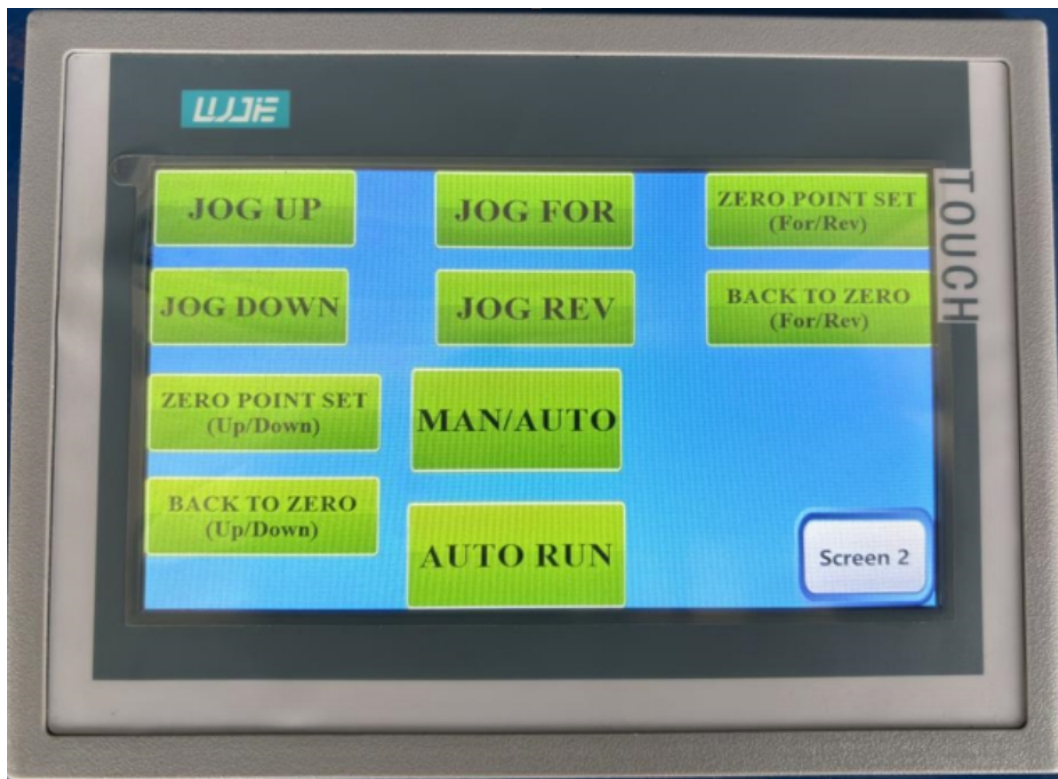




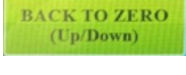
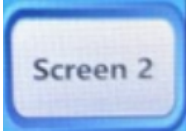
Sawing Kit Saw Mill's Operators Manual





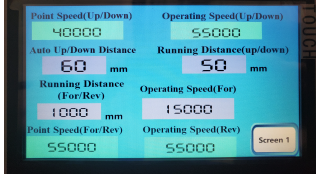
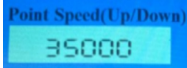
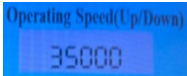
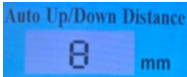
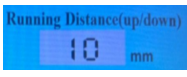
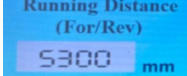
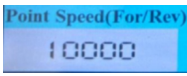
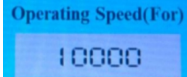
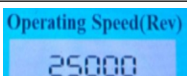
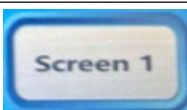
The screen and what it means what you see.

Screen 1 /Operating the machine

	JOG UP: Long press, the saw head will go up, until button is released.
	JOG DOWN: Long press, the saw head will go down, until button is released.
	ZERO POINT SET Up/Down: Set the zero point from where the saw head starts in AUTO mode.
	BACK TO ZERO (Up/Down): Push once the saw head will go back to the zero point position.
	JOG FOR: Long press, the Saw head will move forward, until button is released.
	JOG REV: Long press, the Saw head will move backward, until button is released.
	BACK TO ZERO (For/Rev): The Sawmill head will go back to the starting position, CAUTION: the machine will go back or forward without raising the saw head on her own.
 	MAN/AUTO: Manual / Automatic Switch Button. This will switch to Automatic function. The Screen will show now AUTO . AUTO: This will change to manual mode and show now MAN/AUTO
	AUTO RUN: In automatic mode it will begin the Automatic cutting work according to customer's settings.
	Screen 2: This will switch the screen to screen 2.



Screen 1 / Parameter Settings

	
	Point Speed (Up/Down): Speed of Up and Down movement of the saw head.
	Operating Speed (Up/Down): Speed of Automatic up and down operation.
	Auto Up/Down Distance: The height that the saw head rises after cutting the wood, in AUTO mode.
	Running Distance (Up/Down): Cutting thickness in Millimeter (this is the distance to saw head will move down from the zero point at first start).
	Running Distance (For/Rev): Cutting length in Millimeter, the distance the saw head will travel forward while cutting.
	Point Speed (For/Rev): Forward and backward speed in manual mode.
	Operating Speed (For): Forward Speed for cutting in automatic mode.
	Operating Speed (Rev): Backward Speed for cutting in automatic mode.
	Screen 1: This will switch the screen to screen 1.



Important Information to understand how the machine will work.

Running speed. Manual Mode and Automatic Mode.

The **Point Speed** or **Operating Speed** is the pulse quantity of the pulse motor. Those numbers do not represent a value in any length measurement. Those number do not represent any number in Millimeter or Inch.

For **Point Speed (Up/Down)** you can use any number higher than zero but not higher than 40000.

For **Operating Speed (Up/Down)** you can use any number higher than zero but not higher than 55000.

For **Point Speed (For/Rev)** you can use any number higher than zero but not higher than 55000.

For **Operating Speed (Rev)** you can use any number higher than zero but not higher than 55000.

As I mentioned those numbers do not represent any number in Millimeter or Inch. The maximum number is 55000.

Look at it as it was percent. 40000 = 100% speed.

40000 = 100%

30000 = 75%

20000 = 50%

10000 = 25%

55000 = 100%

41250 = 75%

27500 = 50%

13750 = 25%



Distance, length of the cut.

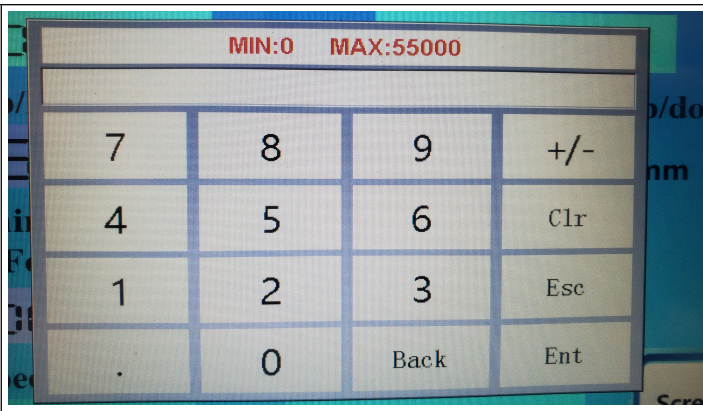
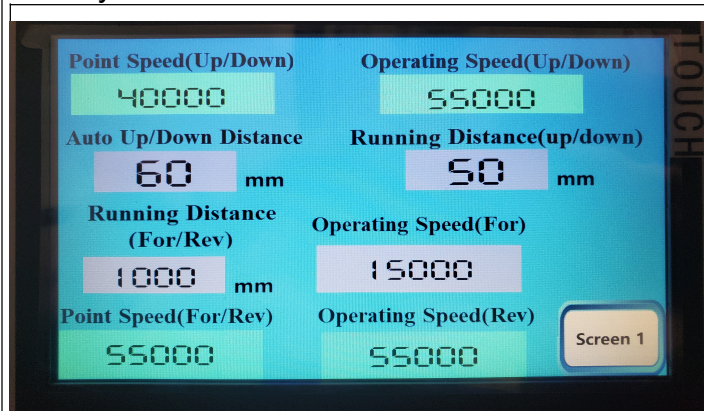
For the values of the distance it is in Millimeter.

1 inch is equal to 25.4 millimeters: 1" = 25.4mm 1ft = 304.8mm

You can not insert decimal places. You have to round up or down.

1 "	25.4 mm	1/16 "	1.587500 mm
2 "	50.8 mm	1/8 "	3.175 mm
3 "	76.2 mm	1/4 "	6.35 mm
4 "	101.6 mm	1/2 "	12.7 mm
5 "	127.0 mm		
6 "	152.4 mm		
7 "	177.8 mm	8ft	2438 mm
8 "	203.2 mm	10ft	3048 mm
9 "	228.6 mm	12ft	3657 mm
10 "	254.0 mm	14ft	4267 mm

To change the parameter tip on the field with a number. A screen will appear and there you can insert your desired number.



Press Enter to go back to the setup screen.

Press Esc to go back without changes.

Press Clr to delete what you have entered.



Operation of the machine.

It is best to “dry run” first. Means no log on the machine. (see sample next page)

Set your manual cutting speed. **Point Speed (For/Rev)**

Enter your speed for your automatic cut. **Operating Speed (For)**

Drive the saw head in manual mode to the position where you want your first cut to cut the bark of. Keep the saw blade 2 Inches away from the wood.

Press **ZERO POINT SET” (Up/Down)**

Press **ZERO POINT SET” (For/Rev)**

That is now the Zero Point / the reference point of the machine where the start position is.

Press and hold **JOG FOR**

The saw will move forward in manual mode and doing the first cut.

After your cut is done and the blade is out of the wood:

Press **Jog Up**

The saw head will go up. Press until your blade is clear to move back to start position.

Now Press **BACK TO ZERO (For/Rev)**

The saw head will drive back to the zero point at the beginning of the log.

Now Press **BACK TO ZERO (Up/Down)**

The saw head will go down to the zero point you have set before your first cut.

The blade now sits at the same spot where you started to cut the bark of.

Press **AUTO**

The machine will switch to Automatic Mode.



The machine now has switched to Automatic Mode.

You can stop the machine any time by press the **AUTO button. But this will not stop the blade.**

Press **AUTO RUN**

The machine will start working.

First the saw head will go down the number your entered in “Running Distance (Up/Down)”.

Then the saw head will move forward cutting the wood for the distance you entered in “Running Distance (For/Rev)”.

After that the saw head will move up the distance you entered in “Auto Up/Down Distance”.

The saw head should now stay above the log and clear to move back.

The saw head will move back.

If this position at the start of the log is reached the saw head will got down to the last cutting hight position where you just did a cut and will stop.

If you press the “AUTO RUN” button again that process will start again.

The saw head will go down again the distance you had entered in “Running Distance (Up/Down)” and start going forward doing the next cut.

Every time you press the “AUTO RUN” button the machine will do the same again.

You can stop the machine any time by press the **AUTO button. But this will not stop the blade.**



These numbers are a sample for the numbers to run a 14 feet long log.
The forward speed should fit spruce.

Point Speed(Up/Down): The speed for the saw head up and down in manual mode is set to 40000.

Operating Speed(Up/Down): The speed for the saw head up and down in automatic mode is set to 55000.

Auto Up/Down Distance: Lifting up the blade after the cut is set to 60 mm / 2.6 Inch

Running Distance(up/down): The thickness of the cut is set to 50 mm / 1.96 Inch

Running Distance(For/Rev): The length of the cut is set to 4300 mm / 14.10 Feet

Operating Speed (For): The speed for automatic cut is set to: 18000

Point Speed (For/Rev): The speed to cut the bark of is set to: 18000

Operating Speed(Rev): The speed for the head to drive back to zero position is set to 55000.

