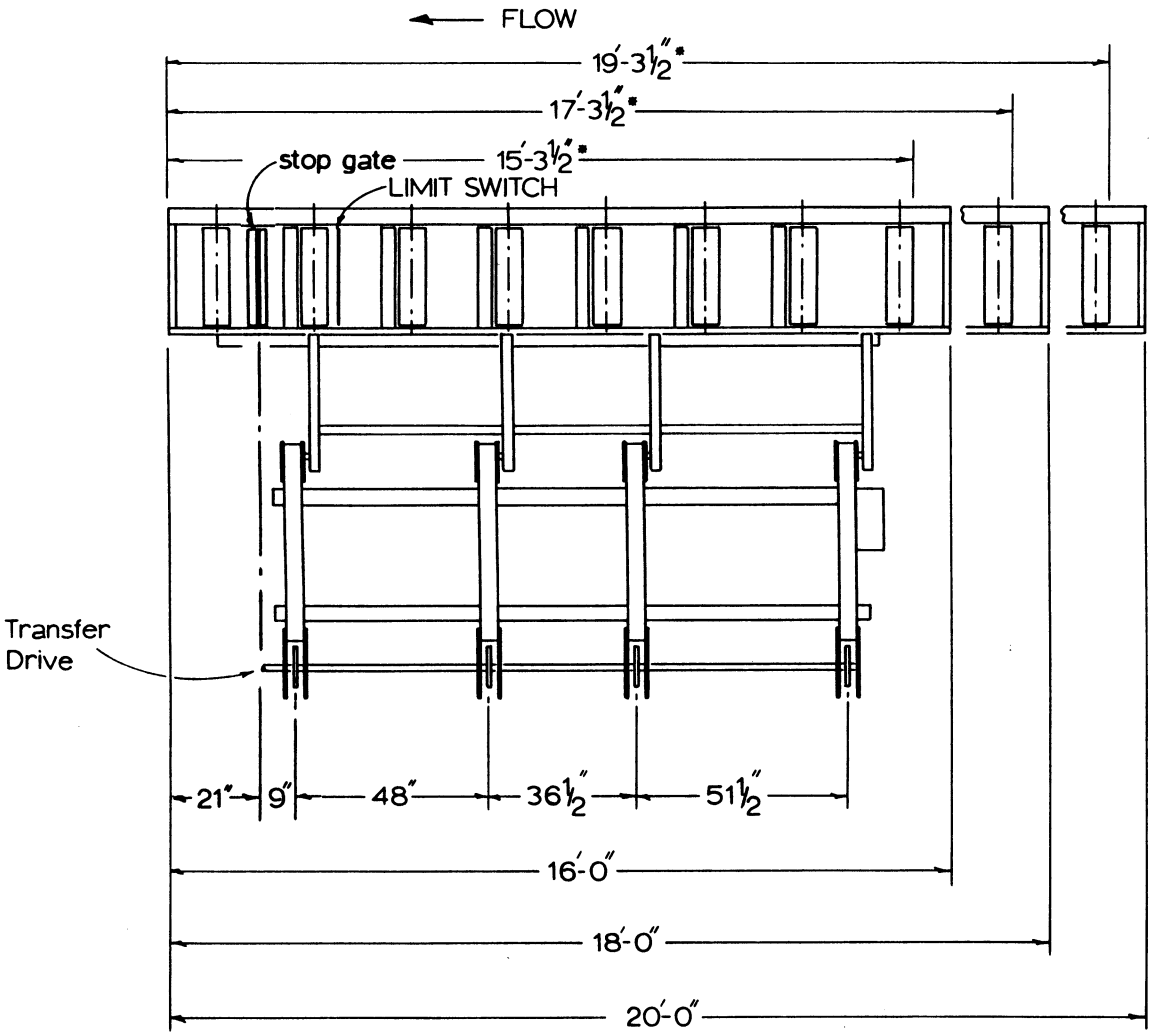

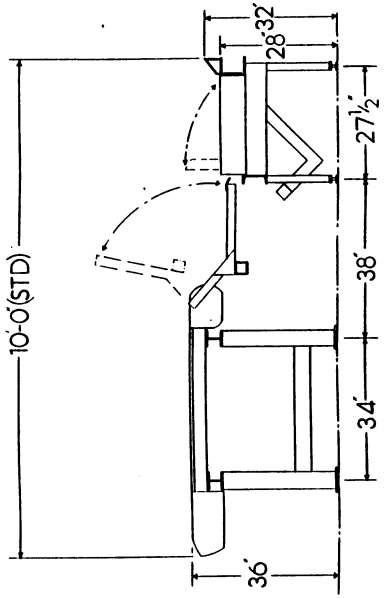

* Length of roll case when located downstream from belted section with drop out space or drop belt.

____ LENGTH OF ROLL CASE
____ RIGHT or LEFT HAND MILL (RH shown)
____ DISTANCE SAWLINE TO EDGER
STOPS:
____ LIVE optional
____ FIXED
____ NONE
____ DEFLECTOR optional
____ ELECTRIC LIVE ROLL DRIVE optional
CONTROL:
____ . SCR std. on dual purpose units.
____ . ON OFF SWITCH std. on slab k.o. units

MELLOTT MFG. CO., INC.

SCALE: ¼" = 1'-0" | APPROVED BY | DRAWN BY JLP

DATE:

Dual Purpose K.O. & Transfer Installation

DRAWING NUMBER

Rev. 1988

DUAL PURPOSE K.O. & TRANSFER INSTALLATION INSTRUCTIONS

INSTALLATION

Position roll case section in line with adjacent rolls or next to husk so that the stop gate will index material going to the edger at the planned index line.

Foot pads can be adjusted for correct roll height. Roll case can be lagged to floor when all adjustments have been made.

Remove shipping ties from control wiring and hoses. Route control cable with foot switch to sawyers or operators station. Position foot switch in convenient location for operator. If unit is equipped with an optional pushbutton enclosure, rather than standard foot switch, mount the enclosure in a convenient location for the operator. Route air lines for air stops to approximate location (Do not remove any tags until proper connections are made.)

Set transfer in place and secure to floor. (See other side for dimensions.) Install 81X chains on skids. Install the cylinders for the transfer arms.

Qualified electrician should make electrical connections. Electric motors on roll drive (optional) and transfer drive must be wired. (Mellott Mfg. Co., Inc. does not provide starters for these motors, local electrician should make proper connections.)

Wiring to relay enclosure must be connected to 120 volt AC source and fused to 10 amps.

Connect air inlet of F-R-L to air supply. Air pressure should be set at 100 PSI with the regulator. Fill lubricator bowl with 10 Wt. non-detergent oil. Set lubrication so that one bowl of oil is dispensed within a two week interval.

LIVE STOPS - INSTALLATION (OPTIONAL)

Install air cylinder for live stops. Connect hoses from foot operated air valve to live stop cylinder and to filter-regulator-lubricator under rolls. (Hoses are tagged at factory as to proper cylinder port connection.) Foot valve should be secured to floor in a position that edger operator can control live stops.

DRIVE MAINTENANCE

Roller chains from drive to headshaft should be lubricated daily. For gearbox maintenance see manufacturer instructions.

CONTROL ADJUSTMENT

All valves and timing controls are operated and pre-set at factory. Local conditions, sawing space and other factors may necessitate minor control adjustments. Unit should be operated for a shift so that personnel can become familiar with its characteristics before any adjustments are made.

The timing relays, located in the enclosure, controls the time the kickoff arms and transfer arms remain in the up position. Increasing the time of the timing relays will cause the arms to remain in the up position longer and decreasing the time will cause the arms to remain in the up position for a shorter period of time.

The speed at which the arms move up and down is controlled by exhaust restrictors located in the solenoid air valve connected to the air cylinders of the arms. The restrictors control the exhaust air for each end of the air cylinders. Turning the restrictor in (by a screw driver) will slow the speed, while backing the restrictor out will increase the speed. The speed should not be so great that the arms hit the end of their cycle with great force.

OPERATION

> CAUTION: NEVER PERMIT PERSONNEL TO STAND NEAR UNIT WHILE IN OPERATION. NEVER PERMIT PERSONNEL TO WALK ON ROLL CASE OR TO REACH ACROSS ROLLS OR TRANSFER WITHOUT SHUTTING OFF POWER TO DRIVE & CONTROL.

Start electric motors for roll case and transfer drives. Be sure air system is operational.

The unit is equipped with a pushbutton station.

When the edger button is pushed the stop gate will raise. When material contacts the butterfly the kickoff arms will operate by pushing the material onto the transfer arms. The transfer arms will raise sliding the material onto the transfer chains. While the kickoff arms are returning to the down position. The transfer arms and stop gate will return to the down position.

When the slab button is pushed the stop gate and transfer arms will raise. When the material contacts the butterfly the kickoff arms will operate pushing the material off the rollcase. The arms and gate will then return to the down position.

To operate the unit without the material contacting the butterfly, push the button for the appropriate cycle(edger or slab)then push the manual button when the material is located correctly on the rollcase.

The clear button can be pushed to cancel any of the other buttons that were pushed.

Operation of live stops is accomplished by the edger man. Live stops are in the "up" position which will stop material on transfer chains from moving over sprockets and onto edger table. Depress pedal of foot valve to lower live stop arms to allow board to move over sprockets to edger table. Release pedal and live stop arms will move to "up" position.