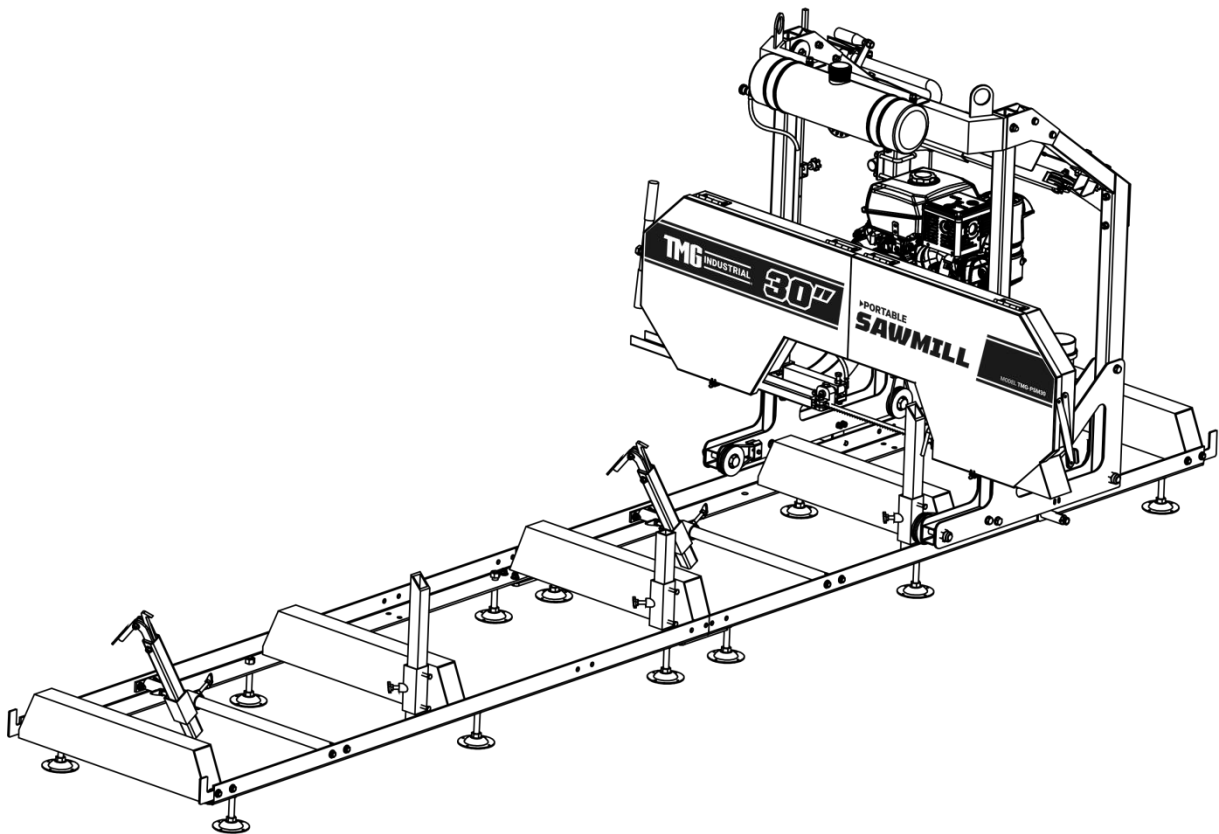


MODEL TMG-PSM30

30" CUTTING CAPACITY PORTABLE SAWMILL

KOHLER COMMAND PRO SERIES ENGINE



⚠ WARNING



- Please read and understand the product manual completely before assembly
- Check against the parts list to make sure all parts are received
- Wear proper safety goggles or other protective gears while in assembly
- Do not return the product to dealer. They are not equipped to handle your requests.

Missing parts or questions on assembly?

Please call: 1-877-761-2819 or email: cs@tmgindustrial.com

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Thank you very much for choosing the **TMG-PSM30** 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 TMG Industrial-A division of Transcan Motorsports Inc.


INTENDED USE


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


TECHNICAL SPECIFICATIONS

Item	Description
Engine	14 HP Kohler
Maximum Log Diameter	30" (762mm)
Maximum Board Width	28" (730mm)
Blade Size	1-1/4 x 158" (32 x 4013mm)

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 and solid surfaces.

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 a 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.
- **Avoid "kick-back"** by knowing what conditions can create it.
- **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 band saw 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 GT26 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.

START UP PROCEDURE - 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. Ensure guide blocks are tight and track is level
4. Fill the lubrication tank with clean water and *washing up detergent*.
5. Start and operate the engine according to the provided engine manual.
6. Depress the throttle to bring the blade up to *full* speed.
7. Throttle should be *fully depressed* when the saw is *under load*.
8. Cut branches off the lumber to be processed.
9. WARNING: to avoid death or serious injury. Do not cut lumber with foreign objects in it such as nails, any metal pieces, etc.
10. Place the lumber to be cut on the supports.
11. WARNING: The operator and any assistants must stay clear of the front and back of the blade whenever the engine is on.
12. Move the saw head slowly along the track and against the lumber to make the cut.
13. Trim off the rounded sides of the log.
14. When the log is squared-off, boards or posts can be cut to custom specifications.
15. 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.

MAINTENANCE

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

1. **Band wheel 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 band-wheels.
6. **Drive Belt** – Periodically check the tension of the drive belt. It should deflect by no more than 1/2".
7. **Saw-Head Locking Cam Handles** – Grease assembly every 30 days or as required.
8. **Saw-Head Vertical Posts** – Spray posts before use with a silicone spray lubricant such as 3- in-1 or Jig-A-Loo.
9. **Band-Wheel Guards** – Routinely remove any build-up of sawdust that may collect inside the band-Wheel guards.
10. **Lubrication Tank** – Only fill with a water/washing up detergent mixture(one to two caps) or in winter months, use windshield washer fluid. Do not leave lubricant in tank if temperatures fall below 0 degrees Celsius.
11. **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.
12. **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.
13. **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.

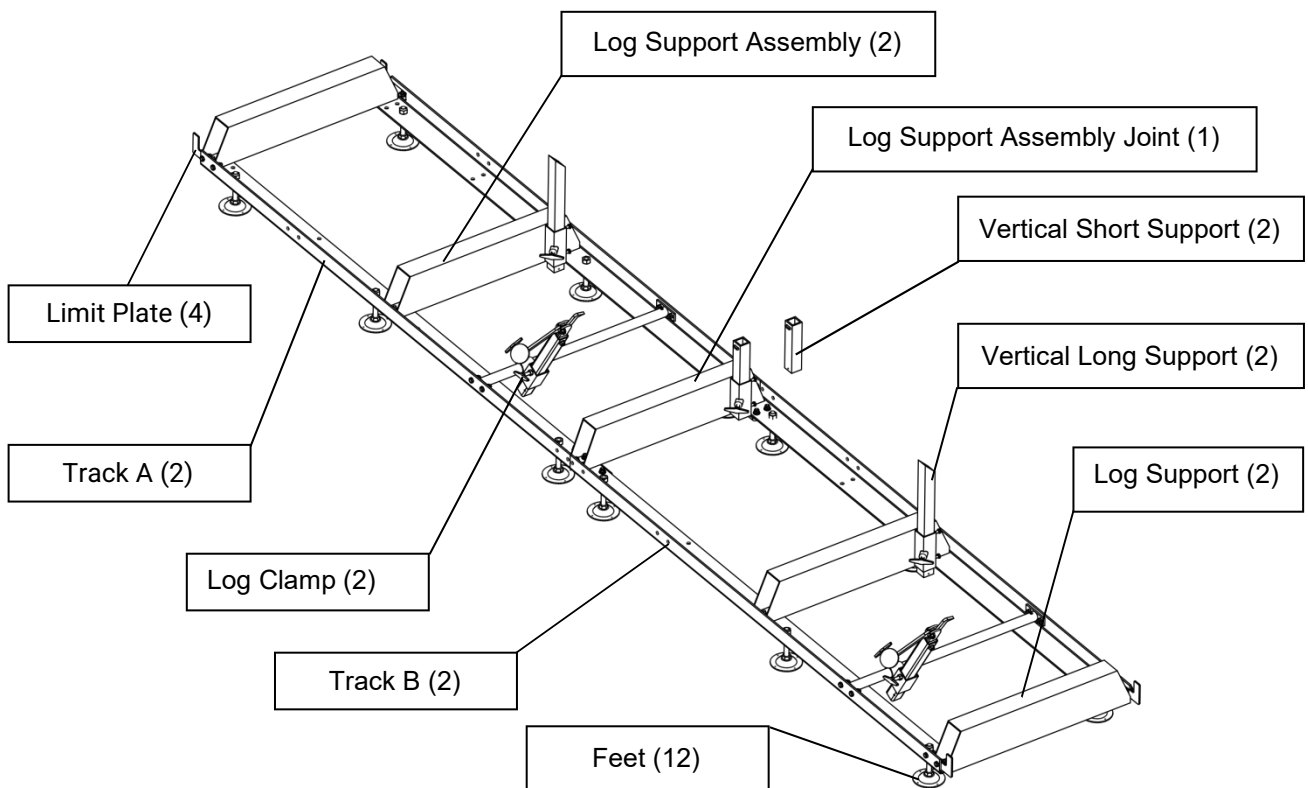
SAWMILL ASSEMBLY

#1 – INSPECTION

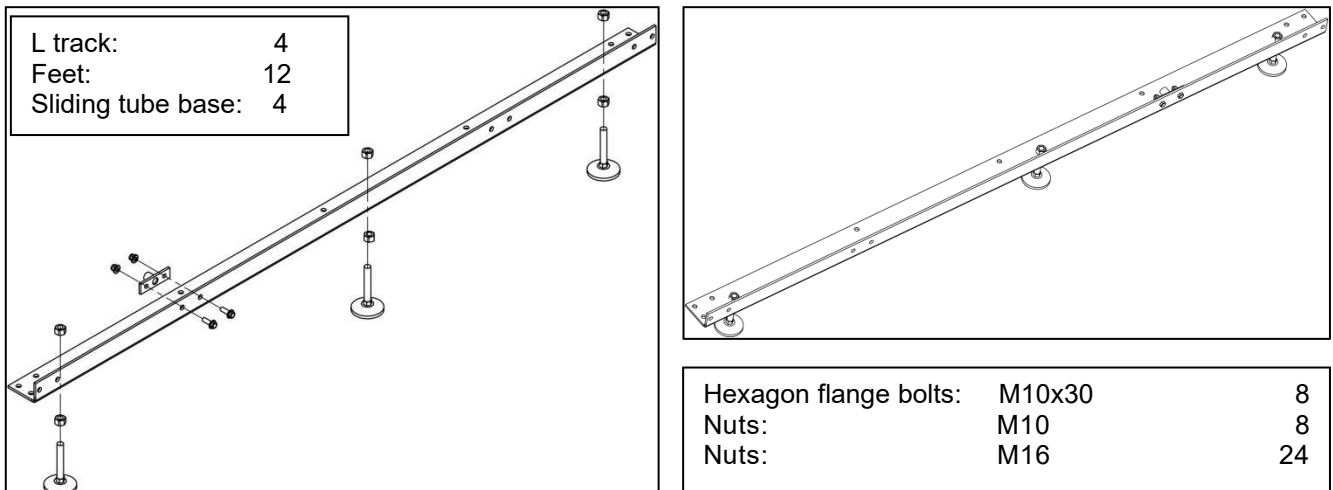
Take all of the parts out of the shipping crate and lay them out.

#2 – TRACKS

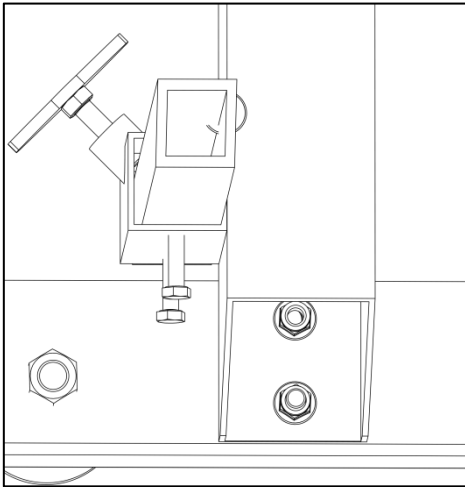
Assemble track system and secure loosely with provided nuts & bolts. It is important not to fully tighten the bolts at this stage. This will be done after the head is assembled and rolled along the track. It is ideal to assemble the tracks on a solid and level footing that is a minimum of 4" off of the ground – We recommend you attach the leveling legs to sleepers which we discuss later in the instruction manual). This will allow for easy cleanup of sawdust from under the tracks and height adjustment of the log supports and also easier leveling of the track.



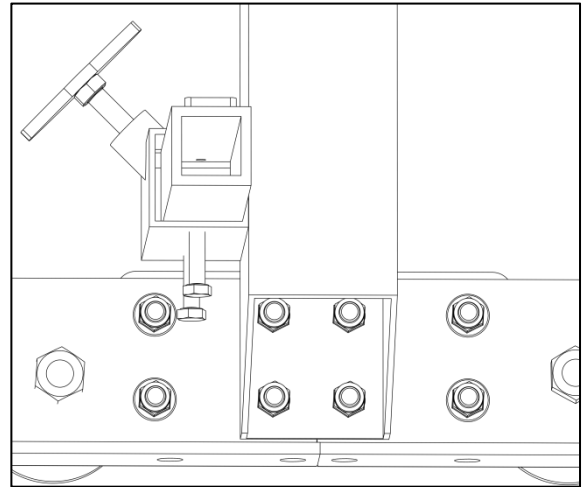
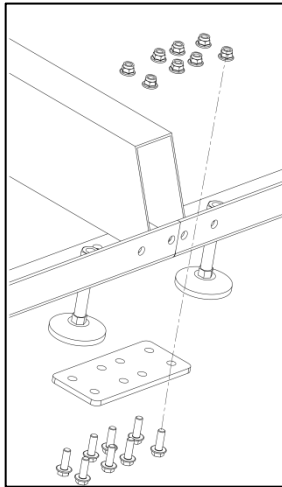
1. Install leveling feet and fasteners to the track, and install the sliding tube base on the track, repeat the above installation until all four are complete



2. 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 right-down 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.

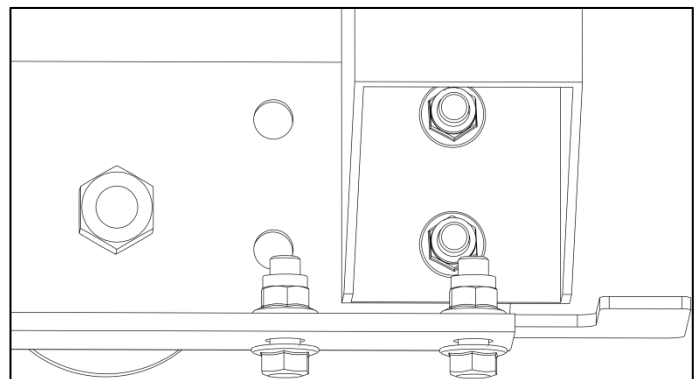
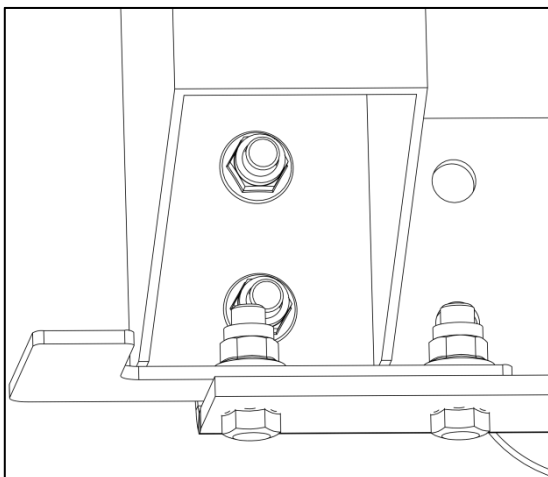


Hexagon flange bolts:	M10x30	16
Nuts:	M10	16

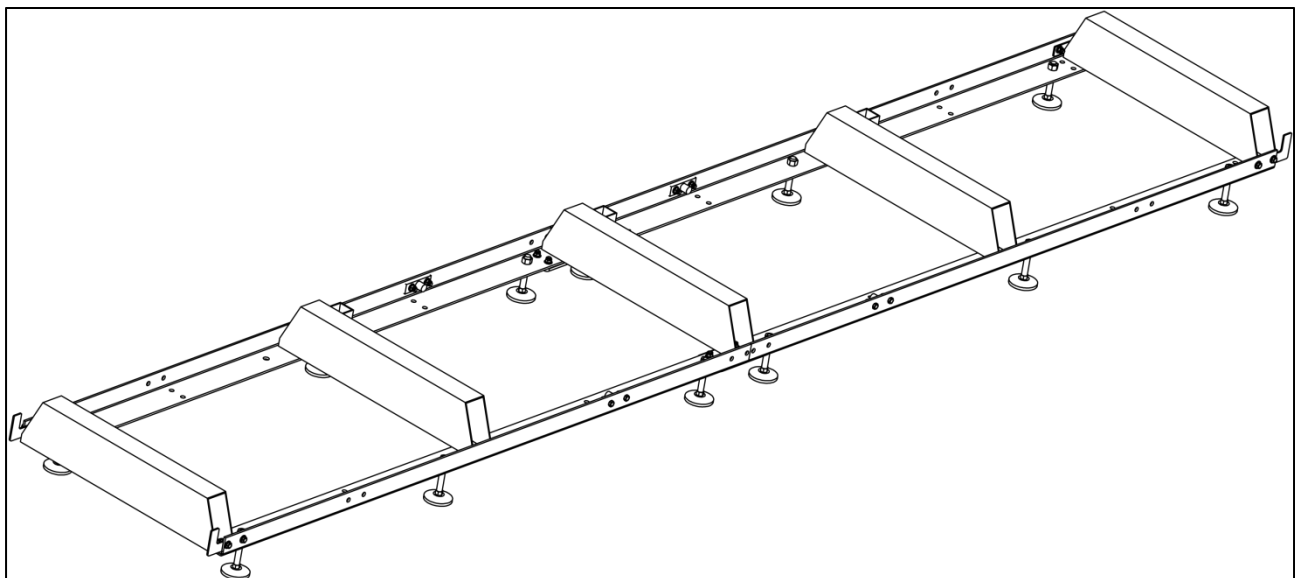


Hexagon flange bolts:	M10x30	16
Nuts:	M10	16

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

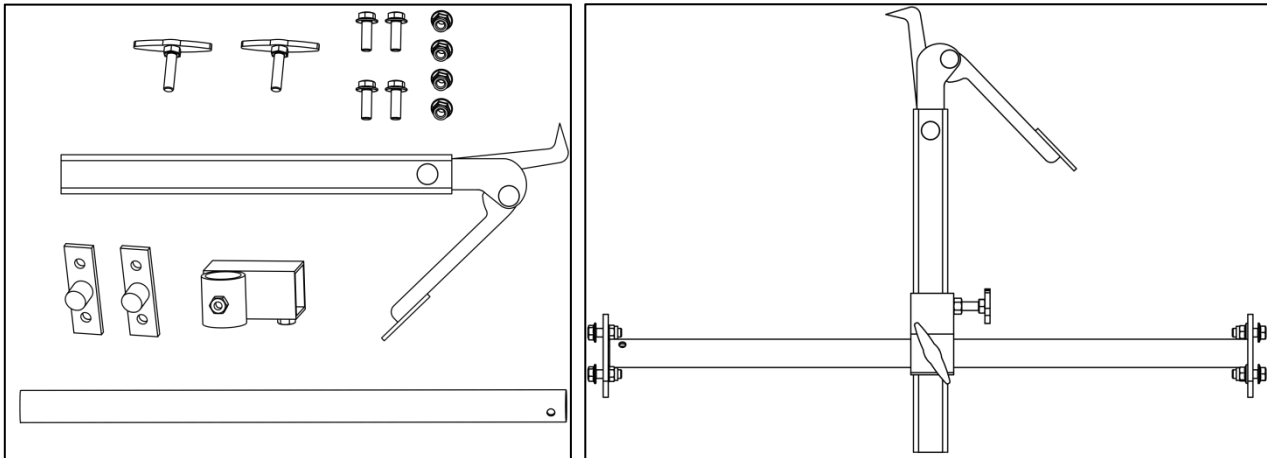


Hexagon flange bolts:	M10x30	8
Nuts:	M10	8

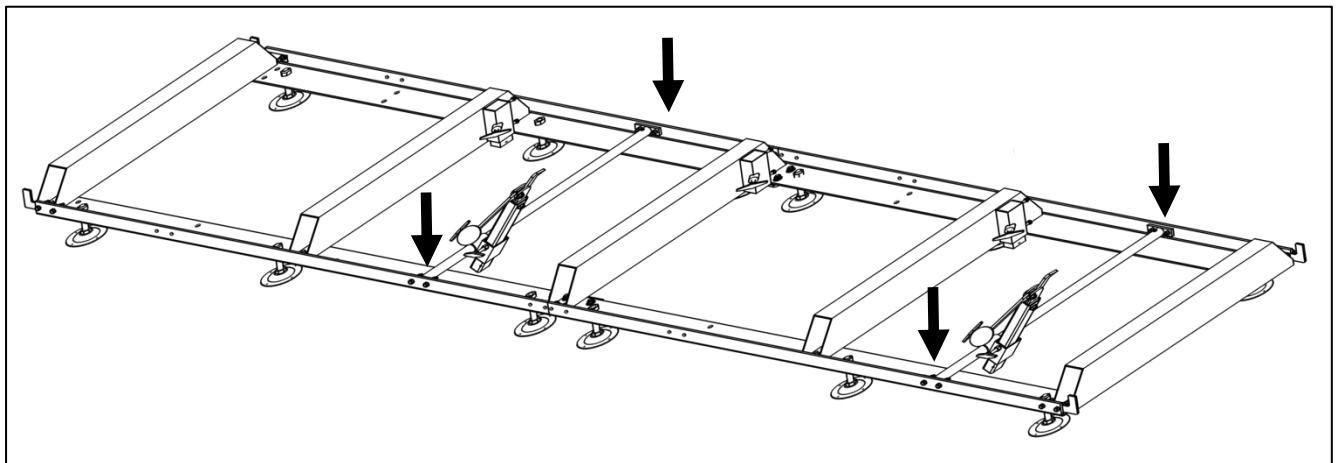


#3 – LOG DOG & SUPPORTS

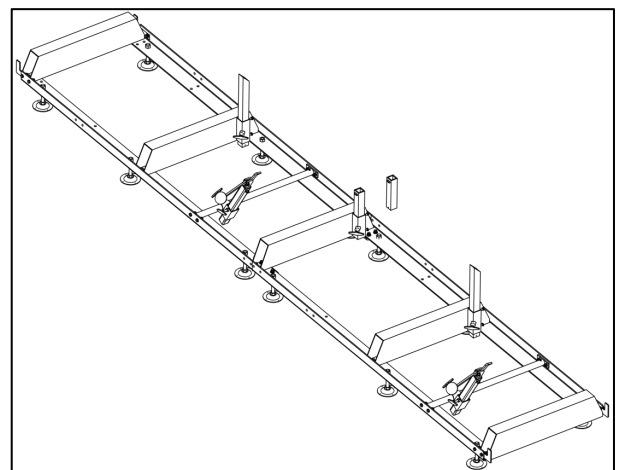
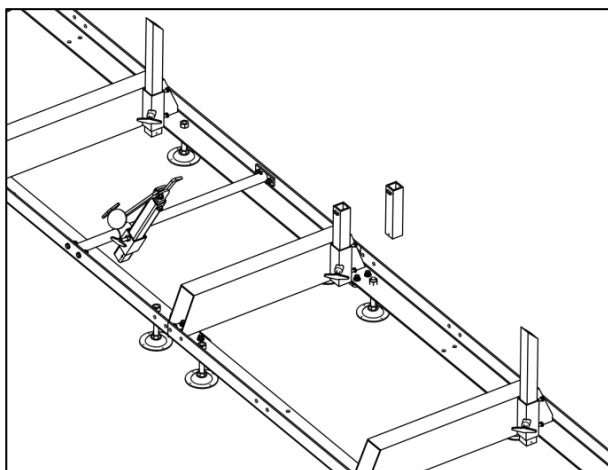
Assemble log dog pieces as shown below and use water proof grease on threaded handle and "T" handle.

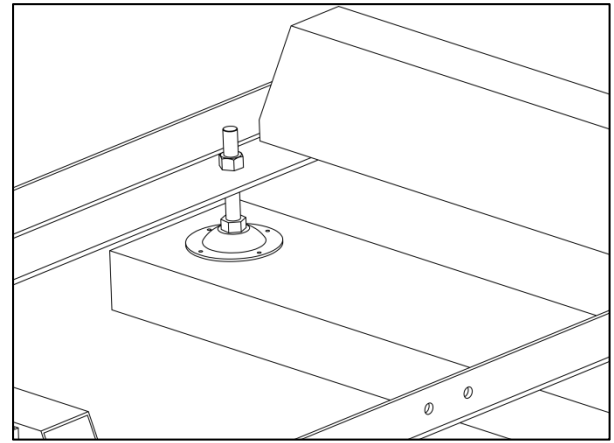
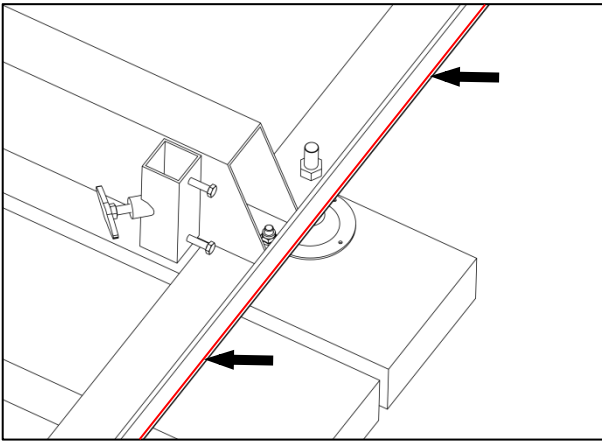


Attach assembly to the track using the provided nuts & bolts and tighten. Attach log dog assembly to track as shown below with the 4 nuts and bolts provided. Note that there are various locations along the track where this assembly can be bolted. Depending on how many track sections are being used, select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

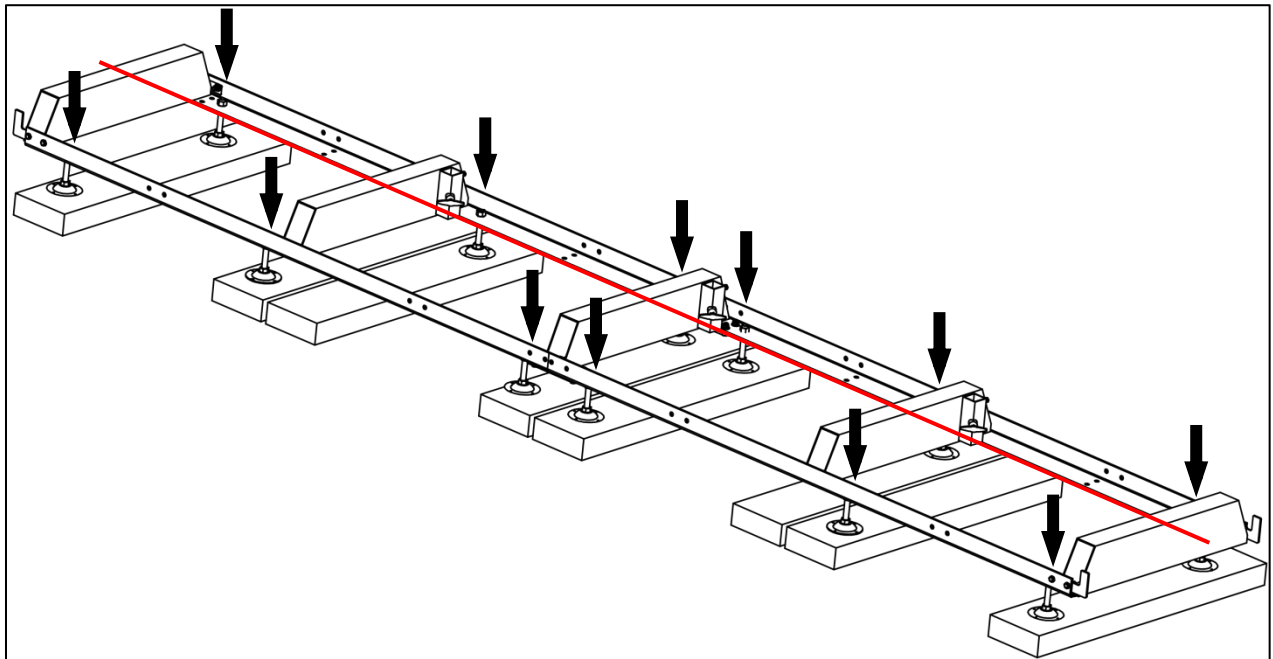


Insert log supports into track cross supports and secure with "T" handles. The "T" handle threads should be coated with waterproof grease. The sawmill includes two sets of log supports – a short set and a long set. The longer set is ideal for larger logs and the shorter set is ideal for small logs and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





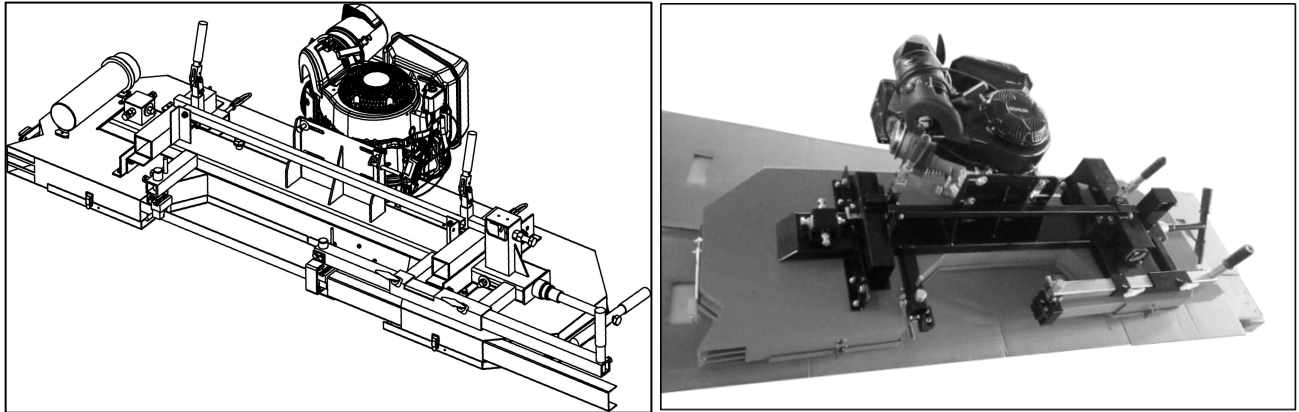
We recommend text screwing the leveling legs to sleepers once the mill has been made level. So before text screwing the mill to the sleepers, it is highly recommended that you run a string line down **both** sides of the mill, to make sure the track is straight and level. (The string line is in pink in the above picture).



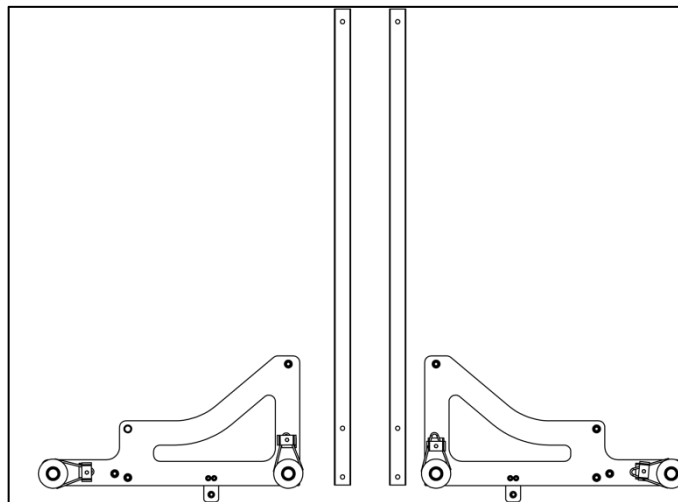
The **BLACK ARROWS** indicate where the locations of the leveling legs are. There are 4pcs per 87in. of track. 174 in. total on the machine. On the intermediate bunks the leveling legs alternate. We recommend placing the mill leveling legs on sleepers running left to right as shown above. You need to make sure the bunks are also level. To do this you use a spirit level going left to right on top of each bunk and also using a string line down the length of the track. The string line needs to be approx. 10mm **above** the bunks.

#4 – CARRIAGE ASSEMBLY

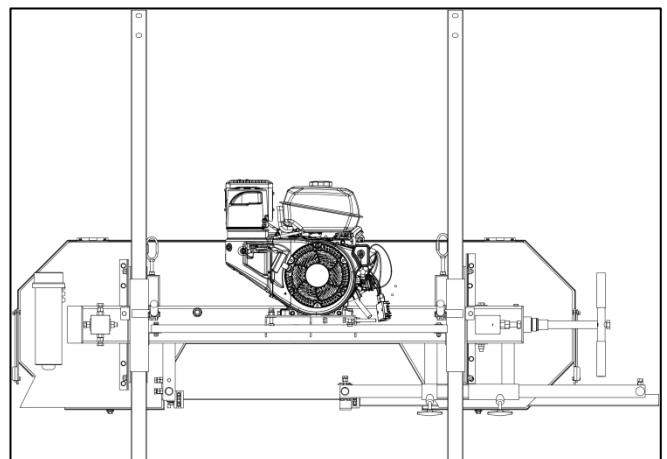
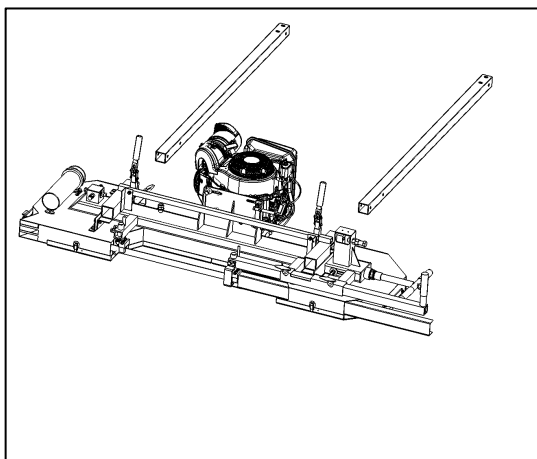
1. Place a moving blanket on the shipping pallet that the sawmill crate was strapped to. The blanket will prevent the blade guard covers from becoming scratched. Using a **minimum of two people** or a mechanical advantage system, remove the head assembly from the sawmill crate and place face down on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



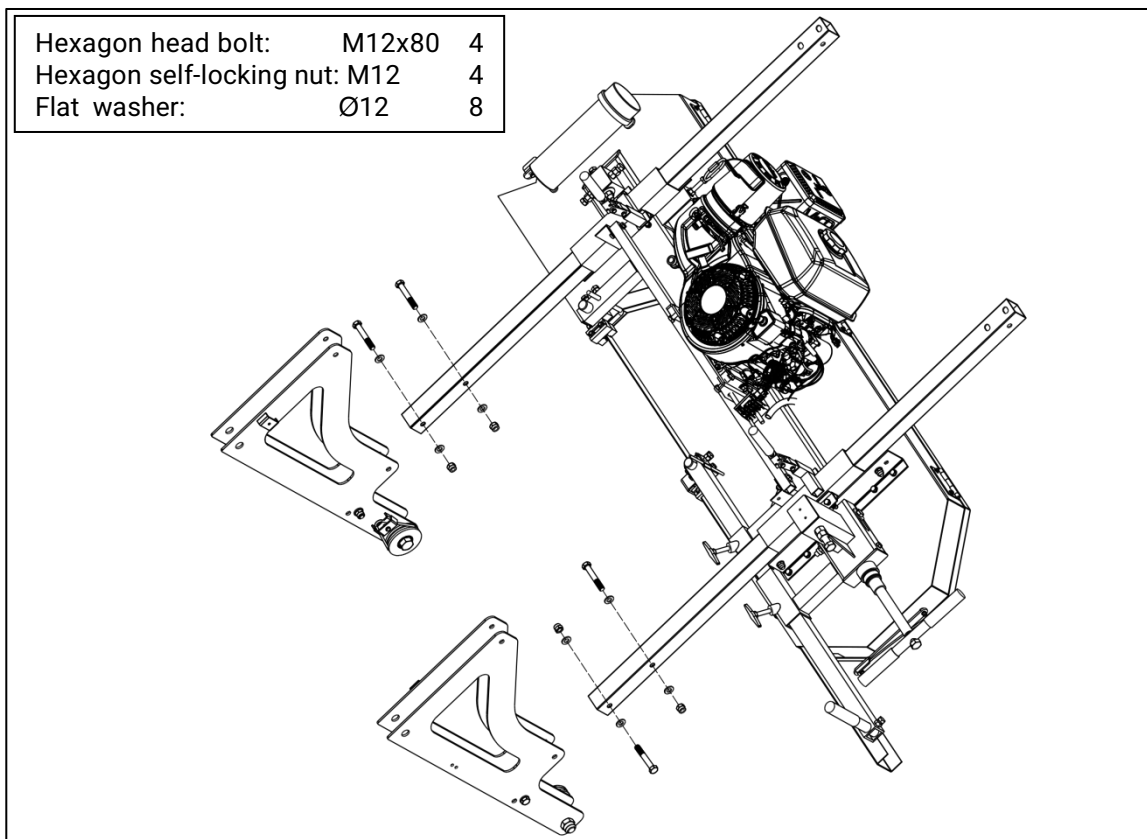
2. Lay the above carriage pieces out.



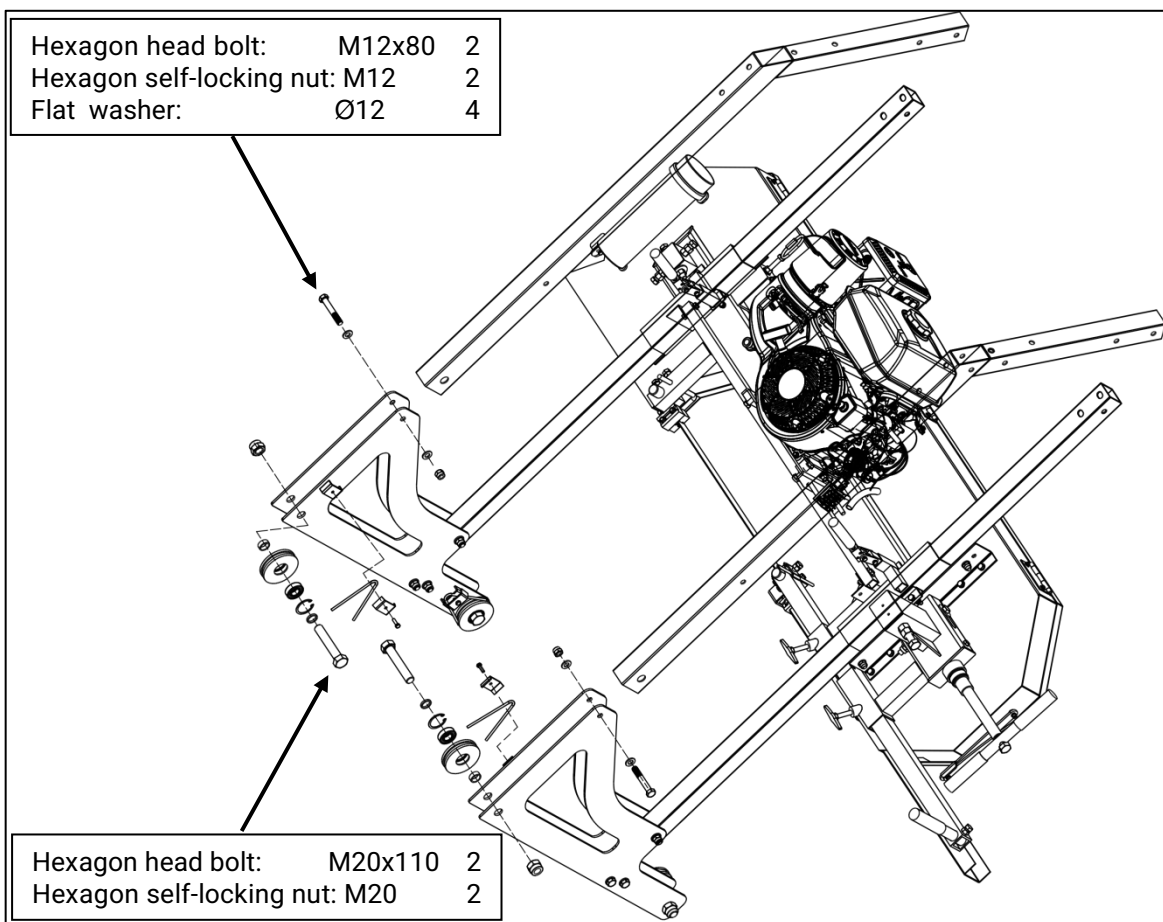
3. Then Insert vertical post assemblies into corresponding locations in head assembly.



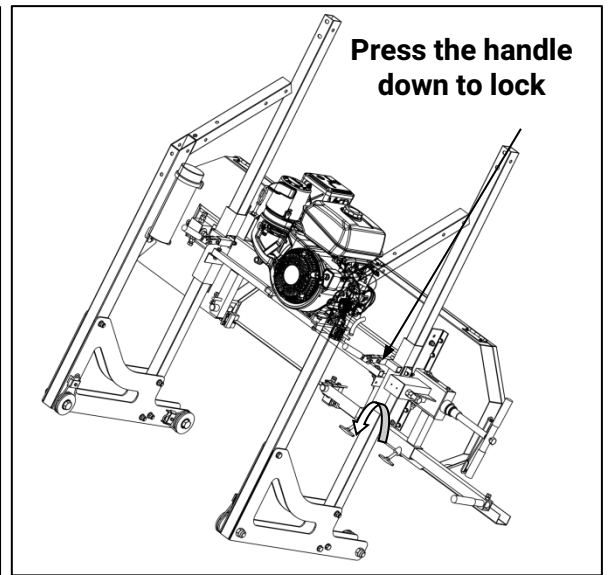
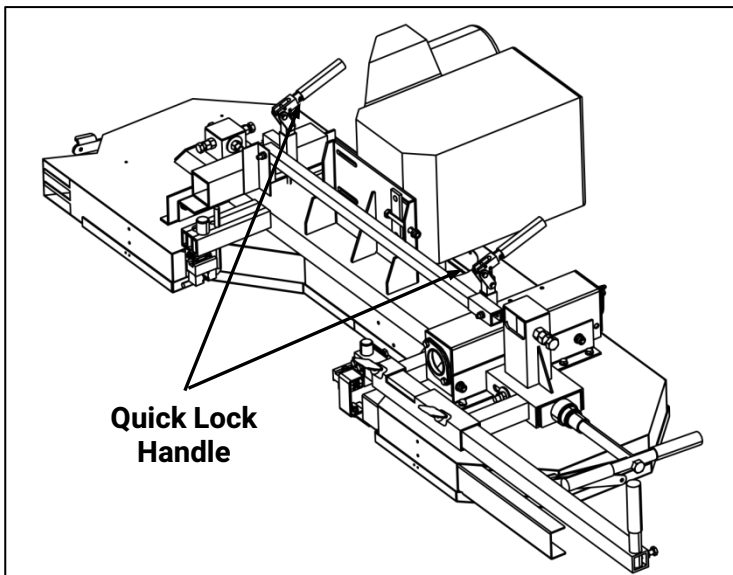
4. Assemble front vertical post to wheel assembly using the two bolts and back plate. Repeat same step for the other front vertical post assembly.



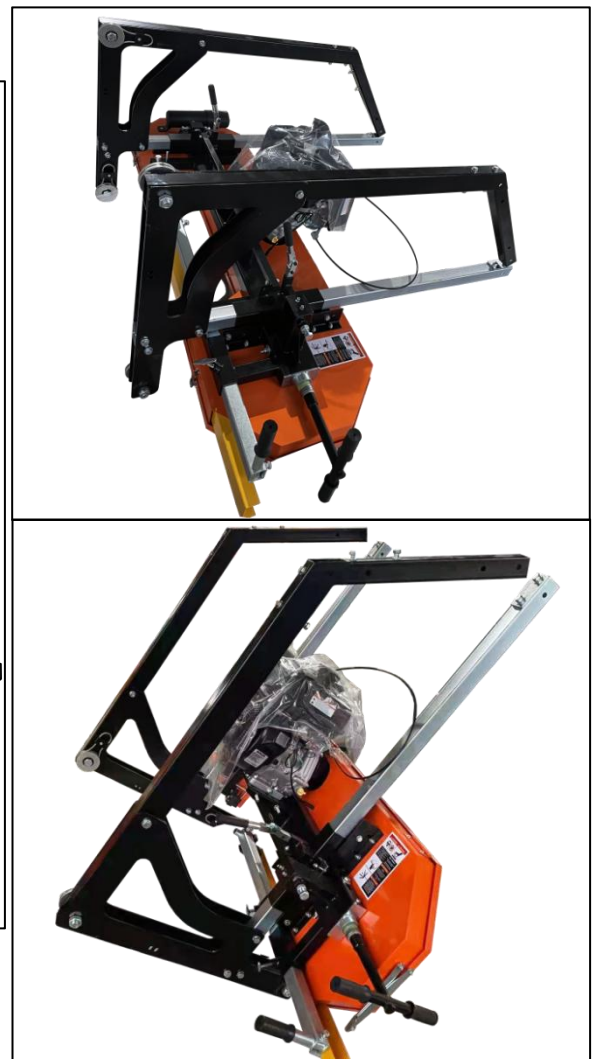
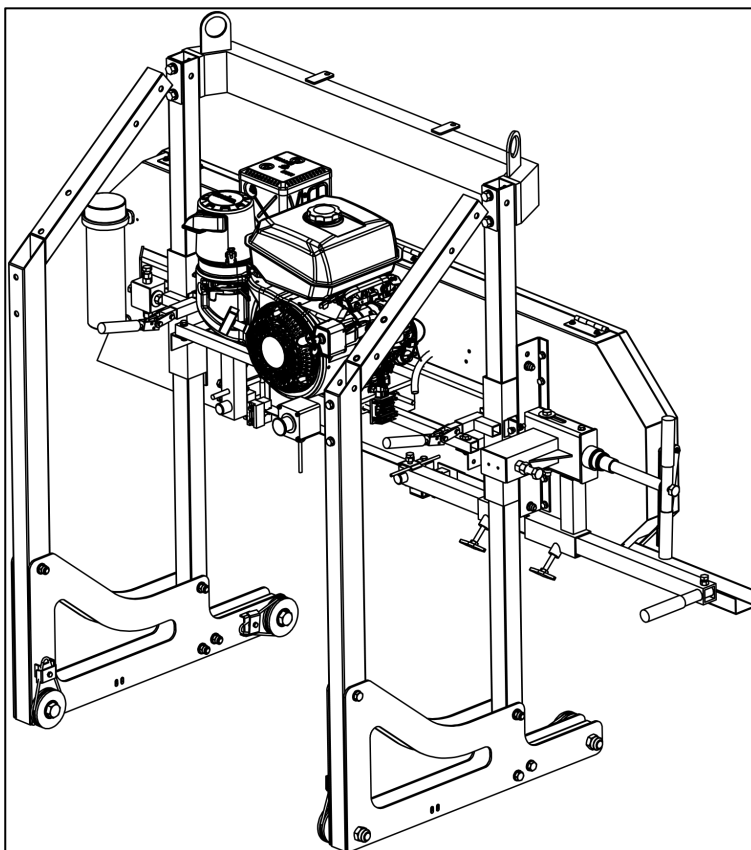
5. Assemble rear vertical post to wheel assembly using the two bolts and back plate. Repeat same step for the other rear vertical post assembly.



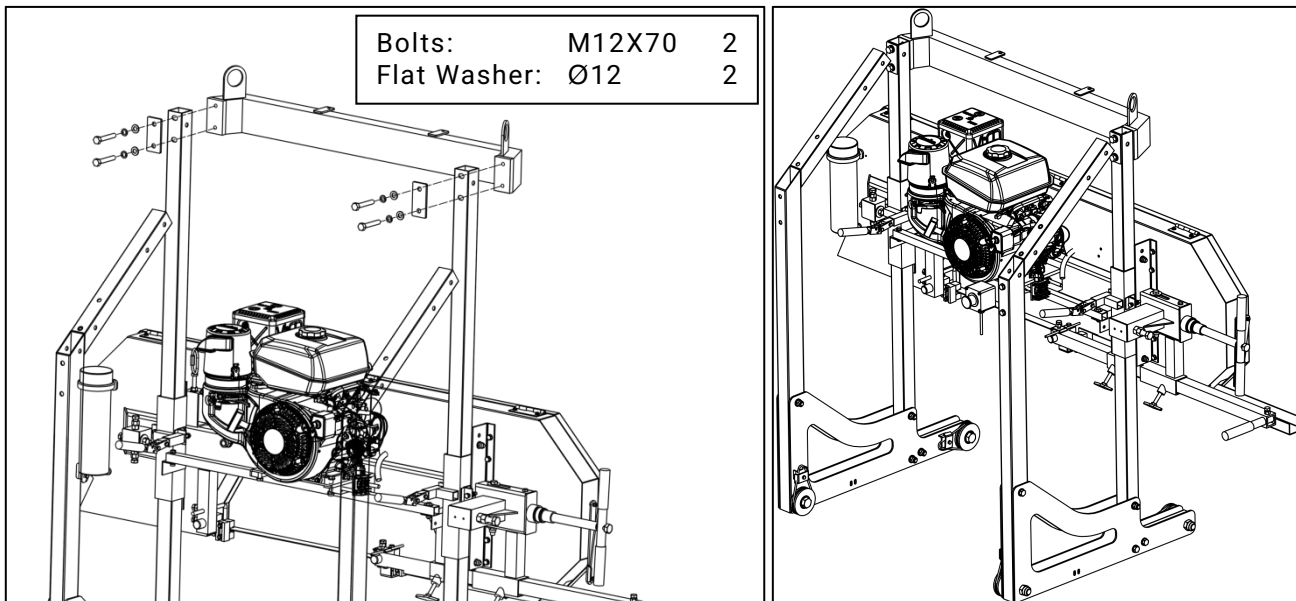
6. Lock the cam handles on both the square post to prevent the head from moving when it is stood up in the coming steps. Ensure that when activating the cam handles, the clamps securely lock on the square vertical post.



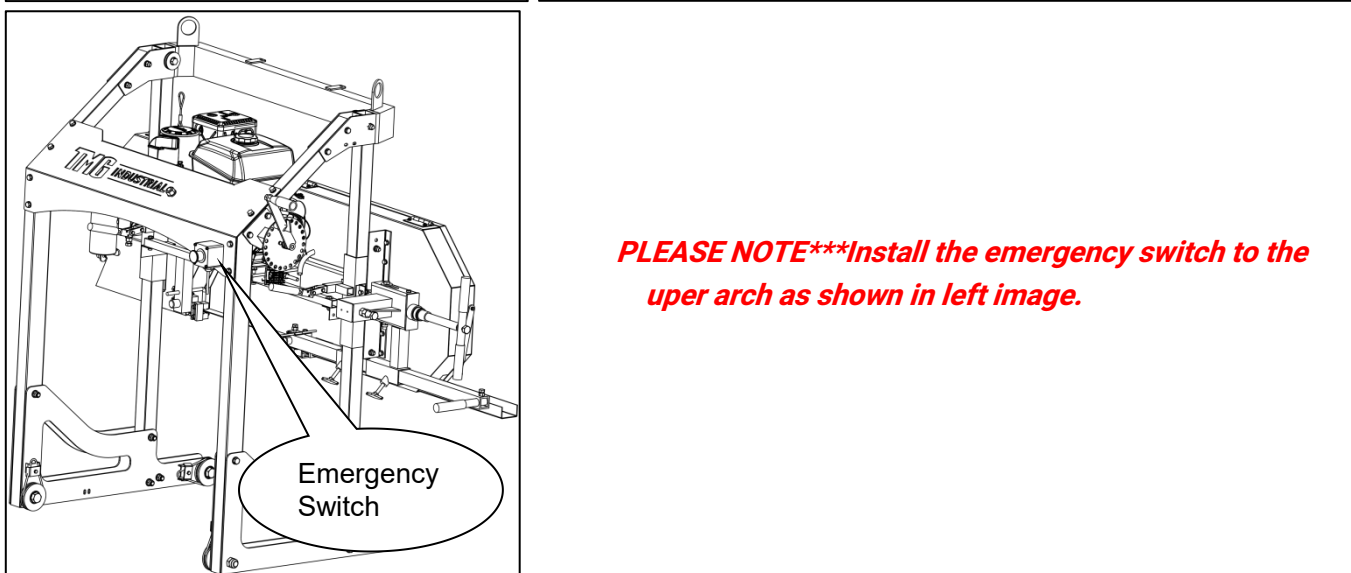
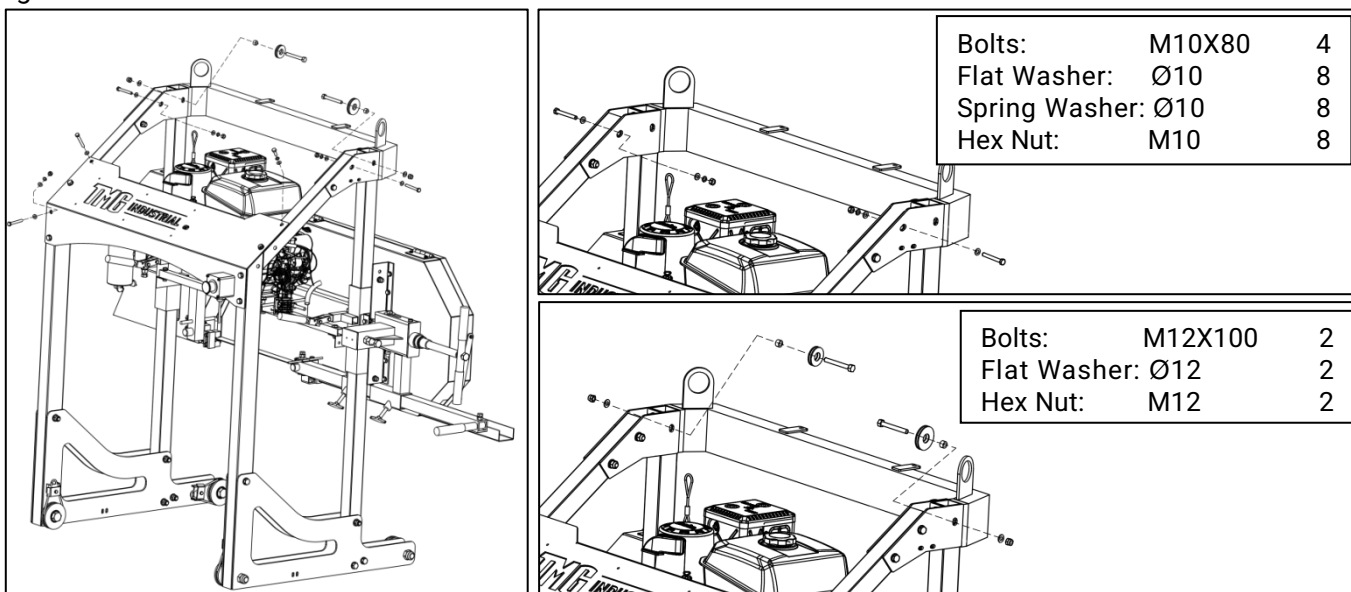
7. With one person on each post, stand the head assembly up on the wheels as shown above. Again, using a **minimum of two people**, set the saw head assembly on the track system ensuring the carriage wheel grooves rest on the "L" rails. The square vertical post should be on the same side as the log supports



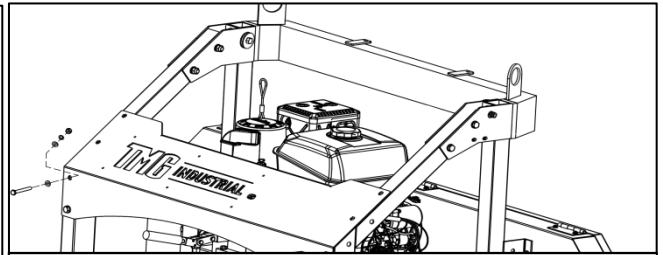
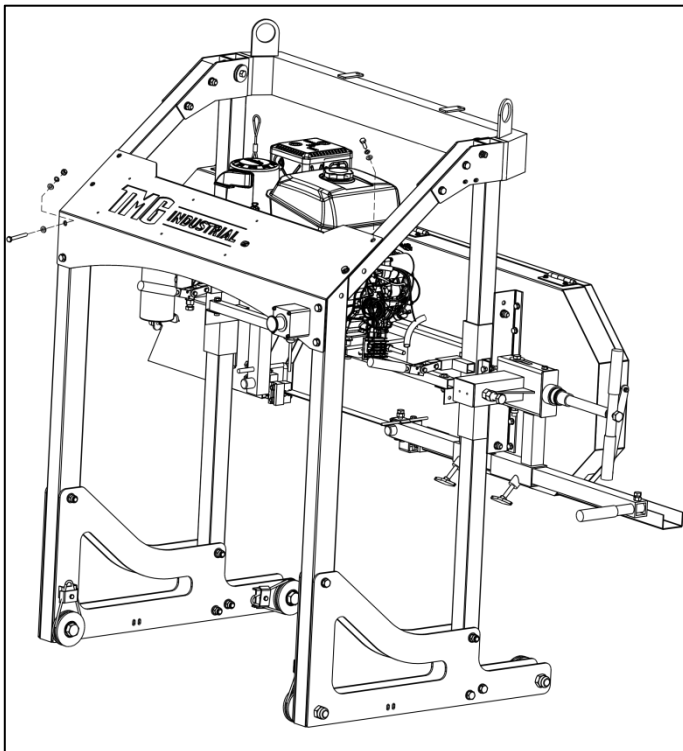
8. Slide the cross beam into the two square tube post. Bolt the top of the square tube post and the cross beam



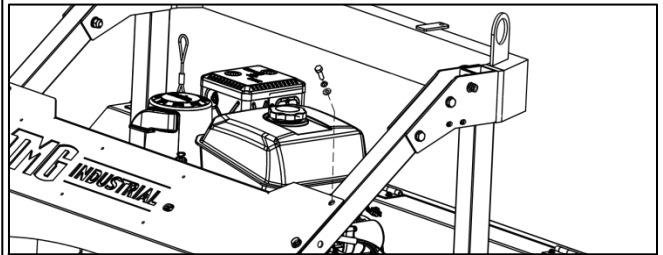
9. Install the connecting clamping plate, upper arch and steel cable roller, using wrench to hold the nut, tighten the bolt



PLEASE NOTE*Install the emergency switch to the upper arch as shown in left image.**

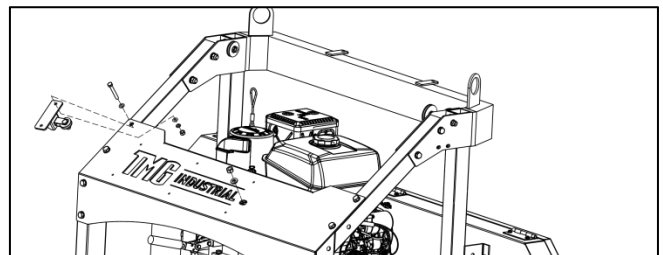
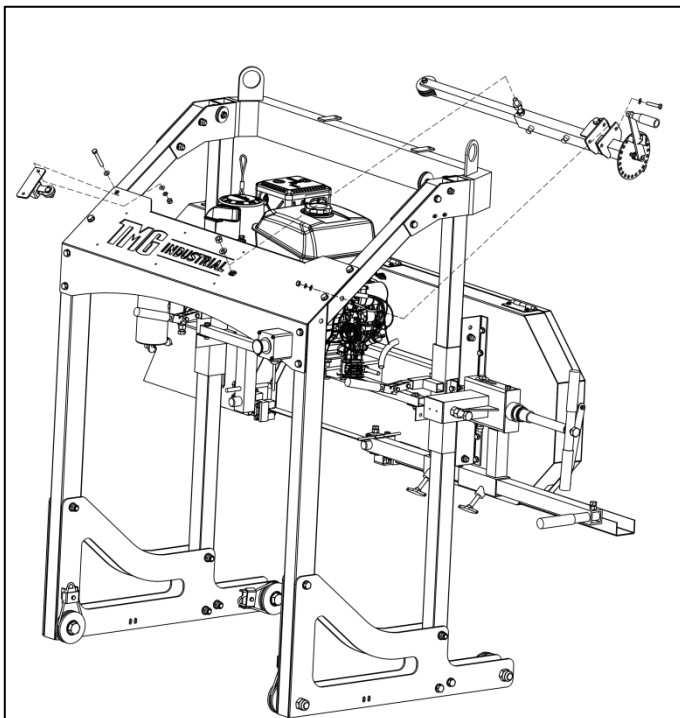


Bolts:	M10X90	4
Flat Washer:	Ø10	8
Spring Washer:	Ø10	4
Hex Nut:	M10	4

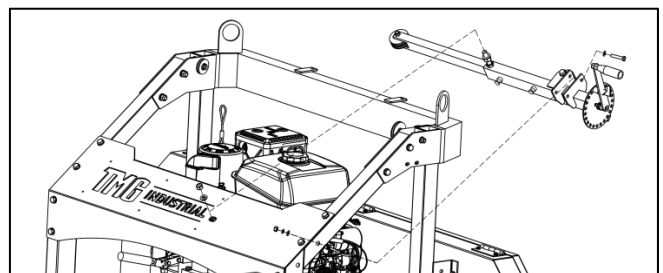


Bolts:	M10X30	2
Flat Washer:	Ø10	2

10. Install the lifting system, using wrench to hold the nut, tighten the bolt.



Bolts:	M10X75	2
Flat Washer:	Ø10	2
Spring Washer:	Ø10	2
Hex Nut:	M10	2

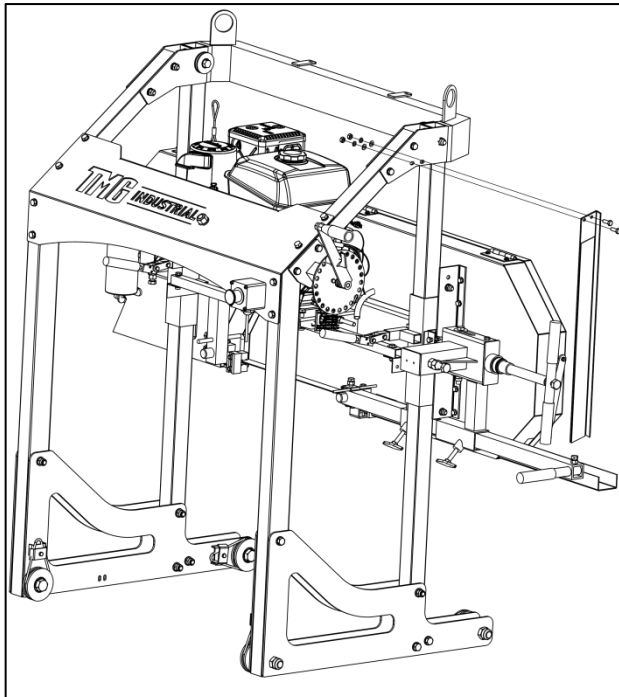


Bolt:	M 10 x 80	2
Flat Washer:	Ø10	4
Spring Washer:	Ø10	2
Nuts:	M10	2
Nuts:	M16	2

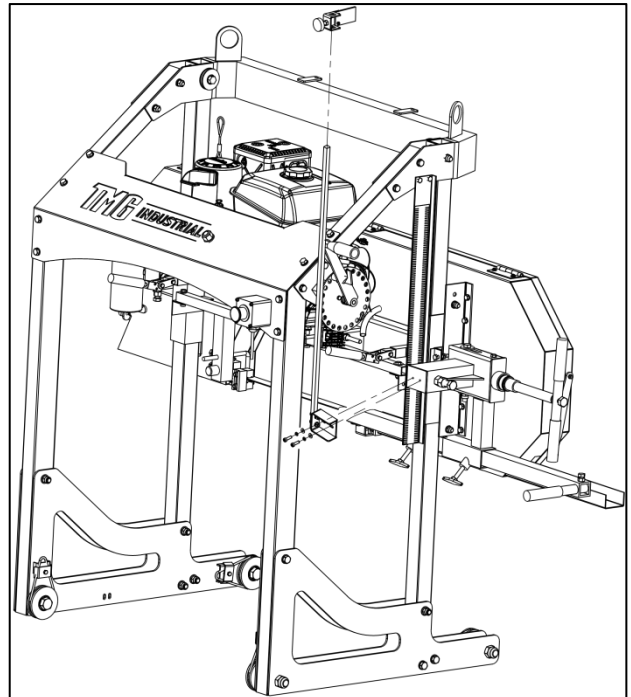
11. Place the measuring scale assembly, the assembly include ruler and height indicator.

A. install ruler, using wrench to hold the nut, tighten the bolt.

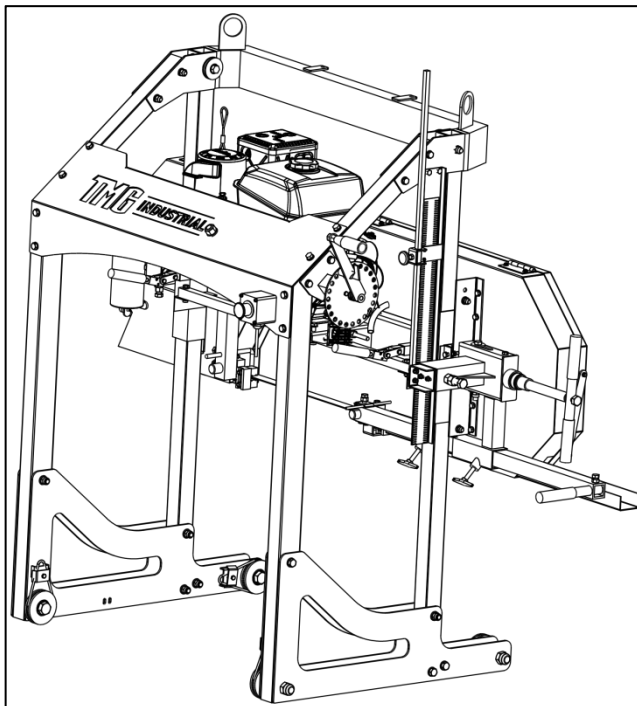
B. Install the square indicator rod to the sawmill using the two bolts and tighten. Slide the scale indicator over the square rod and tighten.



Hexagon Head Bolt :	M8X20	2
Spring Washer:	Ø8	2
Flat Washer	Ø8	2
Nuts:	M8	2

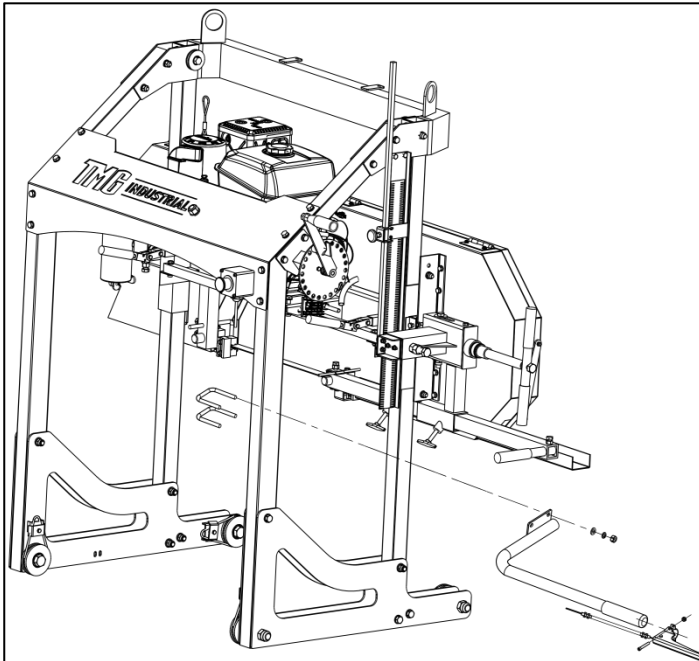


Hexagon Head Bolt :	M6X25	2
Spring Washer:	Ø6	2
Flat Washer	Ø6	2



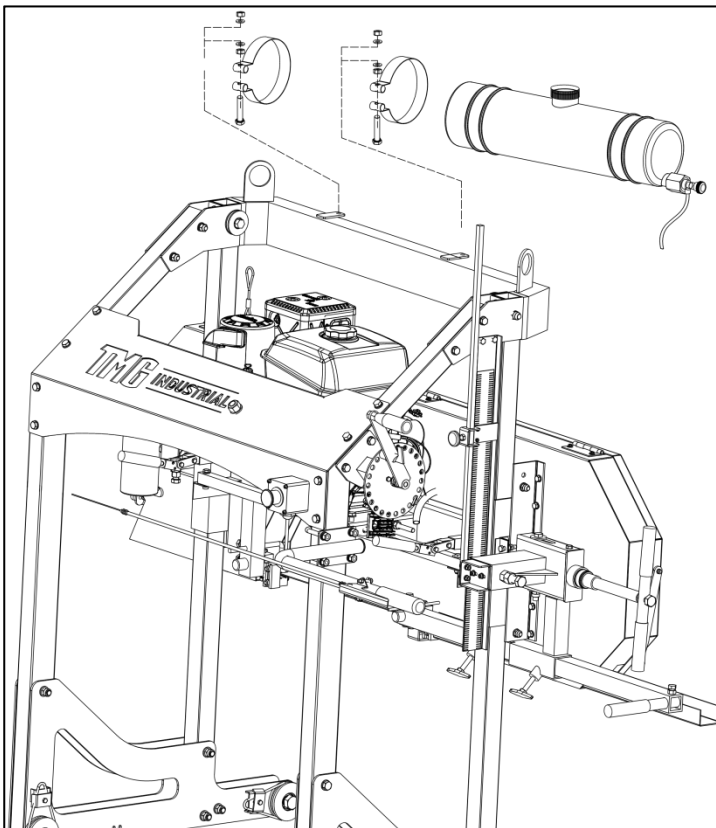
It is important to alternate tightening of the nuts (top then bottom) to ensure the black round clamp begins to compress evenly on both the top and bottom until flanges meet at outer edge.

12. Install the throttle handle to the round bar as shown in below left image. 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.

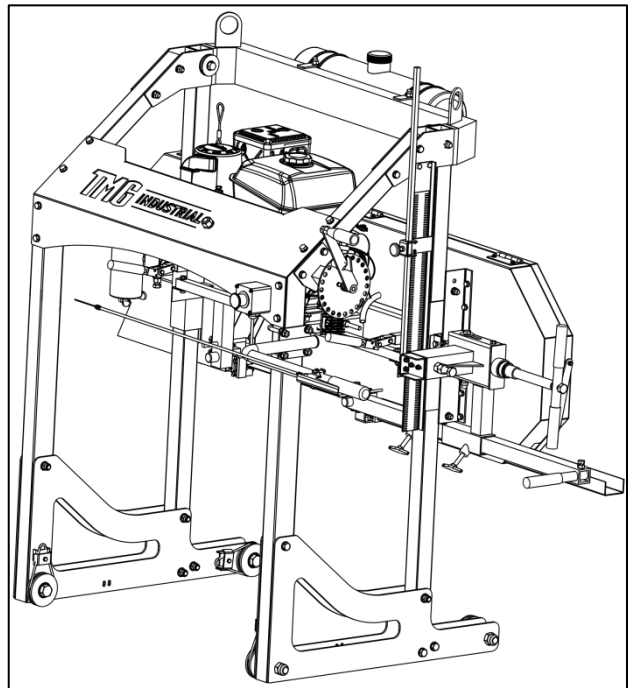


PLEASE NOTE*The idler screw needs to be wound fully out failure to do this will result in the engine not running at its full RPMs' which will result a poor cut.**

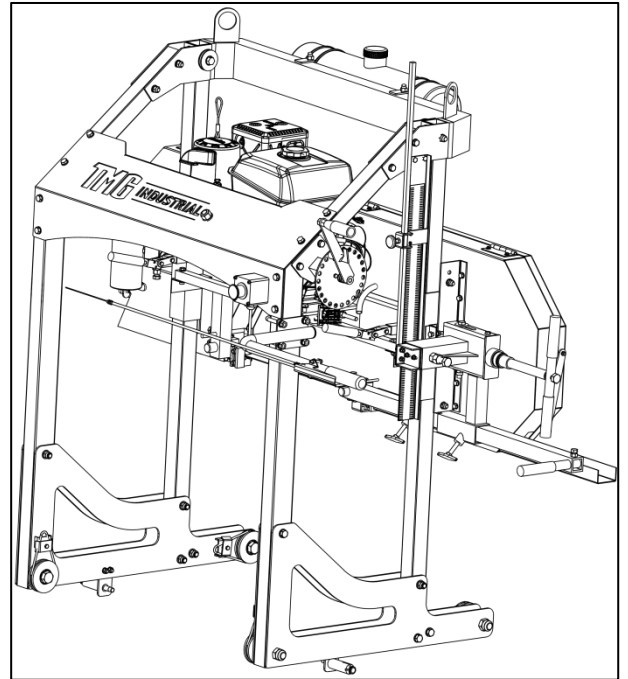
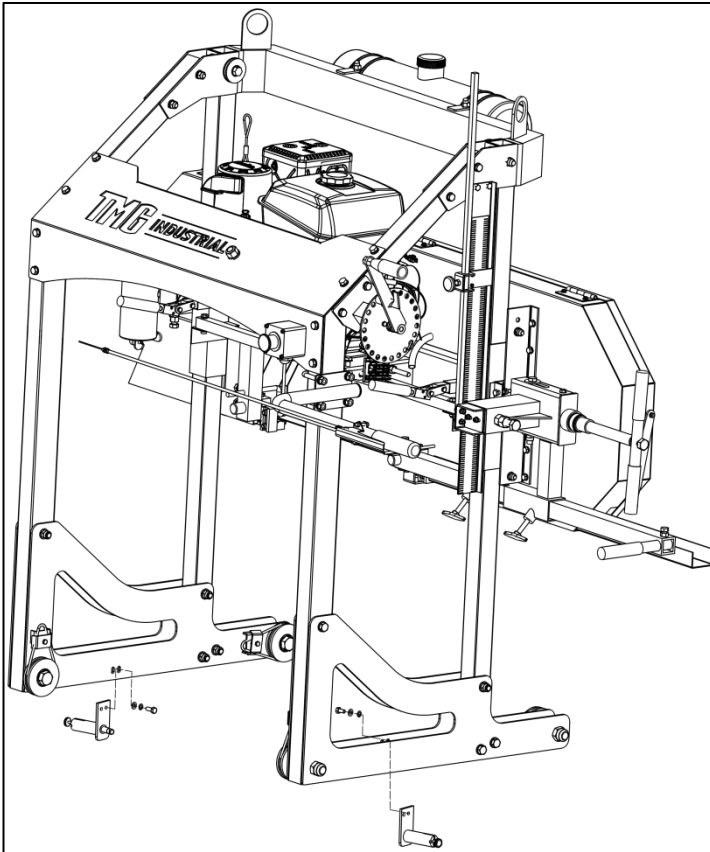
13. Install the cooling box bracket on the beam, using wrench to hold the nut, tighten the bolt.



Hexagon Head Bolt :	M10X105	2
Flat Washer	Ø10	4
Nuts:	M10	4



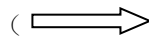
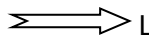
14. Install the travel locking device on the travel assembly, using wrench to hold the nut, tighten the bolt.



Hexagon Head Bolt :	M8X16	4
Spring Washer:	Ø8	4
Flat Washer	Ø8	4

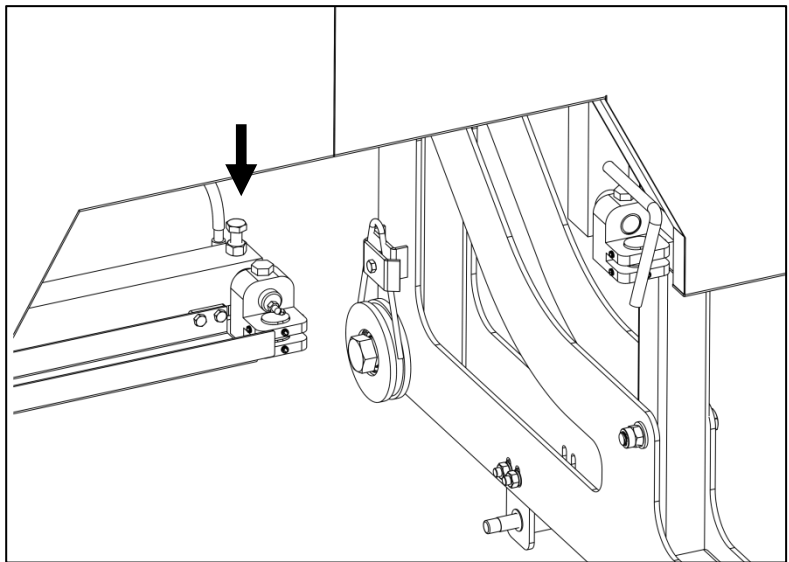


15.Route the cables on both sides as shown in the below image.

( Short cable,  Long cable)



16. The transparent water pipe connects the water tank to the copper connector



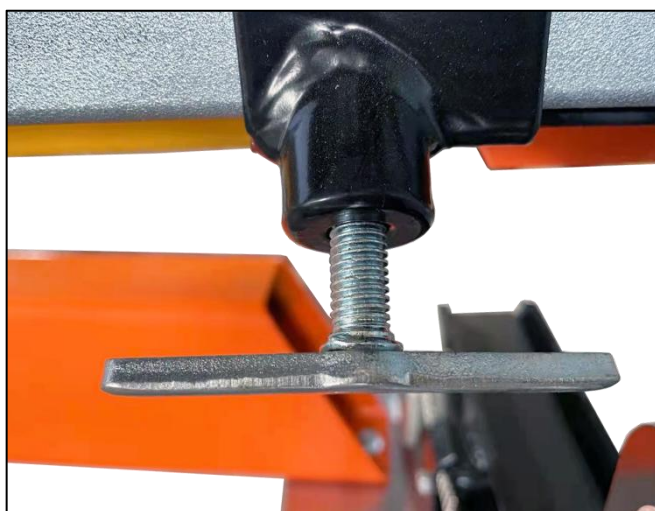
Please Note: We recommend adding some dishwashing liquid to the tank to help lubricate the wood – two to three capfuls.

17. Add waterproof 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 when the blade deflects no more than a total of 1/8" - 1/4" up/down.

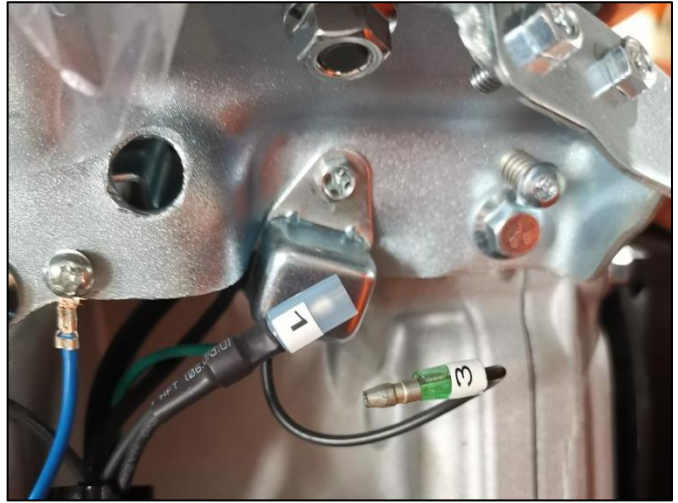
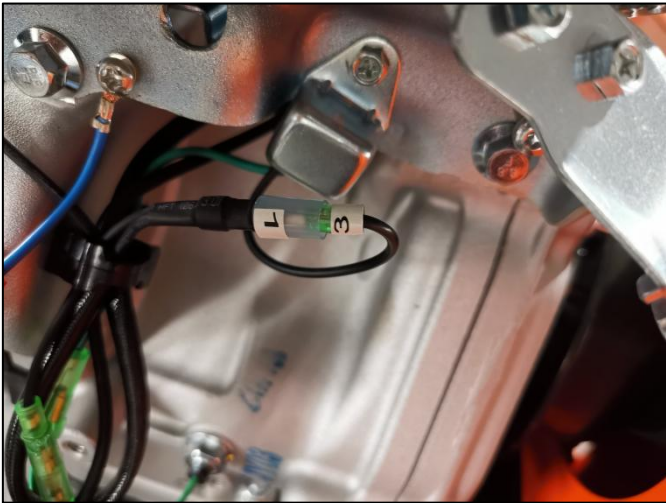


****Note – It is very important to take the tension off of the blade by turning the "T" handle in the counter-clockwise direction when the sawmill is not in use. Failure to do so, will result in flat spots on the rubber belts. These flat spots will cause the mill to vibrate excessively during next use.****

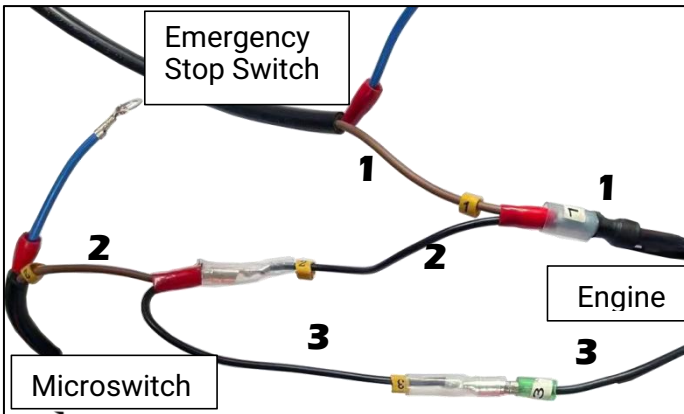
18. Add water proof grease to all "T" handle threads on the sawmill.



5 – ELECTRIC WIRE CONNECT



Step. 1: find the show 1 and 3 connection terminals

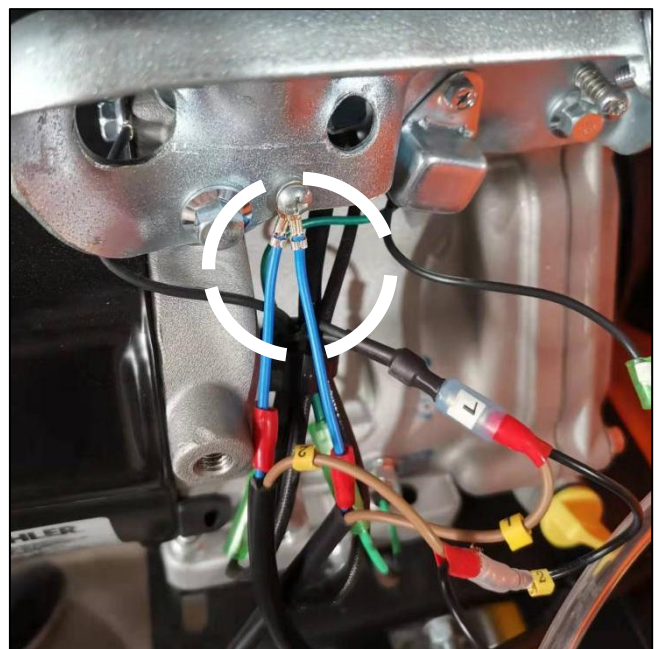


Step. 2: Disconnect the connection terminals

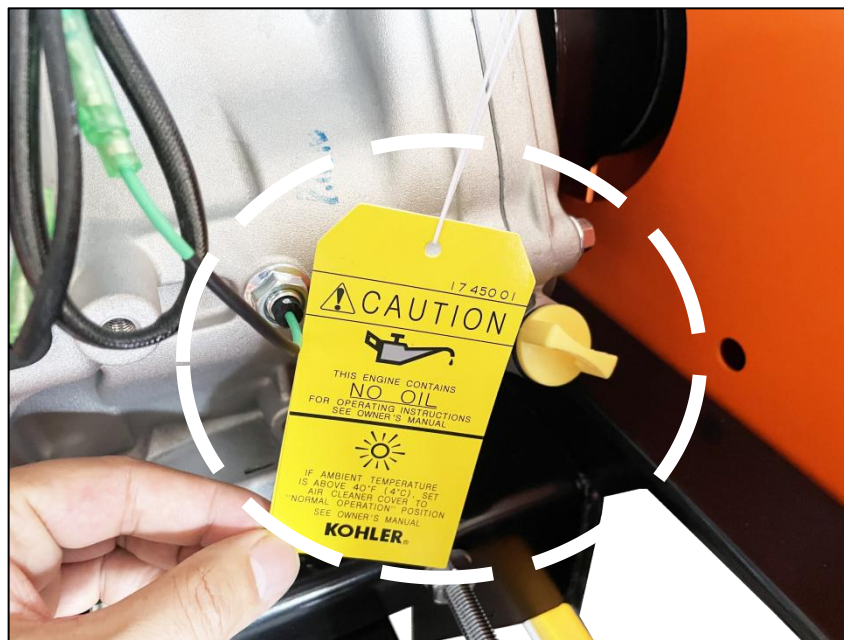
Step. 3: Find the **Emergency Stop Switch** and the **Microswitch**

Step. 4: Connect the 1 and 1, 2 and 2, 3 and 3

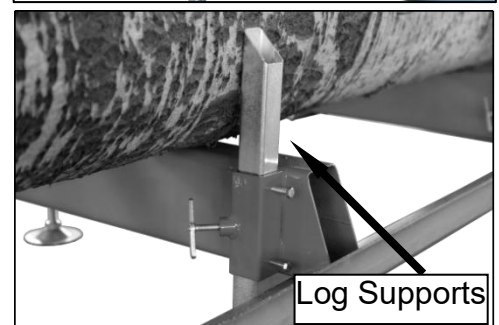
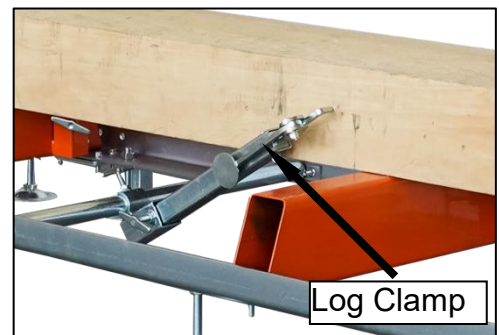
Step. 5: Connect the ground wire (Blue) on the engine



#6- ENGINE



Refer to the engine manual before using your sawmill. Please note that the engine does not contain any petrol 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.

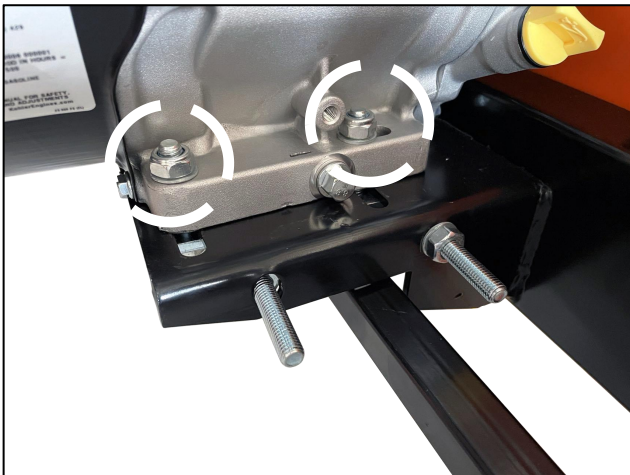
****Now that your sawmill is assembled, please run through the "SAWMILL SET-UP PROCEDURES" in the following section. Failure to do so may result in poor sawing performance, damage or injury. See next page.****

SAWMILL SET-UP PROCEDURES

#1 – BELT TENSION

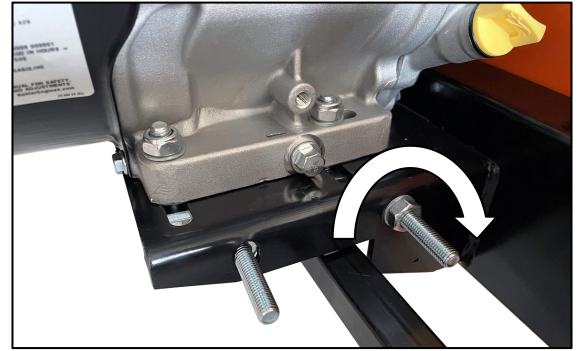


To check the belt tension, with your hand, firmly try to deflect the belt up and down. There should be no more than 1/4" of deflection in both directions (1/2" total). If the belt deflects more than this, it will need to be tightened as described below.



To tighten the drive belt, start by loosening the four bolts that secure the engine to the engine mount using a 16mm wrench.

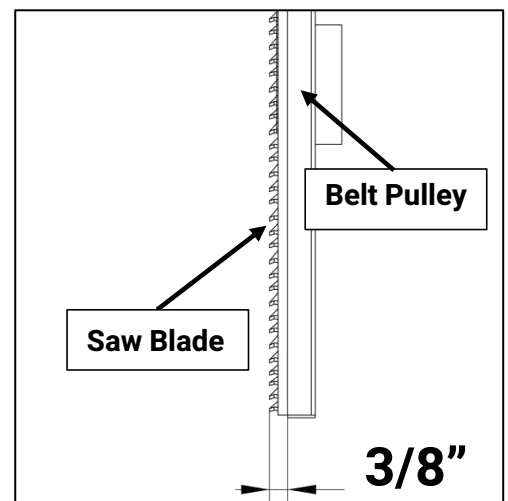
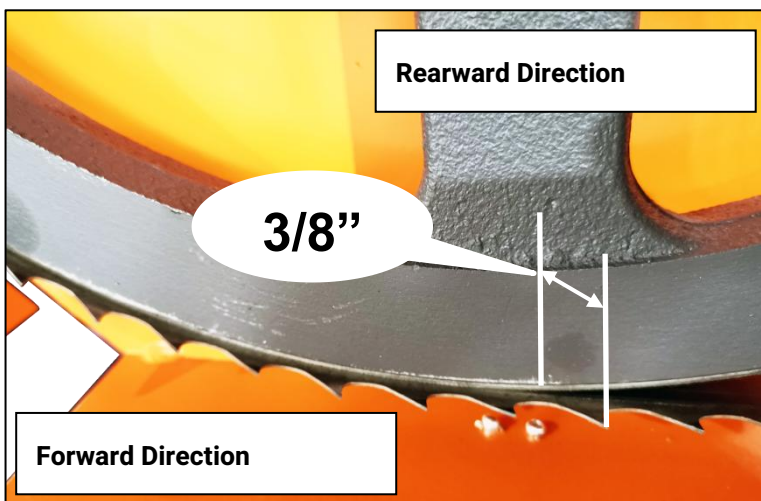
Now that the engine is free to slide on the engine mounting plate, turn the 16mm nut on the horizontal stud in the clockwise direction. This will pull the engine towards the stud and apply more tension on the belt. Do this step incrementally while checking the belt for proper deflection. It is also important 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.



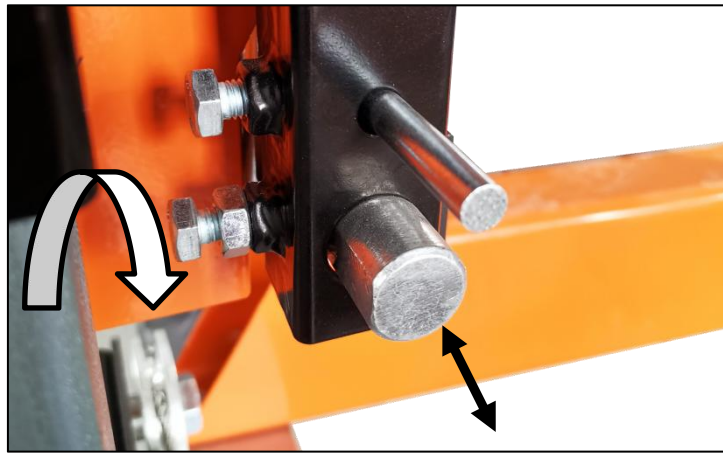
Once the desired belt tension is set, tighten the four engine bolts. *Alternatively, if the drive belt is too tight, the 16mm nut on the horizontal stud can be turned counter-clockwise.*

#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 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.

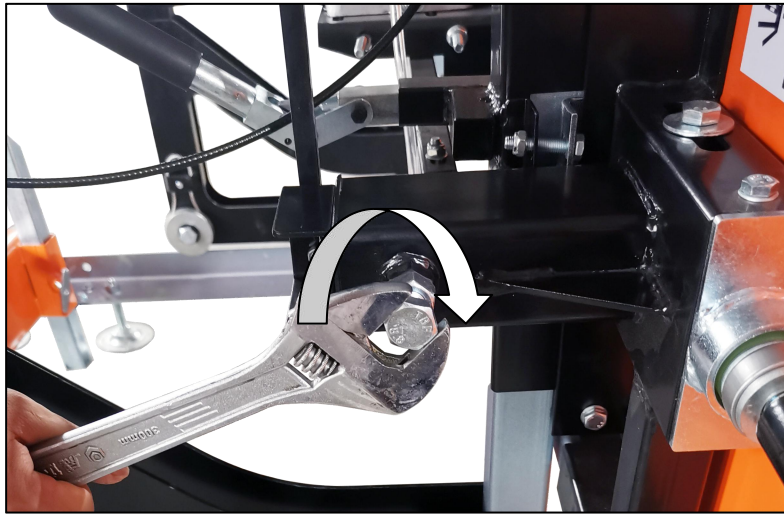


Take some tension off of the blade by turning the "T" handle in the counter-clockwise direction one full turn from full tension position.

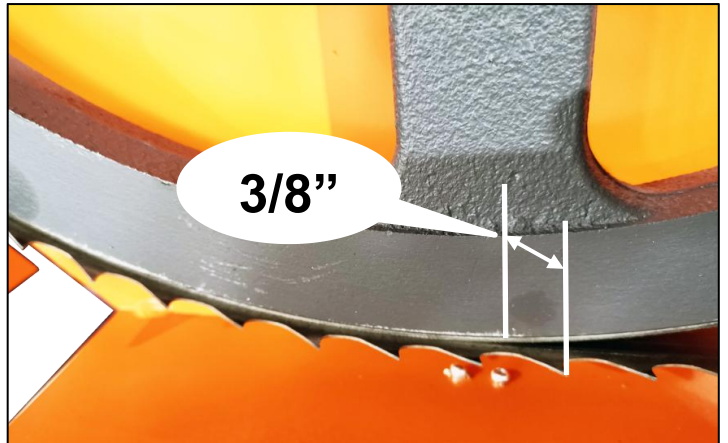
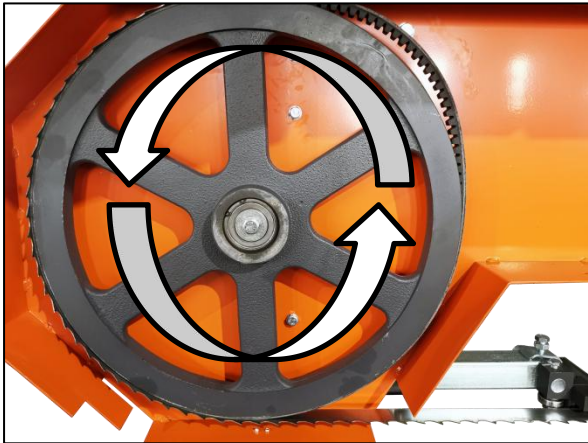
Adjusting The Right Hand Side



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.

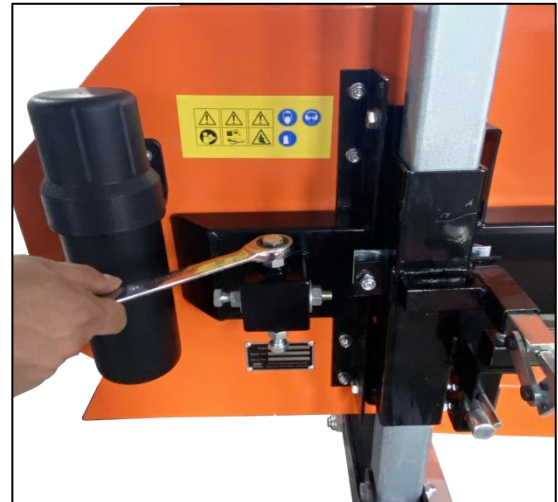
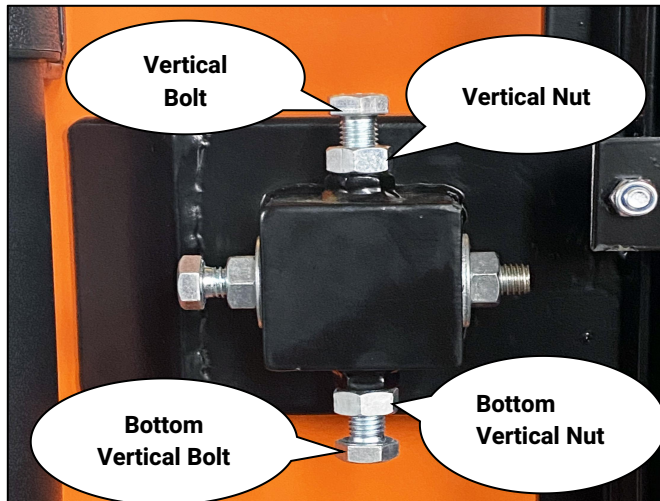


Wearing gloves, spin the bandwheel with your hand and observe how the blade has changed tracking. Measure the distance again and repeat the above step to further compensate if required. The ideal measurement is 3/8".

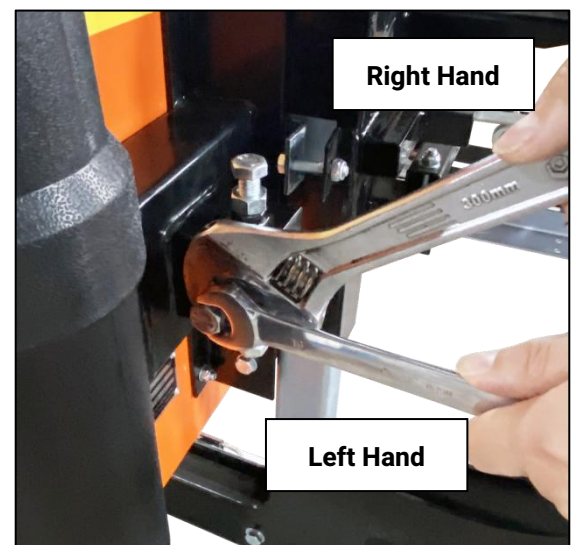
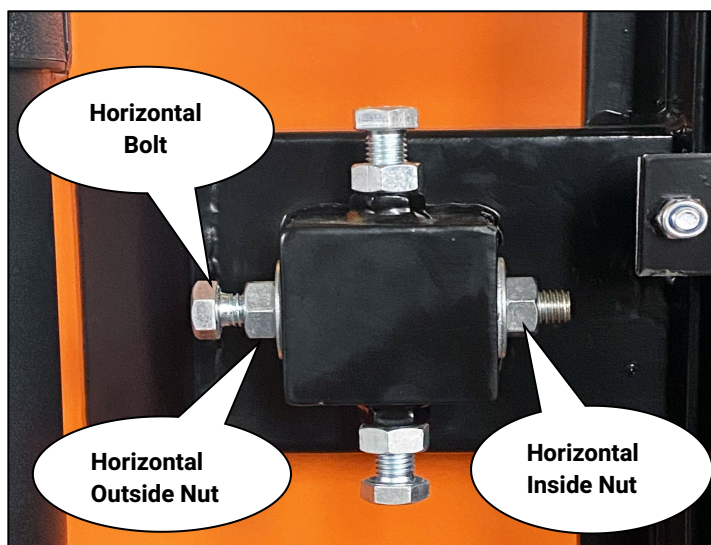


Once satisfied with the measurement, tighten the locking nut clockwise.

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.



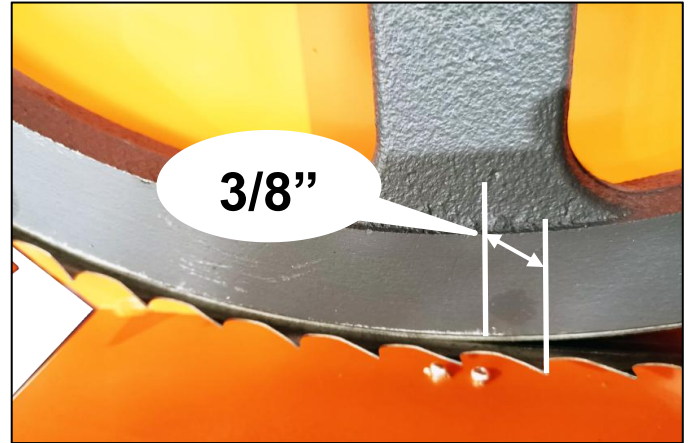
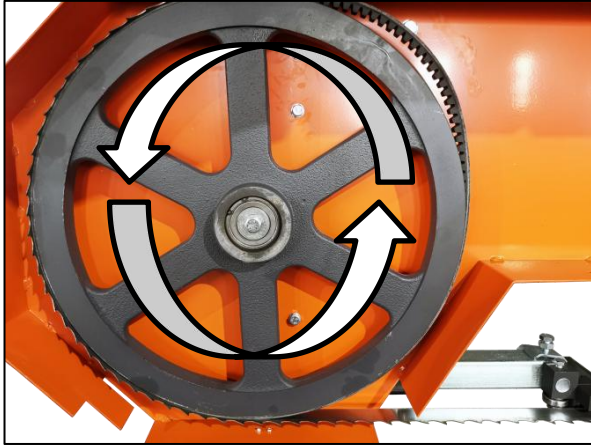
Moving The Blade Forward

Using a 16mm wrench, hold the "**horizontal bolt**" stationary with a wrench and turn the "**horizontal inside nut**" counter-clockwise a ½ turn. Still holding the "**horizontal bolt**" stationary, turn the "**horizontal outside nut**" clockwise a ½ 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 ½ turn. Still holding the **"horizontal bolt"** stationary, turn the **"horizontal inside nut"** clockwise a ½ turn. This step has now shifted the **"horizontal bolt"** and bandwheel shaft, causing the blade to track more forward.

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.

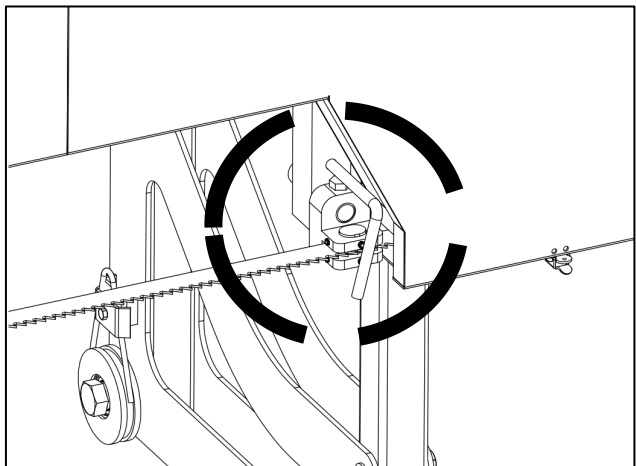
Measure the distance again and repeat the above step to further compensate if required. The ideal measurement is 3/8".

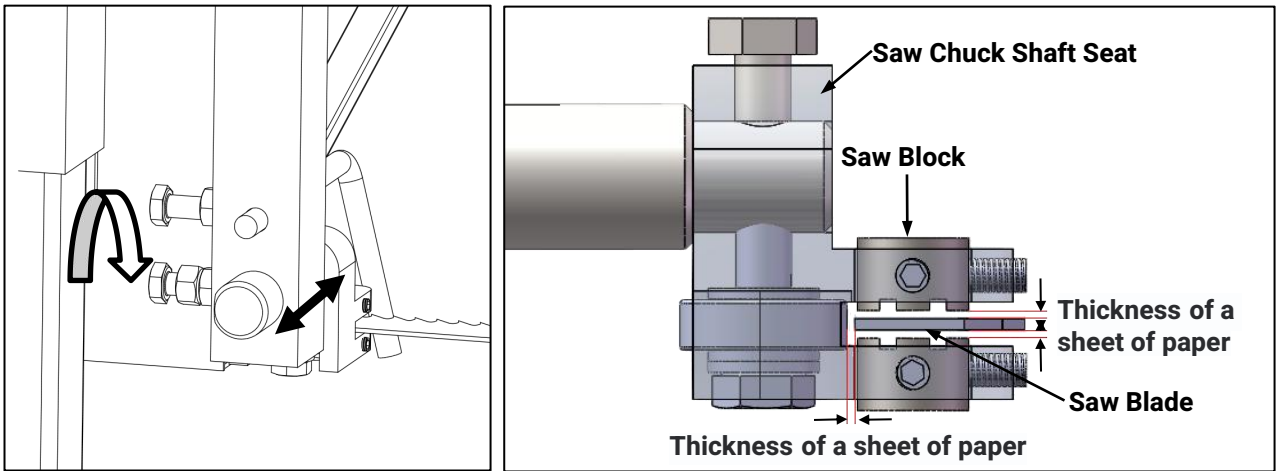
Once the blade is tracking true, bring the blade guide assemblies back up to the blade. Keep a paper width distance between the blade guide bearing and the back of the blade. More information on this set up can be found in the next section – **"BLADE GUIDE ADJUSTMENT"**

#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.



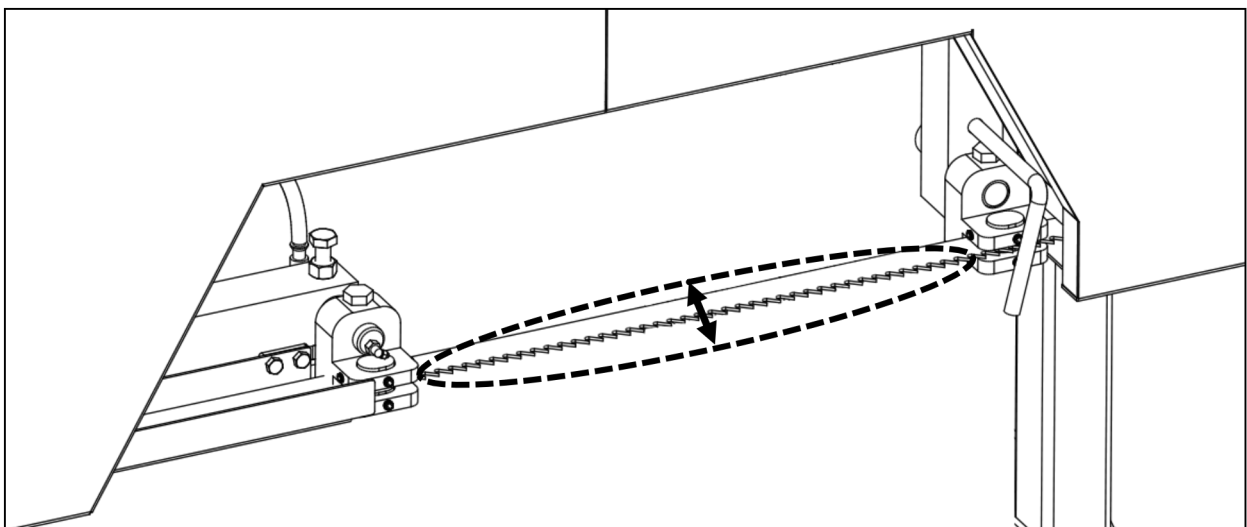


Loosen the blade guide assembly bolt with a 16mm socket. The round shaft should now be free to slide back and forth. Position it so that there is a paper width gap between the bearing and the back of blade. Tighten bolt against the flat on the shaft to secure assembly back in position.

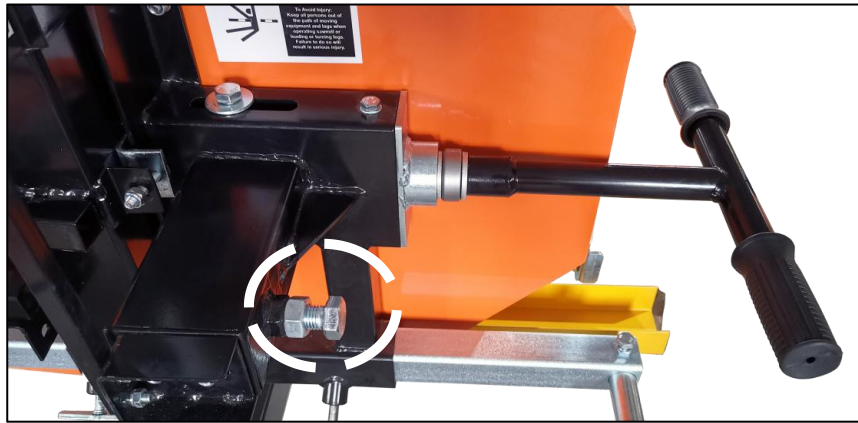


Using a piece of paper in between the blade and blade guide blocks, tighten the allen key bolts.

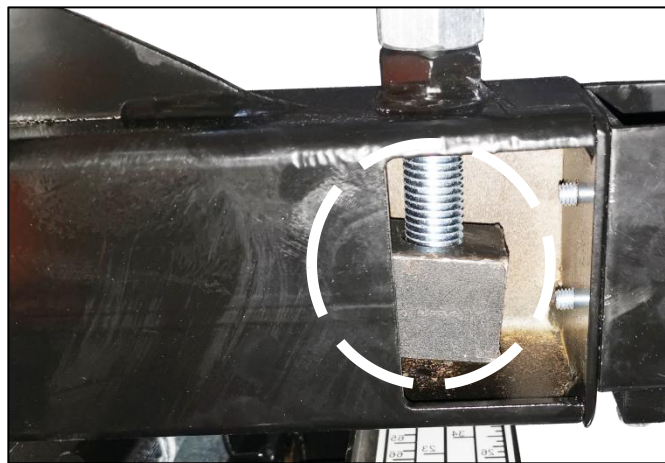
#4 – BLADE TENSION



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.

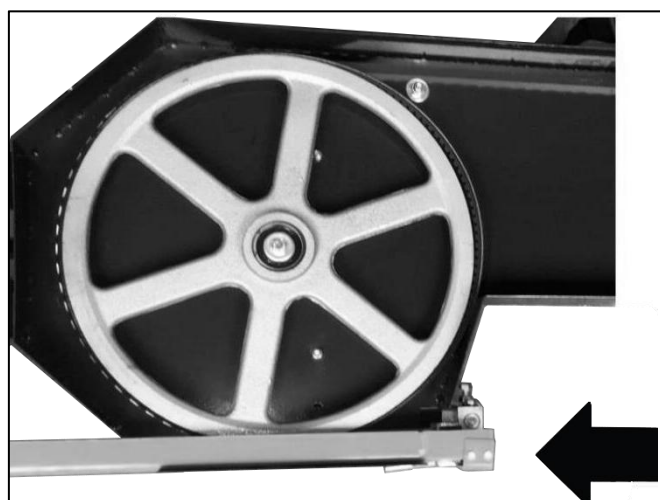


When tensioning the blade, make sure the tracking adjustment bolt sitting behind the T handle (pictured) is sitting back in its recess after you have finished and *before* the mill is run. Failure to do this will result in the blade being thrown and possibly broken.



Tracking adjustment bolt out of recess, of it looks like this DO NOT start the mill until it is resting back in its recess

Tracking adjustment bolt sitting in recess. It should look like this *before* the mill is started back up.



Ensure the blade support arm is locked into place after tensioning the blade.

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

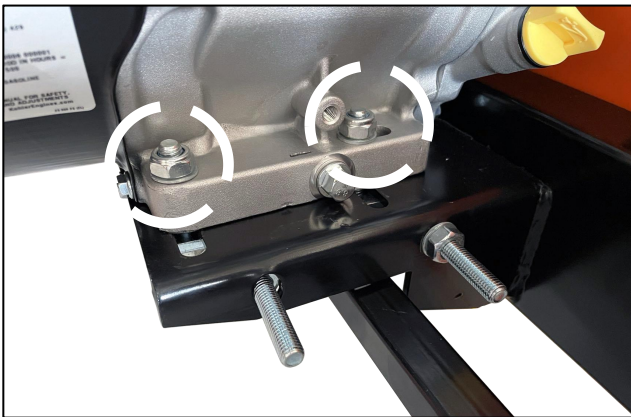
Never attempt the below with the engine running. As a safety precaution, remove the spark plug cap. Gloves and safety glasses must be worn when replacing the belts.



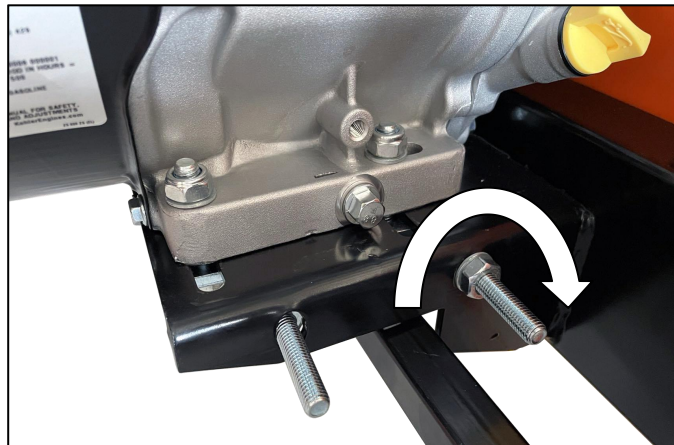
There are two rubber “V” belts on the sawmill and they should be replaced as a set. It is not advised to replace individual belts separately. It is recommended to use a BX2400 Li drive belt for the drive side and a BX473 Li follower belt.



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"> 1. Inadequate blade tension. 2. Improper blade guide set up. 3. Improper blade tracking. 4. Sap build up on blade. 5. Dull blade. 6. Pushing mill too quickly. 	<ol style="list-style-type: none"> 1. Tighten blade. Refer to page 32. 2. Gap between guide blocks and blade are incorrect. Refer to page 31. 3. Adjust blade tracking. Refer to page 27. 4. Install new blade. Refer to page 34. Always use blade lubricant. 5. Install new blade. Refer to page 34. 6. Slow feed rate down and push head slower through log.
Last board is tapered or narrow in middle.	<ol style="list-style-type: none"> 1. Tracks are not level. 	<ol style="list-style-type: none"> 1. Tracks need to be checked with level and adjusted to be square. They also need to be set up on firm, sturdy round/base so deflection does not occur from logs or sawmill head.
Blade dulls quickly.	<ol style="list-style-type: none"> 1. Logs are not clean. 2. Foreign objects in log. 	<ol style="list-style-type: none"> 1. Logs may contain dirt/sand causing them to wear prematurely. 2. Tree may contain nails, staples, old fencing etc.
Blade comes off of bandwheels.	<ol style="list-style-type: none"> 1. Inadequate blade tension. 2. Improper blade guide set up. 3. Improper blade tracking. 4. Belts are worn. 5. Dull blade. 6. Pushing mill too quickly. 	<ol style="list-style-type: none"> 1. Tighten blade. Refer to page 32. 2. Gap between guide blocks and blade are incorrect. Refer to page 31. 3. Adjust blade tracking. Refer to page 27. 4. Install new belts. Refer to page 34. 5. Install new blade. Refer to page 34. 6. Slow feed rate down and push head slower through log.
Blades are breaking.	<ol style="list-style-type: none"> 1. Too many blade sharpening. 2. Inadequate blade tension. 3. Improper blade guide set up. 4. Improper blade tracking. 5. Pushing mill too quickly. 	<ol style="list-style-type: none"> 1. Replace blade. Refer to page 34. 2. Binding between guide blocks when blade is too loose. Tighten blade. Refer to page 33. 3. Gap between guide blocks and blade are incorrect. Refer to page 31. 4. Adjust blade tracking. Refer to page 27. 5. Slow feed rate down and push head slower through log.

Blade is slowing down or stopping when milling.	<ol style="list-style-type: none"> 1. Inadequate blade tension. 2. Improper drive belt tension. 3. Pushing mill too quickly. 	<ol style="list-style-type: none"> 1. Tighten blade. Refer to page 32. 2. Belts are worn or too loose. Replace. Refer to page 35. 3. Slow feed rate down and push head slower through log.
Mill is not cutting/cutting very slowly.	<ol style="list-style-type: none"> 1. Dull blade. 2. Blade is on backwards. 	<ol style="list-style-type: none"> 1. Install new blade. Refer to page 34. 2. Remove blade and flip it inside out. The teeth should be facing in the direction of the log supports.
Mill is vibrating excessively.	<ol style="list-style-type: none"> 1. Log is not clamped securely. 2. Belts are deformed. 3. Bandwheel bearing issue. 4. Pushing mill too quickly. 5. Loose bolts. 	<ol style="list-style-type: none"> 1. Ensure log is clamped firmly resting on log bunks and against log supports. 2. Belts may have flats in them from leaving blade tension tight when not in use. Replace them. Refer to page 34. 3. Inspect and replace the bandwheel bearings if worn. 4. Slow feed rate down when milling. 5. Check all bolts to ensure they are tight.

DIAGRAM--ENSEMBLE

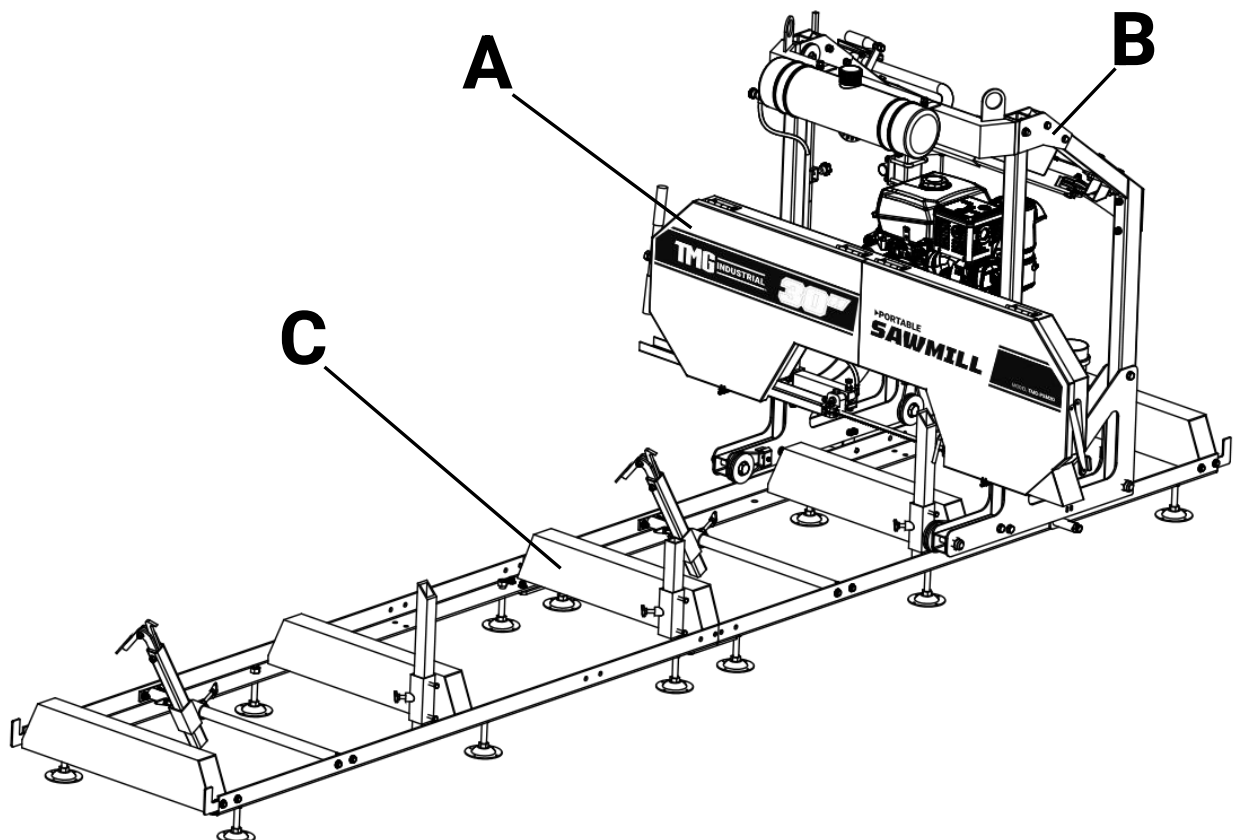
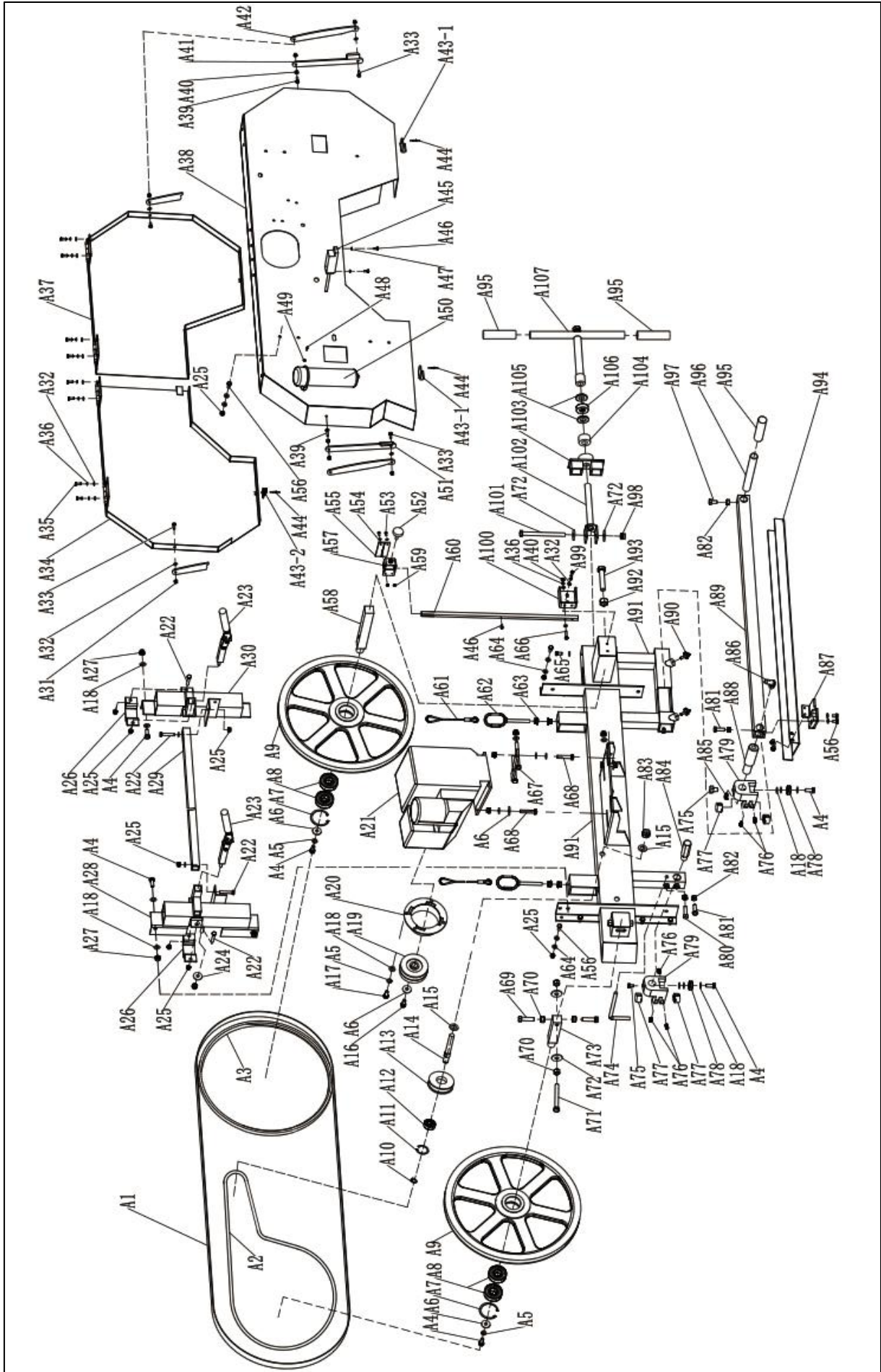


DIAGRAM (A) --BANDWHEEL HOUSING



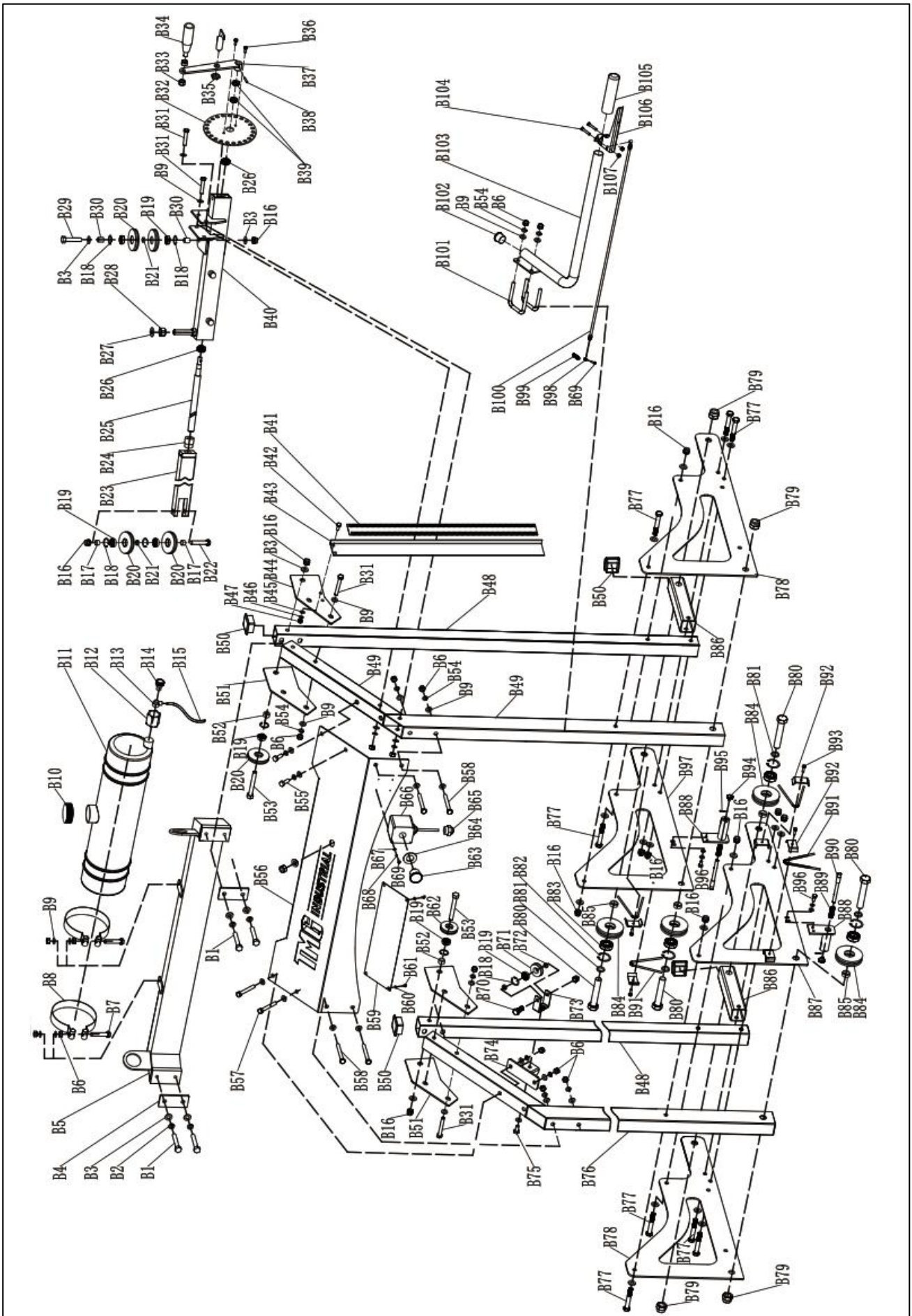
PARTS LIST (A) -- BANDWHEEL HOUSING

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
A1	Saw blade	1	A35	Cross pan head screw M6X16	8
A2	BX2400 Li V- belt	1	A36	spring washer Ø6	12
A3	BX1473 Li V-belt	1	A37	Left cover door welding	1
A4	Hexagon head bolt M10X25	9	A38	Shield body welding	1
A5	Spring washer Ø10	7	A39	Hexagon head bolt M6X20	2
A6	Large side flat pad 10 (Ø10*35*3.0)	5	A40	Hex Nut M6	4
A7	Circlips for holes 62	2	A41	Side pull plate 3	1
A8	Deep groove ball bearing 6305	4	A42	Side pull plate 1	2
A9	Pulley	2	A43	Buckle	2
A10	Shaft circlip 17	1	A44	Blind rivet 4X10	8
A11	Circlips for holes 40	1	A45	Limit switch YBLX	1
A12	Deep groove ball bearing 6203-2RS	1	A46	Cross recessed pan head screw M5X12	3
A13	Tensioner	1	A47	Spring washer Ø5	2
A14	tensioner shaft	1	A48	Blind rivets 4X16	3
A15	Flat washer Ø16	1	A49	Large flat pad 4	3
A16	US 3/8X24X25	1	A50	Instruction manual	1
A17	US 3/8X16X25	4	A51	Side pull plate 2	1
A18	Flat washer Ø10	22	A52	M8X40 flower handle	1
A19	Clutch	1	A53	Cross recessed pan head screw M4X12	2
A20	Clutch guard welding	1	A54	Flat washer Ø4	2
A21	Engine	1	A55	Scale plate	1
A22	Hexagon head bolt M8X40	4	A56	Hexagon head bolt M8X20	11
A23	Quick lock	2	A57	Scale holder	1
A24	Large washer Ø10	5	A58	Passive saw wheel shaft	1
A25	Non-metallic insert hex lock nut M8	16	A59	Hex nut M4	2
A26	Locking plate weldment	2	A60	Height Indicator Rod	1
A27	Non-metallic insert hex lock nut M10	11	A61	lifting wire	2
A28	Right lift lock welding	1	A62	Lifting rings	2
A29	Tube	2	A63	Hexagon flange face nuts M10	4
A30	Left lift lock welding	1	A64	Flat washer ç8	17
A31	Non-metallic insert hex lock nut M6	8	A65	Hexagon head bolt M8X16	1
A32	Flat washer Ø6	18	A66	Hexagon head bolt M6X25	2
A33	Hexagon head bolt M6X16	6	A67	Tension plate	1
A34	Right cover door welding	1	A68	Hexagon head bolt M10X50	4

PARTS LIST (A) -- BANDWHEEL HOUSING (CONT)

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
A69	Hexagon head bolt M12X45	2	A89	Guide square tube	1
A70	Hex Nut M12	4	A90	Triangle handle M10X40X30	2
A71	Hexagon head bolts full thread M12X100	1	A91	Beam welding	1
A72	Large washer 12 (Ø12*35*3.0)	4	A92	Hex Nut M16	1
A73	Active saw wheel shaft	1	A93	Hexagon head bolt M16X80	1
A74	Saw hook	1	A94	Saw guard plate 2	1
A75	Hexagon head bolt M10X12	2	A95	25 tube rubber handle	3
A76	Hexagon socket head set screw M6X12	12	A96	Push handle	1
A77	Saw block for aluminum seat	4	A97	Hexagon bolt M10 x 20	1
A78	Deep groove ball bearing 6200-2RS	2	A98	Non-metallic insert hex lock nut M12	1
A79	Aluminum saw chuck shaft seat	2	A99	Hexagon socket head cap screws M6X14	2
A80	Hexagon bolt M10 x 35	1	A100	scale seat	1
A81	Hexagon head bolt M10X30	2	A101	Hexagon bolt M12X150 half wire	1
A82	Hex Nut M10	5	A102	Tension rod welding	1
A83	Non-metallic insert hex lock nut M16	1	A103	Tension seat welding	1
A84	The right saw shaft	1	A104	Cushion	1
A85	One M6 90 degree oil cup	1	A105	Tension gasket (Ø21*38*4.5)	2
A86	1/4 elbow external connection	1	A106	Thrust ball bearing for automobile steering knuckle 51204	1
A87	Saw guard plate 1 welding	1	A107	Tension handle welding	1
A88	Left saw chuck shaft	1			

PARTS LIST (B) --CARRIAGE



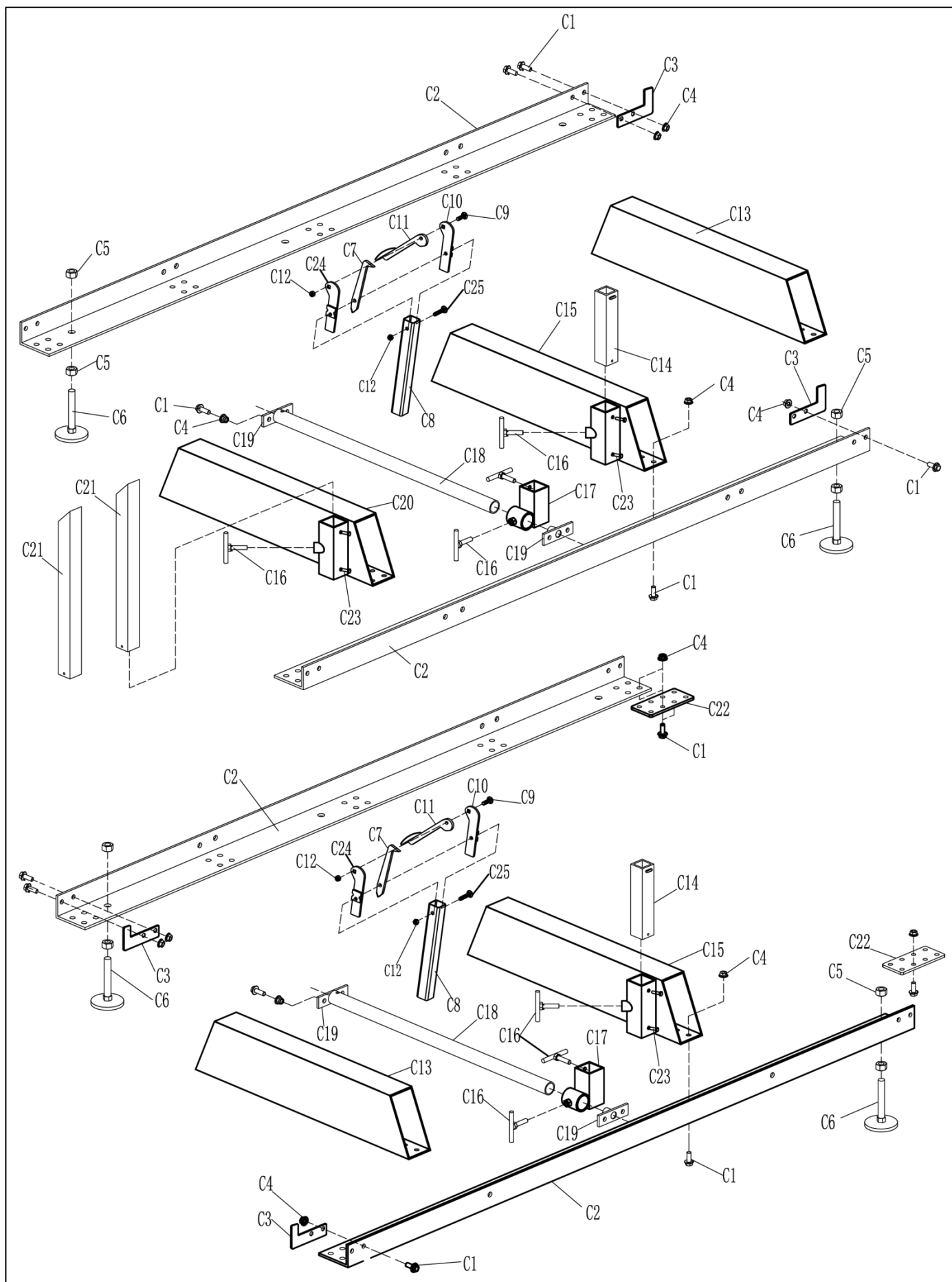
PARTS LIST (B) --CARRIAGE

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
B1	Hexagon head bolt M12X75 half wire	4	B34	13 hole handle	1
B2	Spring washer Ø12	4	B35	Knob plunger assembly	1
B3	Flat washer Ø12	24	B36	Hexagon head bolt M6X16	2
B4	Clamping plate	2	B37	Rocker welding	1
B5	Upper beam welding	1	B38	Elastic cylindrical pin 5X24	1
B6	Hex Nut M10	20	B39	Round nut M14X1.5	2
B7	Hexagon head bolt M10X105	2	B40	Expansion tube 2 welding	1
B8	Water Tank Rack	2	B41	Height Ruler	1
B9	Flat washer Ø10	35	B42	Hexagon head bolt M8X20	2
B10	Water tank cover	1	B43	Ruler base	1
B11	Water tank	1	B44	Connecting plate 3	1
B12	Water Tank Connector	1	B45	Flat washer Ø8	6
B13	Quick connect CSL8-04	1	B46	Spring washer Ø8	6
B14	Throttle valve	1	B47	Hex Nut M8	2
B15	PU high pressure air pipe 8*5 transparent-1.8 m	1	B48	Lifting Square Tube	2
B16	Non-metallic insert hex lock nut M12	13	B49	Left Bottom Wheel Frame Welding	1
B17	Spacer 1	2	B50	50*50 square pipe plug	6
B18	Circlips for holes 28	7	B51	Connecting plate 1	3
B19	Deep groove ball bearing 6001RS	7	B52	Lifting Wheel Cover	2
B20	Lifting wheel	5	B53	Hexagon head bolt M12X95 half wire	2
B21	Spacer 2	2	B54	Spring washer Ø10	18
B22	Hexagon head bolt M12X65 half wire	1	B55	Hexagon head bolt M10 x 30	2
B23	Telescopic Tube 1 Welding	1	B56	Upper dome cover	1
B24	Copper nut	1	B57	Hexagon head bolt M10X75 half wire	2
B25	Lifting Screw	1	B58	Hexagon head bolt M10X90 half wire	4
B26	Thrust ball bearing 51102	2	B59	Trademark bezel	1
B27	Flat washer Ø16	2	B60	Spring pad 5	6
B28	Hex Nut M16	2	B61	Cross recessed pan head screw M5X8	6
B29	Hexagon head bolt M12X85 half wire	1	B62	Right Lifting Wheel	1
B30	Reversing wheel set	2	B63	Mushroom head emergency stop button	1
B31	Hexagon head bolt M10X80 half wire	6	B64	Emergency stop sign	1
B32	Dial	1	B65	Can't take off M20	1
B33	Hex Nut M12	2	B66	Button box CA-BX1 one hole	1

PARTS LIST (B) --CARRIAGE (CONT)

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
B67	Flat washer Ø4	4	B88	Limit welding	2
B68	Spring washer Ø4	4	B89	Small Compression Spring	2
B69	Cross recessed pan head screw M4X12	5	B90	Limit shaft	2
B70	Hexagon head bolt M12X30	1	B91	Wire rope brush	4
B71	7001-230040 Pulley 2	1	B92	Splint 2	4
B72	7001-240030 Spacer 1	2	B93	Hexagon head bolt M6X20	4
B73	7001-230010 Pulley frame welding	1	B94	Small round handle M5	2
B74	Pulley frame seat	1	B95	Split elastic pin 2.5X16	2
B75	Hexagon head bolt M10 x 20	1	B96	Hexagon head bolt M8X16	4
B76	Right Bottom Wheel Frame Welding	1	B97	Left reinforcement plate welding	1
B77	Hexagon head bolt M12X80 half wire	8	B98	Wire clip	1
B78	Outer reinforcement plate	2	B99	Tension spring (engine)	1
B79	Non-Metallic Insert Hex Lock Nut M20	4	B100	Throttle Cable	1
B80	Hexagon head bolt M20X110 half wire	4	B101	U-bolt	2
B81	Bottom wheel spacer 1	4	B102	33 round pipe plug	1
B82	Circlip for hole 42	4	B103	Push handle welding	1
B83	Deep groove ball bearing 6004	4	B104	Hexagon socket head cap screws M6X35	2
B84	Bottom wheel	4	B105	Grip cover Ø32	1
B85	Bottom wheel spacer 2	4	B106	Throttle handle	1
B86	Bottom wheel frame gasket	2	B107	Hex Nut M6	2
B87	Right reinforcement plate welding	1			

DIAGRAM (C) --GUIDE RAIL



PARTS LIST (C) -- GUIDE RAIL

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
C1	Hexagon flange bolts M10*30	48	C14	Log support	2
C2	Guide rail	4	C15	Two-hole guide rail beam welding	2
C3	Limit plate	4	C16	T-screw M10*40	7
C4	Hexagon flange self-locking nuts M10	48	C17	Log clamp receiver	2
C5	Hex nut M16	24	C18	Slide tube	2
C6	Leveling Feet M16	12	C19	Sliding socket welding	4
C7	Hook	2	C20	Four-hole rail beam welding	1
C8	Telescopic tube welding	2	C21	Log support	2
C9	Hexagon socket head screw M10X35	2	C22	Rail connecting plate	2
C10	Telescopic left plate welding	2	C23	Hex Bolts M8*30	6
C11	Eccentric compression welding	2	C24	Telescopic right plate welding	2
C12	Hexagon lock nut M10	4	C25	Half round head square neck bolt M10x35	2
C13	Two-hole guide rail beam (not welded)	2			