

# NF-130



## **Petrol Band Saw Mill Operator's Manual HY30G**

**FOR YOUR SAFETY  
READ AND UNDERSTAND THE ENTIRE MANUAL  
BEFORE OPERATING THIS MACHINE**

# NF-130

## Warranty Registration Form

|                             |                    |
|-----------------------------|--------------------|
| Model:                      | NF-130             |
| Serial Number:              |                    |
| Type of Use:                | Business/ Domestic |
| Name:                       | sawmill            |
| Business Name:              | North-Forest       |
| Address:                    |                    |
| Email Address:              |                    |
| Phone Number:               |                    |
| Date of Purchase:           |                    |
| Place of Purchase:          |                    |
| Proof of Purchase enclosed: |                    |

For the warranty to be valid the Warranty Registration Form must be completed and returned to Lumag Distribution Limited within 14 days of the purchase together with a copy of the purchase invoice.

We will use your email to confirm that we have received the completed Warranty Registration Form and contact you about any errors or omissions on the form. We may occasionally use this email address to make you aware of news, technical advice and special offers. If you do not wish to receive such emails please tick this box

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Thank you very much for choosing the 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 be familiar with this product before you begin to use 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 the dealer where you buying it.

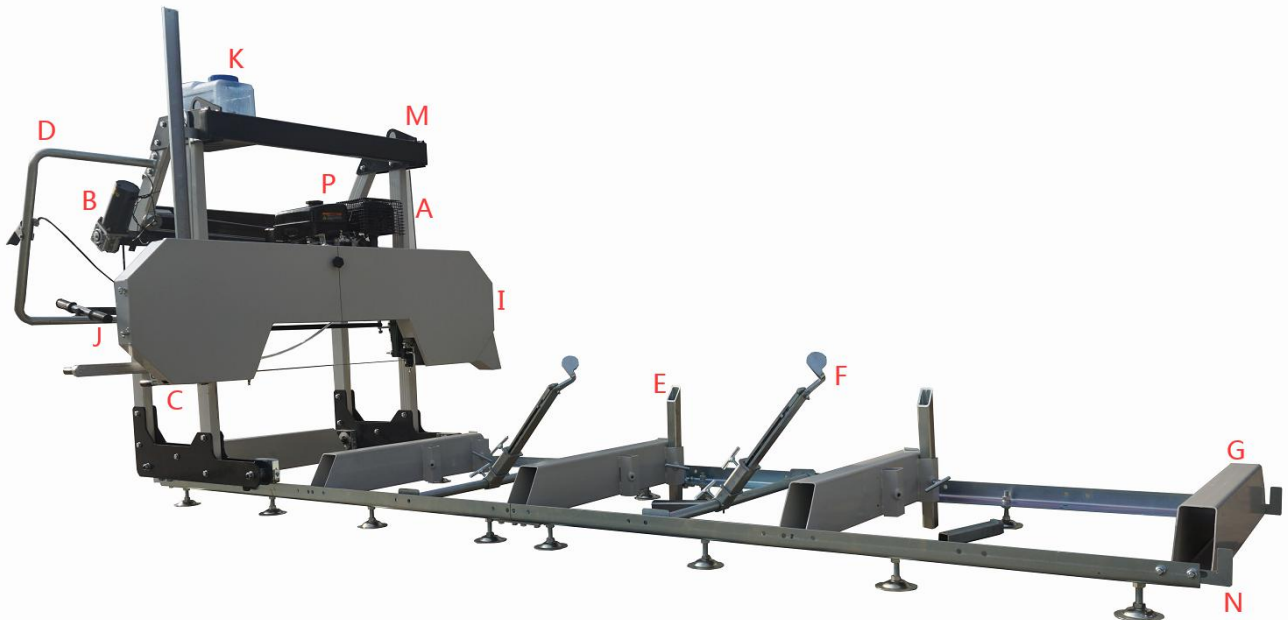
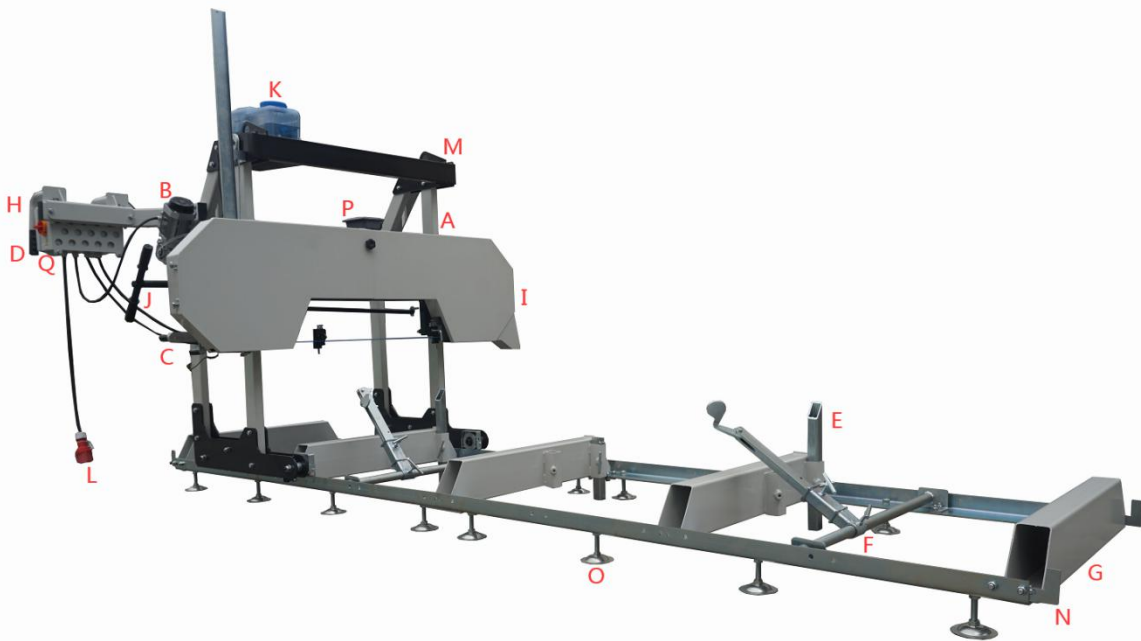
## **INTENDED USE**

This sawmill is designed for sawing logs w/out branches while the mill is firmly supported on the ground. There are holes on the feet. Please make sure to fix the feet with screws to solid ground.



For your own safety and the safety of others, do not use the band sawmill or handle band saw blades without first reading through and understanding the contents of this user manual in their entirety.

# DESCRIPTION OF THE BAND SAWMILL



- A. Saw carriage
- B. Crank for adjusting cut depth
- C. Adjustable blade guard
- D. Lever & throttle control
- E. Log support
- F. Log clamp (hidden behind)
- G. Log bed
- H. Safety switch
- I. Band wheel guard
- J. T-handle for saw blade tensioning
- K. Fluid reservoir for saw blade cooling
- L. Plug
- M. Lifting points on the saw carriage
- N. Rail end stop
- O. Support leg
- P. Motor/petrol engine
- Q. Electric box

# SAFETY INSTRUCTIONS

## Key to symbols



**Warning!** This symbol means that you have to take particular care. It is always accompanied by information on the specific risk.



**ATTENTION.** Pay extra attention when this symbol appears in the text. It will be followed by an admonition or a warning.



For your own safety and the safety of others, do not use the bandsaw mill without first reading through and understanding the contents of this user manual in their entirety.



**Warning!** Cutting tool: Careless use of the machine can result in potentially fatal injuries. Bandsaw blades are extremely sharp and dangerous.



Always wear protective gloves when working with the bandsaw mill. Risk of sustaining cuts when handling bandsaw blades. Bandsaw blades and motor/engine parts may be hot after sawing.



Always wear approved ear protection when working with the machine. Even brief exposure to high frequency noise can damage your hearing. Always use close-fitting protective eyewear when working with the machine or handling bandsaw blades. Under certain circumstances the use of a protective mask may also prove beneficial.



Always wear approved protective footwear with saw protection, steel toe-caps and nonslip soles when working with the machine.



Always wear full-length protective trousers when working with the machine. Never wear loose-fitting clothing, scarves, necklaces, etc., that may get trapped in the machine during the work. Tie up long hair before working with the bandsaw mill.



Always wear approved protective glasses when working with the machine



Always wear approved protective face mask when working with the machine

## Operator



**Warning!** Whenever the machine is used, approved personal protective equipment must always be used. Personal protective equipment does not eliminate the risk of injury, but it can reduce the effects of an injury in the event of any near-accident.



Persons under 18 must not use the bandsaw mill or handle bandsaw blades.



Never use the machine or handle bandsaw blades if you are tired, have consumed alcohol or are taking medicine that might affect your sight, judgment or control over your body.



**Warning!** Never operate a bandsaw mill with a combustion engine in an enclosed or poorly ventilated area. This can cause death by asphyxiation or carbon monoxide poisoning.



If fully adequate working lighting is not available, only use the bandsaw mill in full daylight.



Keep the workplace free of debris, pets, children, obstacles and anything else that may distract the operator.



Choose an erection site where the supporting ground is tightly compacted and level, with generous space for the bandsaw mill, log piles and sawn wood. The machine can be only used in level surface. Please fix the track feet on cement slabs or wooden blocks (15 cm x15 cm).



Always have a hand-held fire extinguisher of ABC type (min. 3 kg) readily accessible at the workplace.



Take precautions to reduce the hazard of inhalation of harmful dusts (e.g. wearing a dust mask)



Always have a complete first aid kit available at the workplace.



The machine must be installed with a residual current device.

Type text here



The machine can be only used outdoor.

### Using the bandsaw mill



**Warning!** Cutting tool: Always stand behind the saw carriage and keep both hands on the handle when operating the machine. Never stand in front of the saw carriage or bandsaw blade. Never pull the saw carriage through a cut.



**Warning** Never clean the saw blade or band wheel of a band saw using a hand-held brush or scraper whilst the saw blade is in motion



**Warning!** Use suitable carrier equipment for transporting tensioned wide saw blades.



**Warning!** Never use the machine unless all guards and other safety devices necessary for machining are in good working order. Check the function of the hold-to-run handle before every shift, if failed, must replace immediately.



**Warning!** Risk of entrapment and rotating parts: Even slight pressure on the saw head release mechanism can cause the saw head to drop in an uncontrolled manner and the crank to start rotating at speed, which may result in injury.



**Warning!** The clutch mechanism is very sensitive. Just slight pressure on the control when the engine is running can engage the clutch and cause the bandsaw blade to move.



**Warning!** Never make modifications to this machine that result in it no longer conforming to the original version, and do not use it if it appears to have been modified by others. Never use any accessories apart from those that are recommended in this user manual.



**Warning!** A broken bandsaw blade can eject bandsaw blade fragments at high speed via the chip ejector. Make sure that no one is at the side of the bandsaw mill when working. The risk of bandsaw blade breakage increases if it has not been properly fitted or maintained.



**Warning!** In case of broken band or belt if fitted, the wheels may keep running, and it is necessary to wait for the complete standstill of the machine before opening the guard(s);



**WARNING:** Do not cut lumber with foreign objects in it such as nails, any metal pieces, etc.



The machine only can be used in weather conditions: **temperature 5-40°C, and humidity 50%@40°C or 90%@20°C and altitude less than 1000m.**



Make sure the machine has been properly assembled and maintained in line with the enclosed assembly instructions as well as these instructions.



Never work alone. Always make sure there is another adult within hearing distance in case you need to call for help. Never stand between a log pile and the bandsaw mill. Always stand to the side of the log pile when handling the logs. Never stand where there is a risk of a log falling on you.



**Warning!** Adjust the adjustable saw blade guard as close to the workpiece as practicable.



Careful adjustment and regular maintenance of saw blade and band wheel cleaning equipment and of the lubricating system will ensure that the residues do not build up.

#### Hazard area:



The minimum safe distances around the bandsaw mill:



The safe distance on the bandsaw's left side is 15 m, as there is a risk of saw blade fragments being ejected via the chip ejector in the event of saw blade breakage. The extent of the hazard area on the other sides is 5 m.



**Warning!** Keep your hands, arms, legs and other parts of your body well away from the bandsaw blade, cables and other moving parts. Remember that when the saw carriage is moved, the position of the bandsaw blade and cable also changes.



**Warning!** Risk of impact from the saw carriage.



**Warning!** Risk of tripping on rail and crossbars. Never take a short cut over the rail.



**Warning!** Hang electric cables up out of the way so that they do not get damaged or become a trip hazard.



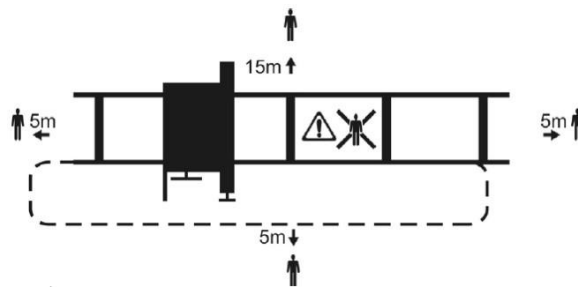
**Warning!** Never operate the combustion engine in enclosed areas. Ensure good ventilation. The exhaust gases contain harmful substances that are potentially fatal.



**Warning!** Risk of entrapment between sawmill and logs when loading.



Never climb onto the rail or the log bed crossbars.



### Before each occasion of use:

Check that:

- the operator is wearing the prescribed personal protective equipment
- maintenance as prescribed has been carried out
- the bandsaw blade is stationary
- the machine has been erected so that it is stable and the rail is supported along its entire length
- the saw carriage's anti-tip wheels and the rail's end stops are in place
- all components on the bandsaw mill are tight and serviceable
- all the safety equipment on the machine is in place and working
- the bandsaw blade is properly installed and runs freely in the right direction

### Before each cut:

Check that:

- no other persons or pets are within the hazard area of the machine
- the workplace is free of obstacles that might present a trip hazard or act as a distraction
- the bandsaw blade runs clear of the log supports and log clamps for the workpiece
- the rail is free of debris, dirt, etc.
- the workpiece is properly fixed in place
- the adjustable saw blade guard has been correctly set for the maximum width of the workpiece

### When in use:



**Warning!** Risk of burn injury. The engine and its silencer become very hot both during operation and for a time





after shutdown. This also applies when the engine is idling.

**Warning!** Risk of fire. Petrol and petrol vapours are highly flammable. Remember the fire, explosion and inhalation risks involved.



**Warning!** Fire risk. The engine must have been shut down and allowed to cool for 10 min before fuel is added.



Always shut down the combustion engine when you leave the operator station, even if just for a short time, to deal with sawn wood or perform maintenance.



When the machine is not in use, for example at the end of a shift, release the saw blade strain and place a notice on the machine to indicate this and to remind the next user to adjust the strain before starting up;



**Warning!** Short circuit. Perform regular checks to ensure that the battery cables are not damaged. Make sure that no metal parts come into contact with the battery terminals.

## Long-term storage

The band saw blade should be taken out of the machine, coiled, secured and stored in a safe, dry place that is not accessible to children or other persons even during short periods of non-use. Before next use, the bandsaw blade should be checked for damaged teeth and cracks;

**When stored for longer periods the following applies:**

- empty the fuel tank and coolant reservoir, - remove the bandsaw blade from the machine, - close the fuel valve, - lock the saw carriage in position. Store the bandsaw mill in a place that is not accessible to children or other persons, preferably in a locked room.



Only store the machine in the place with a condition temperature at 25 to +55°C



Only transport the machine in weather conditions at 25 to +55°C

## Maintenance



**Warning!** Before performing servicing or maintenance on the machine: - remove the spark plug on the engine or unplug the electric cable of the motor.



**Warning!** Risk of burn injury. The engine and its silencer become very hot both during operation and after shutdown.

Allow the engine and silencer to cool before performing servicing or maintenance on the machine.



**Warning!** Never try to dismount the fixed guard! The fixed guard can be only dismounted by the manufacturer for maintenance (replace saw band or belt etc.) or cleaning.

## Moving the bandsaw mill



**Warning!** Risk of entrapment. Keep persons and animals outside the 5 m hazard area around the machine when

lifting and moving machine parts. Secure the load during transport.



The saw carriage and rail component must not be lifted or transported while assembled, but must be transported separately.

**Lifting the saw carriage:** Lift the saw carriage using the lifting points right at the top.

Weight, see Technical data.

**Lifting the rail component:** Use pallet forks or a fork lift to lift the rail from below. Place a protective layer of wood material on the forks before lifting. Make sure that the rail component is well balanced and secure the load to the pallet fork before transporting it. Weight, see Technical data.

# 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 (assembled under two rails) is used at the seam joint to join the two sections together (shown in right images). 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.



Assemble carriage stops at the ends of the tracks (4 stops total) and tighten.

## **#3 – LOG DOG & SUPPORTS**

Assemble log dog pieces as shown below and use waterproof grease on threaded handle and “T” handle. Attach assembly to the track using the provided nuts & bolts and tighten.



Attach log dog assembly to track as shown above with 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.

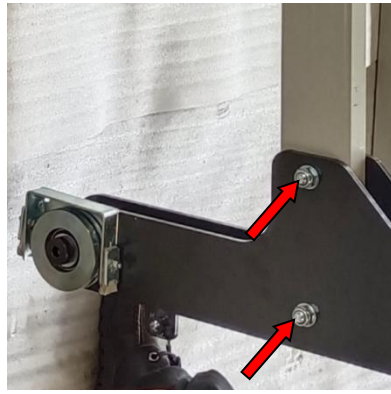


Insert log supports into track cross supports and secure with “T” handles. The “T” handle threads should be coated with waterproof grease. The sawmill includes two sets of log supports – two short set and two long set. The longer set is ideal for larger logs and the shorter set is ideal for small logs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

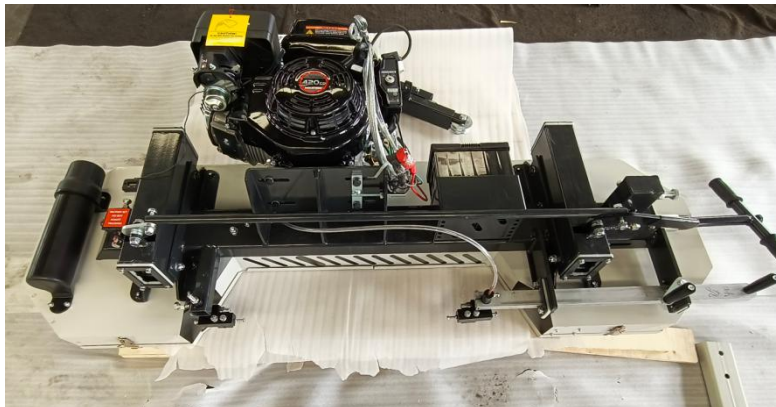
#### **#4 – CARRIAGE ASSEMBLY**



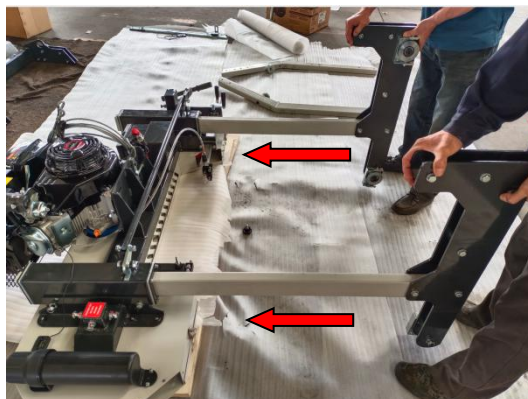
Lay the above carriage pieces out.



Use two bolts to assemble the vertical column (shown on the left) to the wheel assembly. Repeat same step for the square vertical post assembly (shown on right).

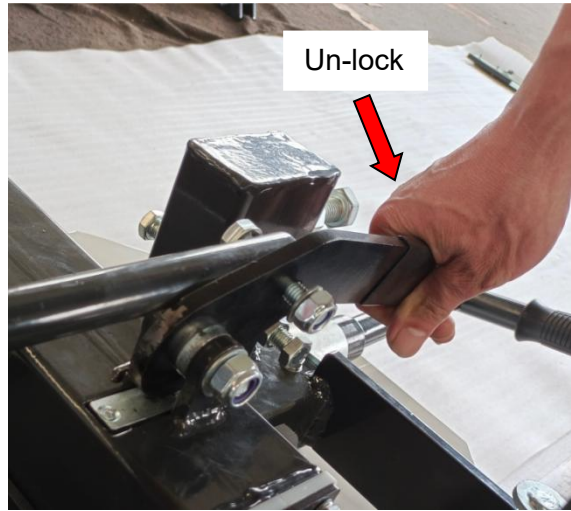
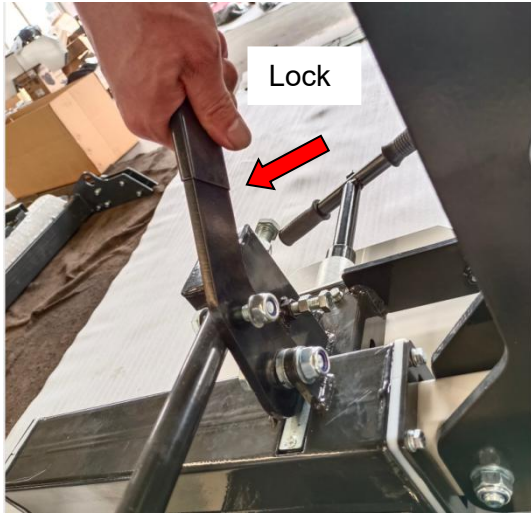


Place a moving blanket on the shipping pallet that the sawmill crate was strapped to. The blanket will prevent the blade guard covers from becoming scratched. Using a **minimum of two people** or a mechanical advantage system, remove the head assembly from the sawmill crate and place face down on the blanket. The head assembly is very heavy, proper technique must be used to avoid injury or damage.



Insert vertical post assemblies into corresponding locations in head assembly as shown above.

S



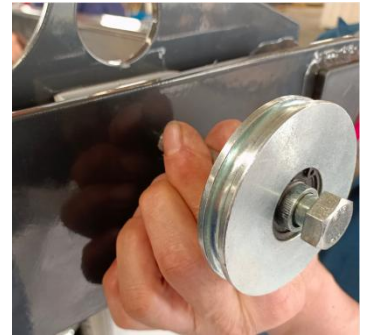
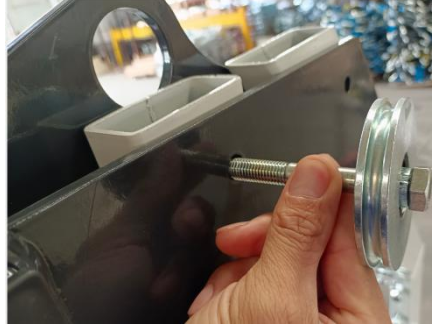
Lock the cam handle on the square column to prevent the head from moving when standing up in the subsequent steps. Make sure that when the cam handle is activated, the clamp is securely locked on the circular and square vertical posts



With one person on each post, stand the head assembly up on the wheels as shown above. Again, using a **minimum of two people**, set the saw head assembly on the track system ensuring the carriage wheel grooves rest on the “L” rails. The square vertical post should be on the same side as the log supports.



Use two bolts to assemble the diagonal column (as shown in the left picture) to the wheel assembly. Repeat the same steps for the other oblique column assembly (as shown on the right).



As shown in the figure above, use bolts to fix the upper beam and column



Place the measuring ruler bracket as shown in the figure above, and insert the bolts and nuts. It is important to tighten the nuts alternately (from top to bottom) to ensure uniform compression. Use a 10 mm wrench to tighten the nut.



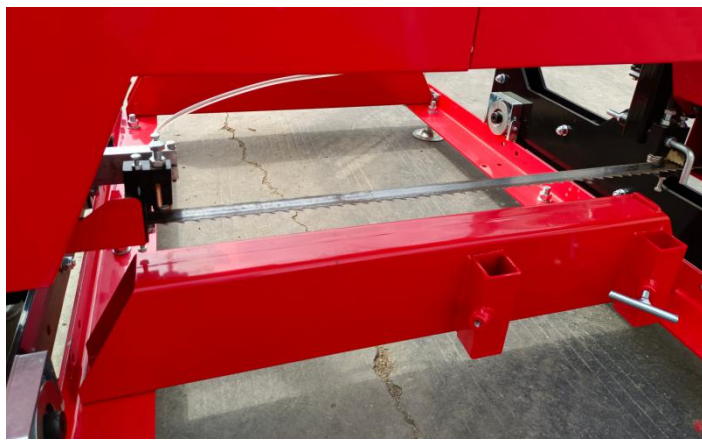
Slide the scale indicator over the square rod and tighten.



Install the cables to the pulleys as shown above.



Attach the cable bolts to the brackets on the sawmill head as shown above. It is ideal to lower the sawmill head all the way down to the deck. Once this is done, adjust the two bolts so that the sawmill head is level to the track cross supports. See next page for further details on this set up.



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 need to adjust the cable bolts (shown on page 13) up or down to raise or lower the head on one side until the measurement is consistent on both sides.



Gasoline engine handle

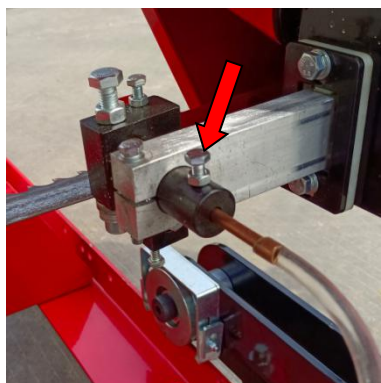


Motor handle

Connect the handle of the gasoline engine and the handle of the motor to the vertical column of the bracket. And lock it with bolts. Please refer to the picture above.



Connect the lock-pin cable to the guiding-wheel-locking-handle. To make sure the engine can run at the highest speed when the throttle handle is fully pushed down. To make sure the guiding wheel can running smoothly when the guiding wheel locking handle is pushed down.

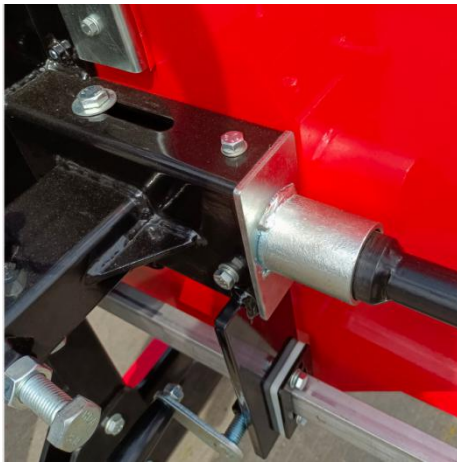


Put the lube tank to the bracket. Insert the lube tank line through the hole in the bottom of the saw head as shown above. Use a 10mm wrench to fix the bolts. Do not over tighten or crush the copper end.





Use the tap at the water tank to adjust the liquid flow by turning the screw left and right.



Add waterproof grease to the threads of the blade tension “T” handle and to the washer face that it meets before use. Use a 24mm socket on a torque wrench to tighten the “T” handle to 25 N.M torque to achieve proper blade tension. See above right image.

***\*Note – It is very important to take the tension off of the blade by turning the “T” handle in the clockwise direction when the sawmill is not in use and hangs the below notice to the “T” handle. 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.\****

**NOTICE!**  
**CHECK THE TENSION OF THE BAND SAW BLADE BEFORE CUTTING!**

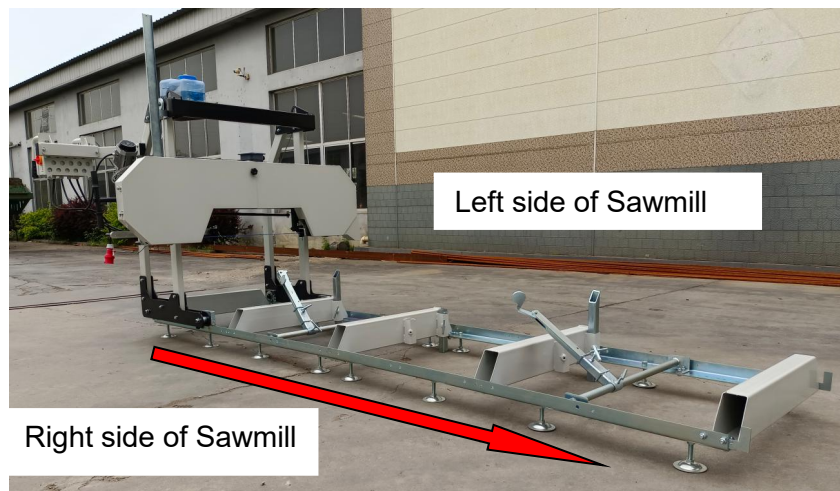


Push the saw head up and down the track system to ensure that the width of the track allows for the saw head to move freely. If it binds, the “L” rails will need to be set further or closer together to achieve a consistent width along the entire track system. Once the desired width is achieved, all nuts and bolts can be tightened to the log bunks as shown in above right image using a 16mm 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.

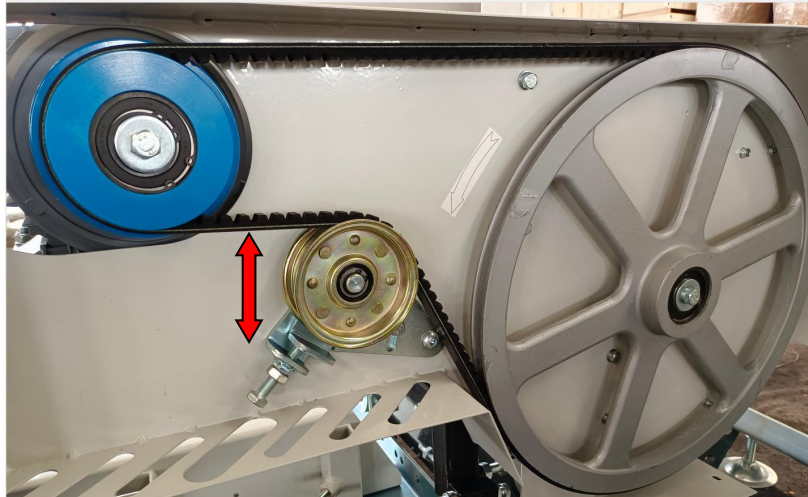


Always cut in the direction shown above. The log clamp should always be on the right side of the log and the log supports should always be on the left. Failure to cut in this direction can cause the log to come loose and possibly even cause damage or injury.

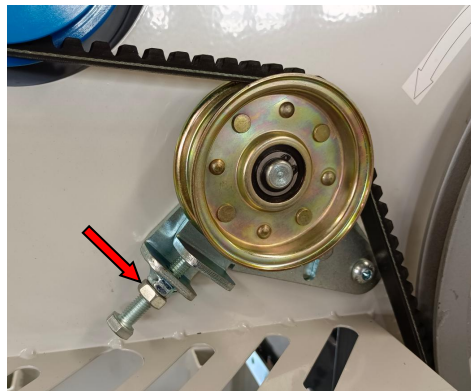
***\*Now that your sawmill is assembled, please run through the “SAWMILL SET-UP PROCEDURES” in the following section. Failure to do so may result in poor sawing performance, damage or injury. See next page. \****

# SAWMILL SET-UP PROCEDURES

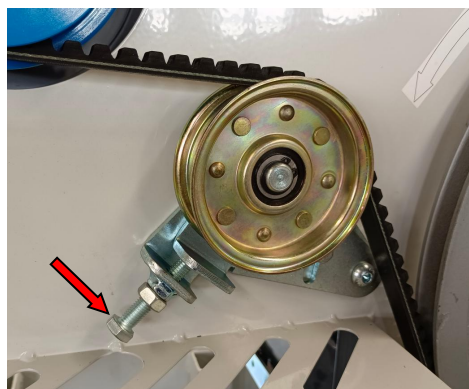
## #1 – BELT TENSION



To check the belt tension, with a tension meter, deflect the belt up and down with 60N force. There should be no more than 5-6mm of deflection in both directions. If the belt deflects more than this, it will need to be tightened as described below.



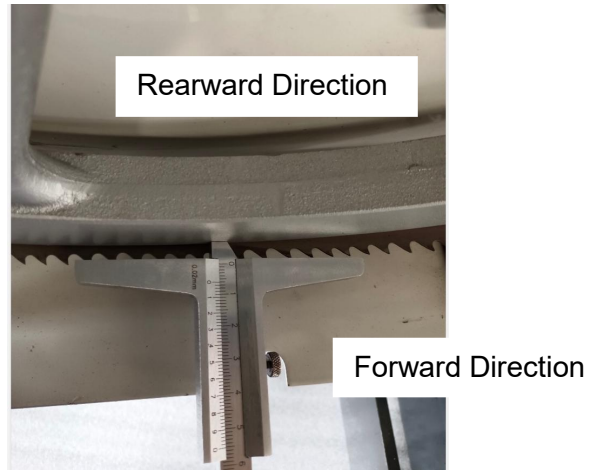
To tighten the drive belt, first use a 17mm wrench to loosen the nut



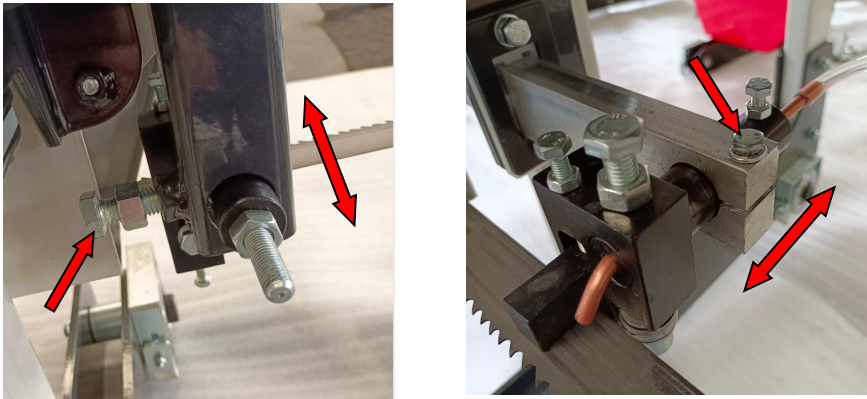
Now, turn the 12mm bolt clockwise. This puts more tension on the belt. While checking whether the belt is deflected correctly, perform this step step by step. Over-tightening can cause the mounting plate to twist, which can cause belt alignment problems and premature wear. After setting the required belt tension, tighten the nut

Alternatively, if the drive belt is too tight, you can turn the 12mm bolt counterclockwise.

## #2 – BLADE TRACKING



The blade should run with the same tooth to bandwheel face distance on both sides. 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 . 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 clockwise direction one full turn from full tension position.



Loosen the tracking alignment locking nut.



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.



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



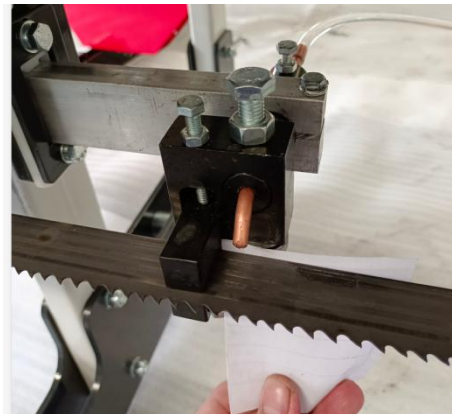
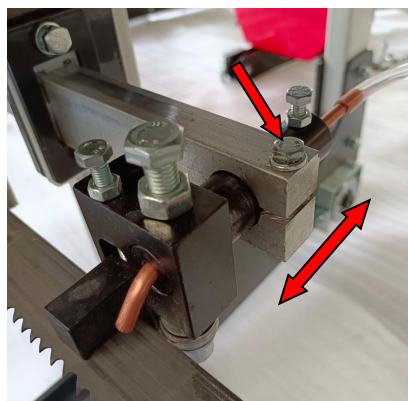
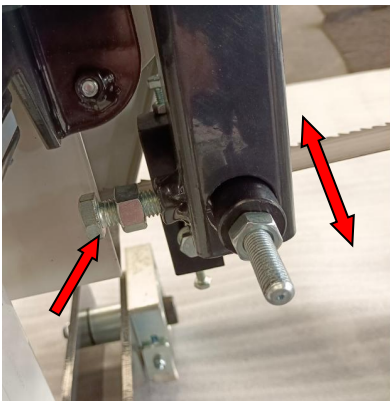
Use a 24mm socket on a torque wrench to tighten the "T" handle to 25 N.M torque. See above image.

### **#3 – BLADE GUIDE ADJUSTMENT**

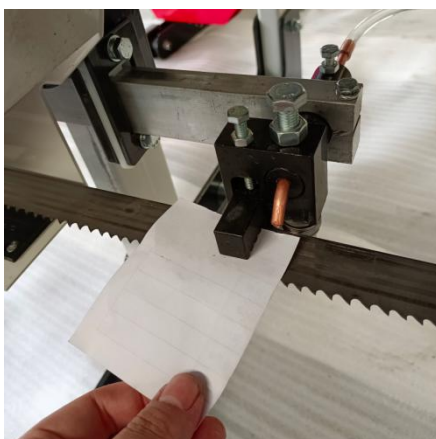
Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. It is also advised to confirm that the blade is tracking properly before performing the below. Blade tracking is covered in the previous page.



Use a 10 mm wrench to loosen the blade guides on the left and right sides. They should be able to slide up and down freely



Loosen the bolts of the blade guide assembly by loosening. 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.



Use a piece of business card paper (0.2-0.3mm) between the blade and the blade guide block, and then tighten the bolts

***\*Now that your sawmill is ready for cutting, please refer the following instructions-“Run your saw”- in the following section to enjoy your log-cutting at home.***

## LOAD AND LOCK THE LOG TO THE BED

With the help of a cant hook, load the suitable log to the bed of the sawmill.

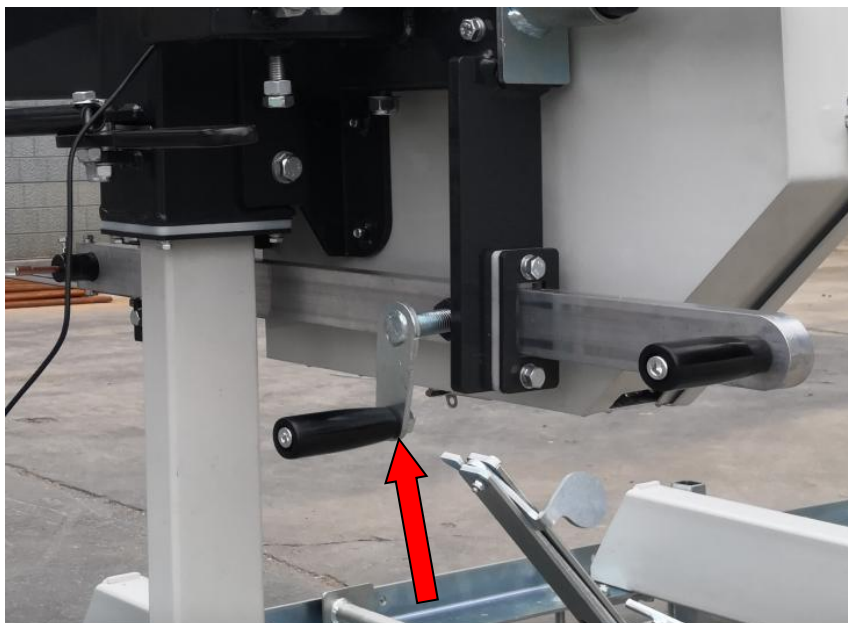


Push the log/cant to the Supports and make sure there is no space left between the log/cant and the Supports. (For supports use, Refer to page 11.)



Lock the log/cant with the log dog. (Refer to page 11.)

# BLADE SLIDABLE GUARD ADJUSTMENT

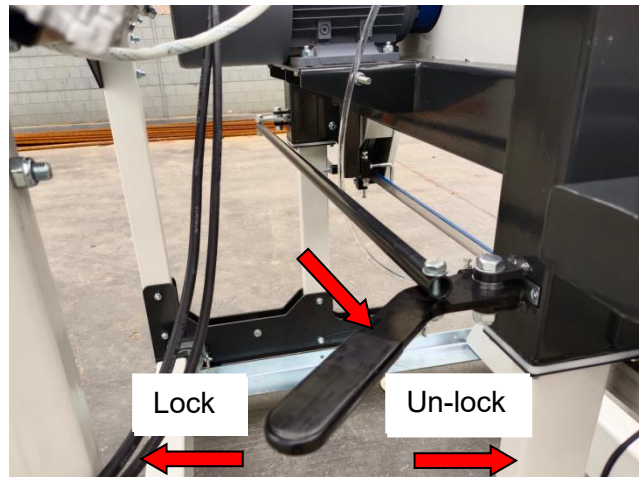


Loose two T bolts on the tube showed above in the red circle, and then slid the blade guard left/right to adjust the blade length for cutting.

Put the "Head-stopper" to the correct position as the above picture show.



# CUTTING HEIGHT ADJUSTMENT



Loosen the handle of the eccentric wheel.



Flip the switch to adjust the height of the sawmill's cutting head to reach the proper height.

You can fix the height of the board with the ruler beside of the crank.

***“After adjusting the cutting height, be sure to lock the Cam lock handles before start engine.”***

## How to release the blocked band saw blade

#1, Stop the **motor**/engine and then unplug **the plug** or remove the spark plug on the petrol engine.

#2, Release the log dog.

#3, Insert a wood wedge under the cutting board  
to make more space for the blade.

#4, Move the cant/log to the opposite  
direction of the blade slowly until the saw  
blade released.



***\*\*\*Do not forget to lock the log/cant again before cutting.***

# RUN YOUR SAWMILL

**Model # HY30G**, start the engine (refer to the engine manual), then push the throttle handle and the guiding-wheel locking handle down completely, and then pushes the cutting head to the log/cant slowly.

**Model # HY30E,**

1. Connect the electric cable.

**electric supply tolerances: 400V±5%, 50±1%Hz;**

The circuit breaker (10A) with RCD module (30mA) shall be installed for supplying electric power to this machine, in order to protect people against electrical shock due to indirect shock.

2. Turn on the twist switch



3. Press the motor start button. (During cutting, DO NOT release the handle, once you release it, the motor will stop.)



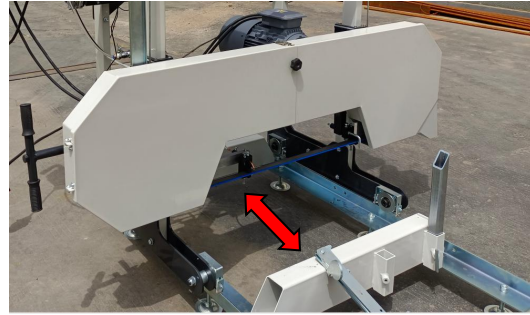
3. Push the bottom switch "ON" to start the motor

4. Hold the water switch handle and the motor start button. Then push the cutting head slowly to the log.

# SAWMILL MAINTENANCE

## #1 – CHANGING THE BLADE

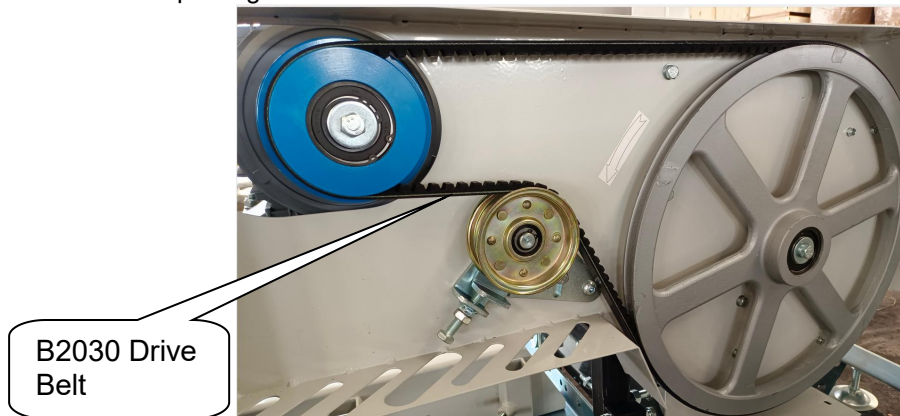
Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. Gloves and safety glasses must be worn when changing the blade.



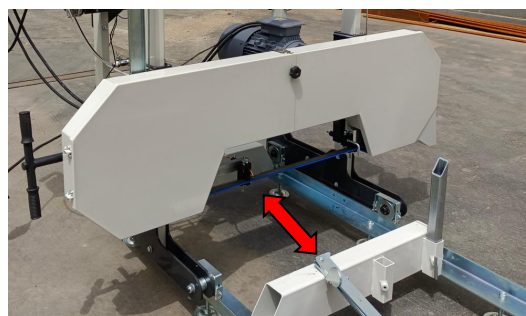
Remove the tension in the blade by turning the “T” handle in the clockwise direction and then open the blade guard cover. The blade should now be loose and free to pull straight out the front. The new blade can now be installed, guards closed and proper blade tension set.

## #2 – REPLACING BELTS

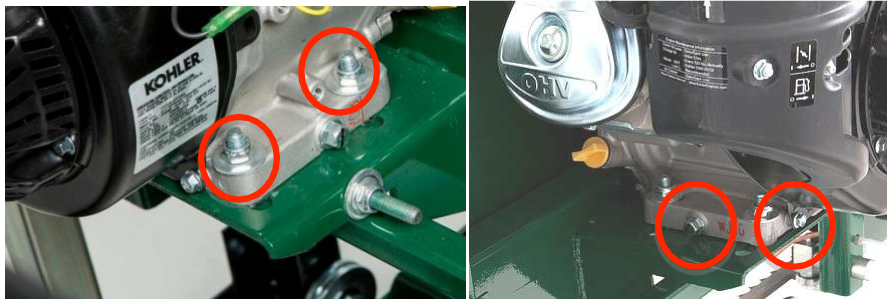
Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. Gloves and safety glasses must be worn when replacing the belts.



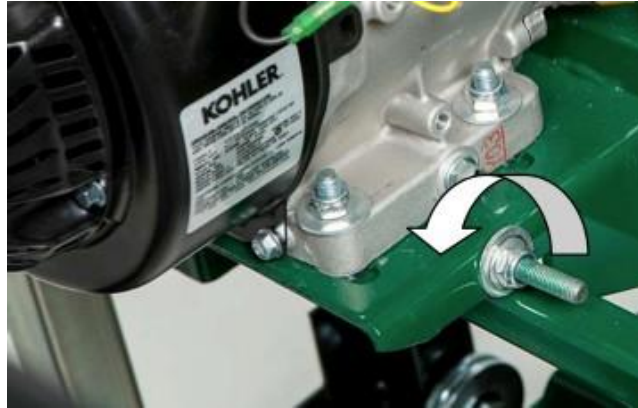
It is recommended to to use a B2030 cogged belt for the drive side .



Remove the tension in the blade by turning the “T” handle in the 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.

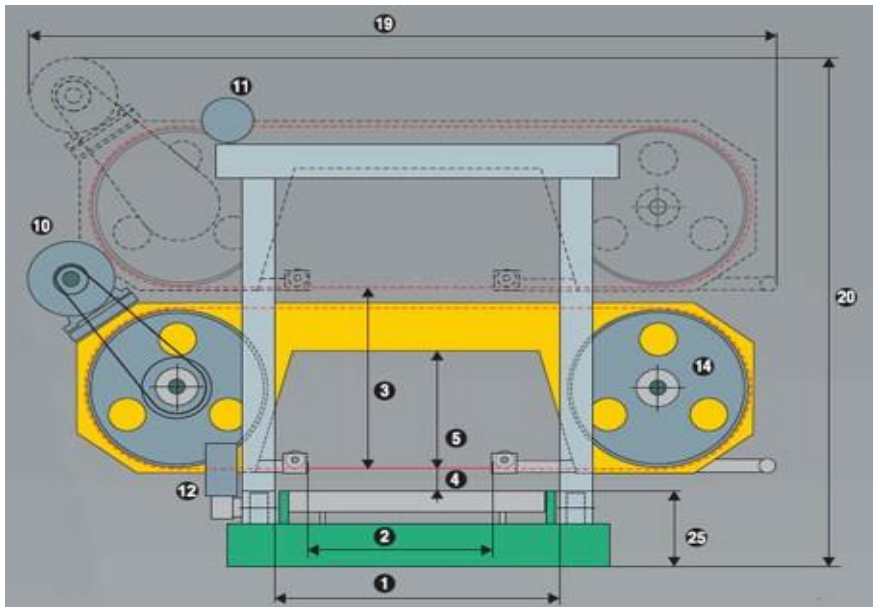
The follower belt can now be changed by simply pulling it off and installing the new one. The blade can now be re-installed, guards closed and proper blade tension set.

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

| <b>Problem/Issue</b>                            | <b>Possible Causes</b>  | <b>Resolution Options</b>   |
|---|---|---|
| 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 32.</li> <li>2. Gap between guide blocks and blade are incorrect. P 31.</li> <li>3. Adjust blade tracking. Refer to p. 27</li> <li>4. Install new blade. P. 33. Always use blade lubricant.</li> <li>5. Install new blade. Refer to page33</li> <li>6. Slow feed rate down and push head slower.</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 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 32.</li> <li>2. Gap between guide blocks and blade are incorrect. P. 31</li> <li>3. Adjust blade tracking. Refer to page 27.</li> <li>4. Install new belts. Refer to P.33.</li> <li>5. Install new blade. Refer to P.33.</li> <li>6. Slow feed rate down and push head slower.</li> </ol>  |
| Blades are breaking.                            | <ol style="list-style-type: none"> <li>1. Too many blade sharpening.</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 33.</li> <li>2. Binding between guide blocks when blade is too loose. Tighten blade. Refer to page 32.</li> <li>3. Gap between guide blocks and blade are incorrect.P.31.</li> <li>4. Adjust blade tracking. Refer to P.27</li> <li>5. Slow feed rate down and push head slower</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 32.</li> <li>2. Belts are worn or too loose. Replace. Refer to P.33.</li> <li>3. Slow feed rate down and push head slower</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 33.</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.</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> |

**Technical Data****HY30E****HY30G**

|                            |              |              |
|----------------------------|--------------|--------------|
| 1. Max. Log diameter       | 760 mm       | 760 mm       |
| 2. Max. Opening            | 760mm        | 760mm        |
| 3. Max. Elevation of blade | 620mm        | 620mm        |
| 4. Min. height from beam   | 50 mm        | 50 mm        |
| 5. Max. Depth of cut       | 180mm        | 180mm        |
| 6.Track Length             | 3960mm       | 3960mm       |
| 7. Track Width             | 940mm        | 940mm        |
| 8. Motor/engine            | 7.5kW,S1     | 420cc        |
| 9. Vertical adjusting      | Manual       | Manual       |
| 10. Horizontal adjusting   | Manual       | Manual       |
| 11. Max. Feed speed        | Manual       | Manual       |
| 12. Bandwheel diameter     | 474mm        | 474mm        |
| 13. Bandwheel width        | 24mm         | 24mm         |
| 14. Sawblade (mm)          | 4045x32x1    | 4045x32x1    |
| 15. Product Weight         | 433Kg        | 423Kg        |
| 16.Shipping Weight         | 488Kg        | 478Kg        |
| 17. Packing                | 2260x730x885 | 2260x730x885 |
| 18. Overall length         | 4090mm       | 4090mm       |
| 19. Overall width          | 2050mm       | 2050mm       |
| 20. Overall height         | 2530mm       | 2530mm       |



## **Noise declaration**

PSB26G:  $L_{WA} = 114$  dB(A),  $L_{PA} = 96$  dB(A);

PSB26E:  $L_{WA} = 99$  dB(A),  $L_{PA} = 80$  dB(A);

Associated uncertainty  $K = 4$  dB

Measurement made in accordance with EN ISO 3746:2010.

The operating conditions is described in 5.4.2 and Annex B of EN 1807-2.

The figures quoted are emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influences the actual level of exposure of the workforce includes the characteristics of the work room and the other sources of noise etc. i.e. the number of machines and other adjacent processes. The permissible exposure level can also vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.