER ASSEMBLY			
DATE	5-29-68	SCALE	1/4" = 1" - 0"
REV.	4	AM. 206	A6909-D

REF DWG. A 15831-D

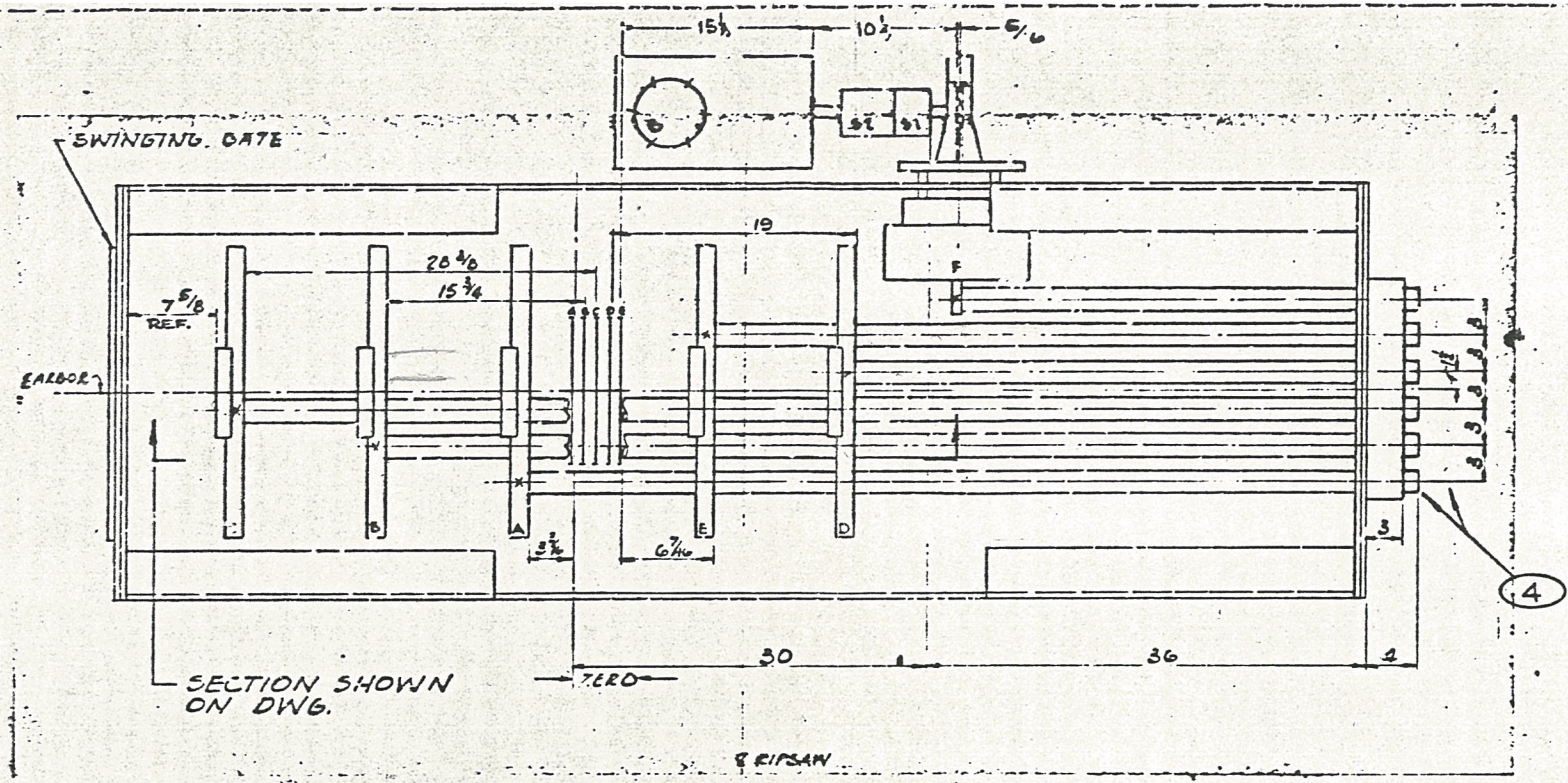
SYM	NO	DESCRIPTION	DWG NO



Ⓟ	10-3-71	3" WAL 9"	600
Ⓜ	7-5-72	9598 MM: 9044B	600
SYM	DATE	REVISION	BY
MANUFACTURING TOLERANCES UNLESS OTHERWISE STATED			
INCHES		UNDER .01"	BY .01" & OVER
		±.001	±.002
<b>PORTLAND IRON WORKS</b>			
PORTLAND, OREGON			
<b>RIPSAW</b>			
BRIDGE TREE BRG, SHIFTER			
BAR & SAW COLLAR ASSEMBLY			
REV	DATE	BY	APP'D
2-2B-73		RM 206	
12-1-0		4	<b>A15831-D</b>

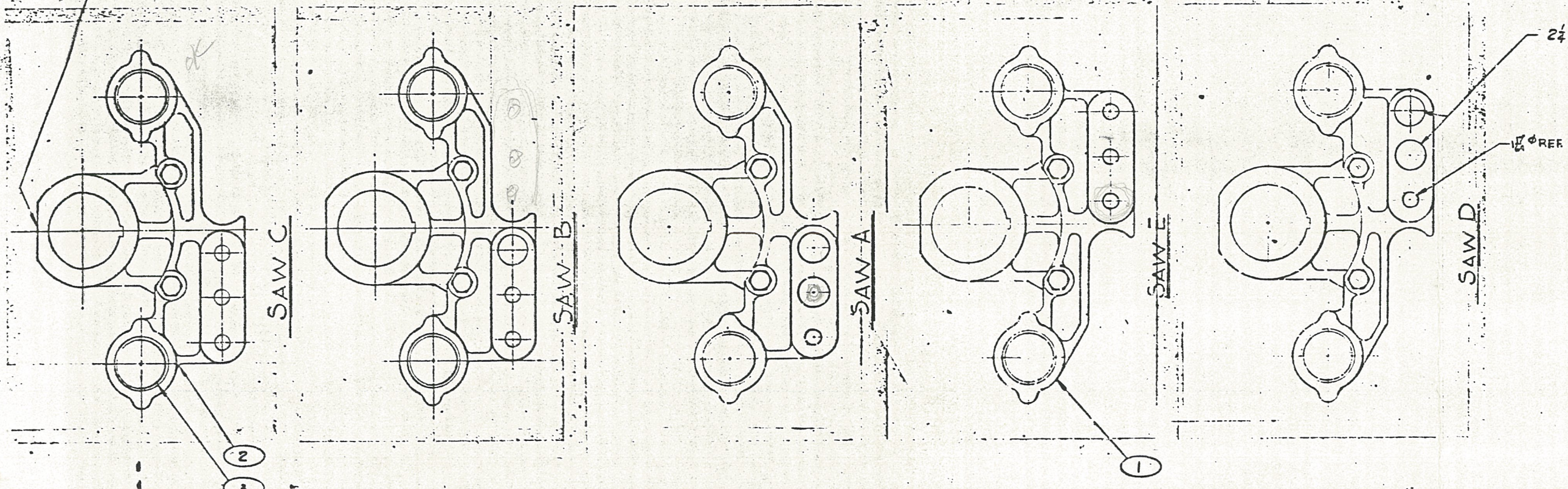
REF. DWG A 6909-D

QTY.	NO. REQD.	DESCRIPTION	QTY. REQD.
1	2	BRIDGE TREE ASS'Y	9873-B
2	3	BRIDGE TREE ASS'Y	9875-B
3	10	BUSHING	9874-B
4	1	SHIFTER ROD SET	8193-B



PLAN VIEW  
R.H. ZERO, 5 SAW

SEE NOTE #1



RIPSAW BRIDGETREE ARRANGEMENT

NOTE:  
1. STAMP TOP OF EACH BRIDGE TREE  
WITH THIS DWG. NO. & ITS SAW LETTER  
EXAMPLE:  
THIS DWG. NO. 8194-B  
SAW LETTER

C	2-28-73	A' SAW TO - E'	RH.
E	3-28-68	RH. HOLE WAS 1 1/2"	AM.
A	3-2-67	REDRAWN - WAS 16 SIZE	R
BY	DATE	DIVISION	BY
FORTLAND IRON WORKS PORTLAND, OREGON			
RIPSAW BRIDGETREE ASS'Y			
R.H. ZERO, 5 SAW			
BY	DATE	BY	DATE
None		RYAN	8-19-67
			AB194 D