

⚠ WARNING

There is risk of serious injury or death to machine operators and bystanders from "Chain shot", which is a high-speed ejection of chain parts that can occur in the event of a broken chain caused by incorrect chain repair or by poor chain maintenance.

If the saw chain jams, loose chain links may be flung around with a lot of force, causing serious personal injury. It is absolutely forbidden for anyone to stand in front of or behind the saw unit (in the longitudinal direction of the saw bar) during operation.

If a chain comes off the saw bar, check the chain carefully for fractures, bent teeth etc.

Make sure that the saw bar returns immediately after you have seen all the way across the log. Seeing excessive cross-cutting distances at one go should be avoided. If the saw bar proceeds too far, the saw chain may come off the bar. For more details see the control system instructions for how to adjust the sawing depth.

Grease new saw bars and saw chains before putting them in use.

Discard saw chains with fractures in the sliding surfaces of the side links and cutter links (in the direction of the run).

Lubrication

Chain bar sprocket system must receive enough oil, and the oil must stay in the chain, bar, and sprocket long enough to prevent excessive wear.

A practice of some machinery has been to bleed hydraulic fluid for the purpose of lubricating the saw bar and saw chain. Hydraulic fluid is not adequate for bar/chain lubrication. A separate over sitting high quality bar/chain lubricant is required.

Adequate time must be allowed for lubricant to reach the chain at start up. Cold weather or a new bar will add to this time. Run the chain slowly for several minutes. Under these extreme conditions, increase saw speed gradually over the first few minutes of running time.

Install a fine wire mesh filter into the oil tank opening to help eliminate debris that may enter the oil tank and oil of system.

CHAIN TENSIONING

If the saw chain is too tight, it will wear faster, be noisy, and may break. If the chain is too loose, it may come off the bar. Chain should be correctly tensioned. The groove and the chain may also come off the saw bar and "shoot" on top of the chain bar.

As a rule, chain should be tight enough so that cutter bottoms are pulled firmly against the saw bar at all points around the perimeter of the saw bar. Correctly tensioned, it should still be possible to pull the chain with thumb and forefinger grip, at mid span, away from the bar rails. Cutters should come off the rails roughly 1/8 inch, under the tug of finger pressure. Tension should be checked periodically. Because it expands with heat, chain that is uncomfortably hot to touch should be allowed to cool before re-tensioning. As part of your routine shut down procedure at the end of



each shift, release chain tension to prevent damage to the chain links and contacts.

⚠ WARNING

Always turn off the diesel engine before touching the saw unit. Danger of cuts!

BLEED CHAIN TENSIONING SYSTEM

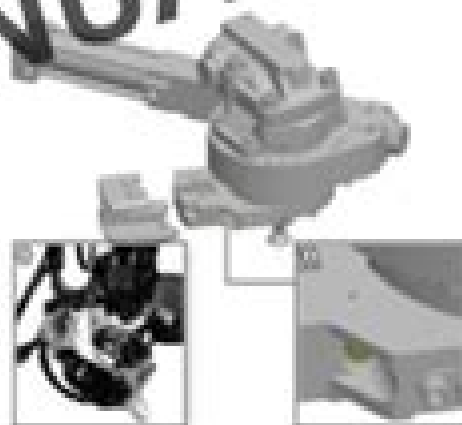
NOTE: Always bleed the system after the main pressure hose is replaced and also if there is any reason to suspect that air has got into the system.

1. Remove the saw chain and leave the saw bar attached.
2. Pump it up and check that the fluid is standing on a firm surface.
3. Lean the saw bar far backwards so that the bleed valve is higher than the rest of the system.
4. Keep the bar/chain running and open the bleed valve 1/2 - 1 turn. (In the case of a 1/2 inch bleed valve 1/2 turn).
5. After all air is expelled, turn the bleed valve shut.

NOTE: The hydraulic line is long and may be fully bled.

6. Turn off the machine and let the chain sit for 10 min.

NOTE: The pressure gauge should be checked above to verify the bleeding.

**SAW BAR**

Saw bar maintenance and the related adjustments largely determine the extent of the saw bar life. This is why the following instructions require undivided attention.

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