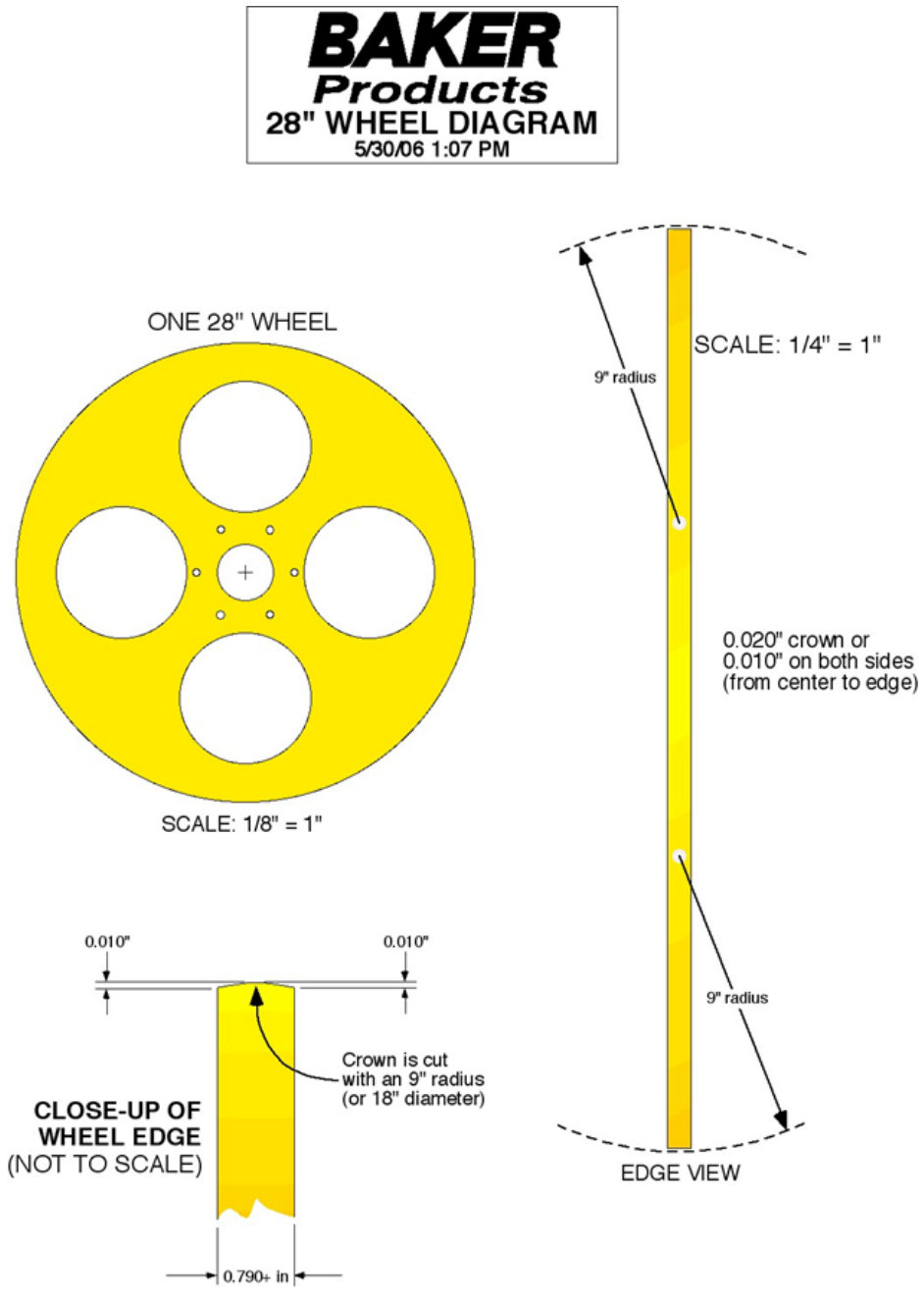
SETTING THE RESAW BLADE UP

About 90% of the calls we get about bad cuts or blade breaking is due to the crown on the wheels running flat. Depending on how often the customer uses the machine and not knowing how old the saw is, these wheels should be crowned at least once a year. Use a square on the edge of the wheel and front face to make sure you have about a .010” crown on the edge with the high point in the middle. That is first off the most important thing about making sure everything is correct. Customer can either send the wheels to us to have them crowned or if they have a local machine shop in their area, the diagram below should help them do it.



After the crowning has been confirmed. Put a new blade on the set of band wheels, and make sure the blade is cutting in the right direction. The teeth should be cutting towards the fence. If blade is rotating in the wrong direction flip the blade inside out. Tighten the blade to spec. If air bag is installed, run 60 PSI to it and tighten the T-handle until 1 of the 4 spacers are tight. If it is a spring assembly then tighten it down until 3 out of the 4 spacers are tight.

Once the wheels are crowned customer will need to work on the tracking for the blade. Move guides away from the blade before tracking the blade. Customer will want the blade to track where the gullet (between the teeth) is flush with the front face of the wheel. Make the first adjustments with the big vertical tracking bolt up above and behind the idler wheel. This bolt will track the blade on both the pull and idler wheels. Every time customer make an adjustment grab the bottom of the idler wheel and give it a good jerk to kind of reset everything. Once customer tracks it correctly on the pull wheel, tighten the jam nut and then move on to the brass tracking bolt under the motor behind the machine. This bolt will track the blade on just the idler wheel. Once all the adjustments are made and it is tracking properly then we move to setting the lead in the blade. A side note: The idler wheel should be able to move up and down, but should not move left and right. If idler wheel is moving from side to side, then something may be wrong with the idler arm in the tubing behind head.

The next task would be to set the lead in the blade. Baker “A”s and “AX”s you will adjust the saddle bolts under the conveyor. On other resaws (AB, ABX, ABXX, B, BX, C, CX, D and DX) customer should have 2 sets of turn buckles on either side of the machine. Front and rear turn buckles. The front tilts the blade left and right if customer is getting thick cut on one side of lumber and thin cut on the other side (We’ll go over this later). The rear turnbuckle will tilt the blade forwards and backwards to set the lead in the blade. What you do to one side, you must do to the other, otherwise you will twist the head. Use a 12” ruler and set it up on edge on the blade on a tooth that is pointed down so customer is measuring the flat surface of the blade, and they will want to adjust the lead to where the front of the ruler is higher in the front than in the back by about 1/32” to 1/64”. To get an accurate measurement place a flat piece of metal on the conveyor belt and measure off of it. The following video shows how to set the guides, but at the very beginning it shows a little bit about setting the lead to show you what I mean.

www.youtube.com/watch?v=VT6vEHUWgg4

Now on to setting the guides. Setting the guides is probably the most tedious part of the whole thing. Making sure that the guides are not too tight or too loose, or even twisting the blade. Start with bringing the bottom guide up to the blade and placing it flat against the bottom of the blade. You will know if it is set right if you tap the blade with your finger nail and hear a solid “thunk” sound. If you hear a “tink, tink, tink” then the blade is slapping against the guide and not set right. Once you set both bottom guides against the blade double check to

make sure you did not adjust the lead in the blade. Make sure the guides do not have any up pressure on the blade as this will cause unnecessary heat which in turn will cause premature wearing. Also make sure the guide wheel is not touching the back of the blade and the blade only touches the wheel when wood is actually being cut. Once the bottom guides are set drop the top guides down on the blade. Do not apply pressure downward and pinch the blade because this to will also cause the blade to heat up and cause unnecessary wear. Some people even use the thickness of a dollar bill between the top guide and the blade.

Once you make the first cut, Check both sides of the material to see if they are the same(thick & thin lumber). If not then you will need to adjust the front turn buckle. You will only have to adjust one side either up or down.

BLADE TRACKING CHEAT SHEET

Tighten the big bolt moves blade out

Loosen the big bolt moves blade in

Moves blade on pull & idler wheels

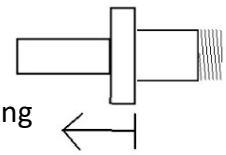
Tighten the brass bolt moves blade in

Loosen the brass bolt moves blade out

Moves blade on Idler wheel only

Pull wheel spindle is set 15/16” from the bearing to back of cowling

Idler wheel spindle is set 13/16” from the bearing to the back of cowling



If there is not enough adjustment on Idler wheel you can move the idler spindle in or out.

Set motor pulley @ 2-3/8” from the front edge of pulley, will end up @ 2-1/2”