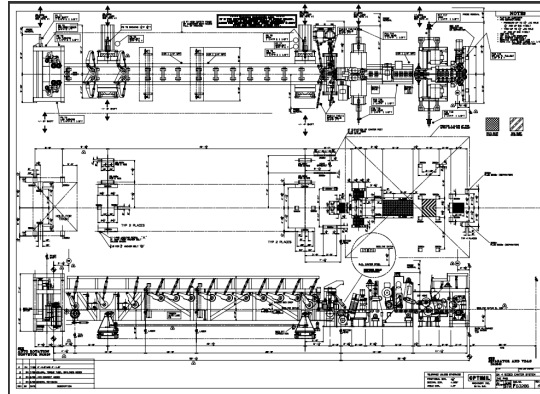


# BEAVER SALES

## SKENA SAWMILLS OPTIMIL LINE



**GENERAL DESCRIPTION**  
**SERIAL# 63286 Optimil Line**

<b><u>ITEM</u></b>	<b><u>DESCRIPTION</u></b>	<b><u>WO#NUMBERS</u></b>
05	Log Infeed Conveyor	64588
10	Auto Rotation Conveyor	63320
20	Log Turner – Quad, 4 segment	63321
30	Infeed – Skewing/Tilt	63322
40	Free Standing Frame	64385
50	Bottom head	63323
60	Side Heads	63324
70	Feed Module	63325
80	Top Head	63326
81	Infeed HQAE	63326
90	HQAE	63328
100	Spline Remover/Feed	63329
110	Separator	63330
120	Infeed VDAG	63331
130	10” VDAG	63332
140	HPU	64384
150	Cab	63334
160	PLC/Scanner	63333

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## GENERAL SPECIFICATIONS

**Log:** Diameter Min: 3" Top Max: 14" Butt ( 16" envelope)

Average Dia: Length 8' - 0" to 20' - 6' Average 15'-9"

**Cant sizes:** min width sawn = 3.875" min width chipped = 2.850" max width before saws = 14" nom max width after saws = 10" nom min height = 2.820" max height = 14" nom

**Chip Length:** 1" @ 358 Fpm

**Lumber size:** 2" = 1.680" for both horiz and vert

**Feed Speed:** max: 450 Fpm min: 200 Fpm base: 358 Fpm @ 60 hz.

**Service Side:** Left hand side

## SPECIAL NOTES:

**HYDRAULIC:** · Cylinders - Optimil · Vickers - directional · hose, CAT XT3 · "Multi Point" connections · Ball valves: **None** ● See GA for connection locations

**PNEUMATIC:** · Cylinders - Optimil · Valves: Mac 6500 · 2 wire · FLR by customer · Regulators = Wilkerson · See GA for connection locations

**REDUCERS:** · Rex (Mars 14.06:1)

**BEARINGS:** · Optimil standard, orient greast ftg. For access.

**COUPLINGS:** · QM on Log turner

**PAINT:** · VK Blue

**FASTENERS:** · Optimil standard · Necessary jigs, fixtures, tools

**GUARDS:** · "No wrench guards"

## ELECTRICAL NOTES:

Control, Scanning, Encoders and Photocells by: Optimil Type: Tri-Cams

Photocells: Banner maxi-beam, Telco in canter guide bar, and in VDAG guide bar, Banner SM 30 in Canter and HQAE only VFD by: others Control voltage 110/1/60

<u>LINEAR POSITIONERS:</u>	<u>DIAMETER</u>	<u>STROKE</u>	<u>GPM</u>
· Log Turning	2 @ 3 1/4"	36"	40
· L.T. Pre-Position:	1 @ 2 1/2"	12"	20
· Log Turner Side Shift	1 @ 4"	12"	40
· Infeed Tail end skew 1 @ 4"		**18"	40
· Infeed Head end skew	1 @ 4"	**12"	40
· Infeed Lift	1 @ 4"	12"	40
· Spike Rolls	4 @ 2-1/2"	6"	20
· Side Heads	2 @ 3-1/4"	24"	40
· Top Head	1 @ 4"	24"	40
· HQAE	2 @ 3-1/4"	30"	40

Servo brand: Bosch Linear cyl brand: Optimil Machinery Inc. Probes and cables by: Optimil Machinery Inc. Optimil HP filter \*\*Infeed tail skew actual travel is 12" Infeed head skew actual travel is 8"

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**MOTOR LIST**

<i>LOCATION</i>	<i>HP</i>	<i>BY</i>	<i>FRAM</i> <i>E</i>	<i>QTY</i>	<i>HAND</i>	<i>REV.</i>	<i>MISC</i>
<b>LOG CONVEYOR</b>	<b>20</b>	<b>OPT</b>	<b>256TC</b>	<b>1</b>	-	<b>YES</b>	
AUTO ROTATION CONVEY	30	CUST	286T	1	F2	YES	
LOG TURNER	7.5	OPT	213T	1	F1	YES	
LOG TURNER	7.5	OPT	213T	1	F2	YES	
INFEED BED CHAIN	40	CUST	324T	1	F2	YES	
SPIKE ROLLS	5	OPT	184TC	4	-	YES	
BOTTOM HEAD	200	CUST	447T	1	F1	NO	
SIDE HEADS	200	CUST	447T	1	F1	NO	
SIDE HEADS	200	CUST	447T	1	F2	NO	
S/H VERT.FEEDROLL	7.5	OPT	213TC	2	-	YES	
FEED MOD. P/ROLL	7.5	OPT	213TC	1	-	YES	
FEED MOD. F/ROLL	7.5	OPT	213TC	1	-	YES	
TOP HEAD	250	CUST	505UZ	1	F1	NO	
TOP HEAD P/ROLL	7.5	OPT	213TC	1	-	YES	
TOP HEAD BED	10	OPT	215TC	1	-	YES	
HQAE INFEED P/ROLLS	10	OPT	215TC	1	-	YES	
HQAE ARBOR	200	CUST	447T	2	F1	NO	
HQAE ARBOR	200	CUST	447T	2	F2	NO	
OUTFEED PRESSROLL	10	OPT	215TC	1	-	YES	
OUTFEED BEDBROLL	10	OPT	215TC	1	-	YES	
O/F VERT. ROLLS	7.5	OPT	213T	1	F1	YES	
O/F VERT. ROLLS	7.5	OPT	213T	1	F2	YES	
SPLINE REMOVER	30	CUST	286T	1	F1	NO	
SEPARATOR OUTFEED	15	OPT	254TC	1	-	YES	
VDAE INFEED BELT	10	OPT	215TC	1	-	YES	
<b>VDAE Infeed Press roll</b>	<b>5</b>	<b>OPT</b>	<b>184TC</b>	<b>1</b>	-	<b>YES</b>	
VDAE ARBOR	350	CUST	5010UZ	1	F1	NO	
VDAE ARBOR	350	CUST	5010UZ	1	F2	NO	
VDAE FEED	7.5	OPT	213TC	16	-	YES	
NETWORKS HPU:							
-networks	75	CUST	365TC	2	-	NO	
-recirc.	3	OPT	182TC	1	-	NO	
-cooler fan	1/4	OPT	-	2	-	NO	120/220

- 1800 x 480/3/60 unless noted otherwise
- AC motors
  - 20HP & less by Optimil, Toshiba EQP-3
  - 30HP & larger by customer, Toshiba EQP-3
  - Max lengths - Side Heads 52 1/2" O/A (with 8 1/2" shaft)
  - HQAE 56" O/A (with 8 1/2" shaft)
  - VFD on canter heads (open loop)

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## **ITEM 05 LOG INFEED CONVEYOR**

- side load on RHS
- Rex 3" chain, Vee flight, same chain as ARC
- Frame mounted drive, 5V belts, Earth reducer
- 1" spacer plates as per ARC
- single piece, drop in assembly (not a bag of parts)
- ARC head and tail shaft assys
- 8 tooth prox wheel B51429
- switch #57413
- autolube as per ARC

## **ITEM 10 AUTO ROTATION CONVEYOR (ARC)**

- skewing
- safety hoops
- 1 scanner, = tricams
- scanner frame, shrouding (c/w 24 " upstream tunnel), and misc parts by Optimil
- keep shroud height to a minimum (sight lines)
- special shroud doors, see GA
- see optical layout dwg #B64319 Rev \_\_\_\_
- fit shrouds in assy
- 3" P chain, side guided non m/c sides, 15" flight pitch
- elevation of chain relative to datum, see GA, 1" shim plates by Optimil
- 30 HP drive, earth reducer
  - chain drive mounted on frame, beefed up brg support, roller bags on head shaft
- Trabon auto lube c/w cycle switch
- Updated Chain tensioner air circuit
- End load
- Encoder info:
  - Opt - 8T prox wheel #B51429
  - prox switch #57413
  - Nanoose encoder #63542
  -
- skewing style:
- movement slaved to log turner by a pivot pin
- pivot at tail end
- center support

## **ITEM 20 QUAD LOG TURNER**

- Pivot with flow, floor mounted, vee skid plate
- 7.5. HP electric drive, roller chain drive
- 4 roll x 4 segment

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- 1 pre positioner cylinder, c/w x-link
- 3-1/4 dia turning cylinder
- skid plate
- pin in lieu of ARC skew cylinder
- auto lube, horiz and vert slides

### **ITEM 30 DOUBLE LENGTH INFEED (SKEWING)**

- standard lift, 1 cylinder
- 2 scanners, type = tricams
- scanner frame, shrouding(c/w 20" upstream panels), by: Optimil
- fit shrouds in assy
- see dwg # D64318 Rev \_\_\_ for optical layout
- frame splice: new position away from center span
- driven hourglass roll ahead of tail sprocket, skid plate before hourglass roll
- 3" pitch chain, c/w vee / flat, std chain flight height, std profile
- 40 HP Uniflex U joint drive, taper lock on head sprocket
- 2 pair idling centering rolls, c/w side guides thru these rolls
- 2 stage Optimil cylinders, c/w mechanical stop, 4" cylinders
- 2 pedestals
- 3-1/2" bed lift
- incorporate hyd float cyl in pedestal
- trabon auto lube
- 1 pair spike rolls mounted on infeed, chain centers for 1-1 sprocket ratio 6" air cylinder stroke
- Spike roll position 12 "ahead of head sprocket
- Ensure no hang ups at upstream end of infeed
- Updated chain tensioner circuit
- Skid plate at head sprocket
- Encoder info: - 8T prox wheel #B51429, prox switch #57413, Nanoose encoder #63542
- Skewing style – NSK
- 8" travel at head end
- 12" travel at tail end
- centerline calibration jig
- auto lube NSK

### **ITEM 40 FREE STANDING FRAME**

- 1 pair of spike rolls, 9" air cylinder
- pressrolls 2 Vee, sprocket, 1 spiked
- ensure bottom head motor clears leg

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#### **4 SIDED CANTER**

- 3 knife heads
- eagle brand (Red series)
- Knives by customer, babbitted domes top type
  - Bottom head: 2" and 2 1/16" CNS, see sketch, 6 at 2" knives, 27 at 2 1/16"
  - Side head 2 1/16" CNS , 60 knives
  - Top head 2 1/16" CNS, 27 knives
  - Spline Remove 2 1/16" CNS, 21 knives
- close up motor slot to prevent entry of chips on guards
- VFD drives on arbors, open loop only (no encoder)

#### **ITEM 50 BOTTOM HEAD**

- guide bar with holes for Telco photocell, 1 immediately after side chip heads, 1 at outfeed side of S/H feedroll (both as far upstream as possible to reduce lockout zone)
- multi spline
- motor clear free stand frame

#### **ITEM 60 15 DEGREE SIDE HEAD**

- replaceable AR chip chute liner (standard) (was not issued with liners)
- bottom head motor RHS
- physical stop at minimum set
- 1 pair of feedrolls, knurled
- m/c key for linear bracket anchor
- auto lube (oil)

#### **ITEM 70 INTERMEDIATE MODULE**

- 1 pressroll with heavy knurl, 2 stage cyl, same strokes as saw feed module
- 2 bedrolls, drive RHS
- pressroll to clear 16" envelope

#### **ITEM 80 TOP HEAD**

- physical stop at minimum set for slide frame
- physical stop at minimum set between bed roll and press roll
  - knurled pressroll
- pressroll travel: **2 1/2" below and 1" above anvil????**
- autolube (oil)
- photo cell immediately behind chip head, and immediately downstream of pressroll

#### **ITEM 81 HOAE INFEED MODULE**

- bedrolls see GA, drive LHS

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- 1 overhead pressrolls, 2 stage, knurled, same strokes as feed module in canter
- integral with top head

### **ITEM 90 15" HQAE**

- ref Spray Lake no. of sawlines = 4
- eagle brand saw specs = carbide tipped x 22" Ø x .160"K x .120" plate x 2500 rpm
- saw guides: bolt on babbitt, steel guides, 6" - 37 ½ involute spline, babbitt fixture included, "T" style if bolt on babbitt, 50 gallon lube panel, 3 complete sets of saw guides, guide bar thru saws, as much as possible, Min saw position from centerline is 1.250
  - Redesign frames for longer arbors, this will allow for longer motor and proper sawdust guard, grease arbor lube
  - 6" round ways, with oil auto lube, non-ferrous brg caps
  - send out arbor motor work sheet (not required by Toshiba)
  - sent out involute gauge to saw supplier (done)
  - ball/cylindrical roller brg on arbor.
  - Photocell slot thru belt guard, immediately behind saws
  - Auto lube on slideways

### **ITEM 100 SPLINE REMOVER MODULE**

- 18" Ø pressroll over spline remover, 2:1 ratio cyl strokes
- 2 stage on overhead rolls, knurled rolls
- pull out for knife change
- 1 pair vertical driven rolls, 2 stage cylinder
- Dodge Paraflex coupling on spline head
- multi spline bedrolls
- watch column on Bayline #56

### **ITEM 110 SEPARATOR**

- use Tenneco if possible (see Dennis)
- canterlevered rolls, 3.4375" brgs, 29" roll face
- split sprockets on roll to roll drive
- fixed end stops, beefed up
- over head pressrolls sequenced
- center chain head sprocket 28 T x 1 ¼"P (confirmed)
- prox switch #57413, 6 tooth star wheel B51427 (confirmed Eric C)
- skid plates full length
- shears c/w skirts
- secondary board stop at 12" from end of roll
- Lacy Harmer chain # 100-2SL-LP

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### **ITEM 120 VDAE INFEED ROLLCASE**

- 7 foot long approx
- 1 only driven pressroll, 5" dia air cyl, 2 stage, roll position adjustable up and down stream 2 feet

### **ITEM 130 10" VDAE**

- center feed, 8 ½" dia rolls, electric U joint drive
- tubular feed frame
- fixed saws
- no. of sawlines = 7
- polychain belts 125mm, 90T, and 56T with "F" bushing
- base feed speed = 276 fpm with 14.06:1 ratio
- saw specs = carbide tipped x 17" Ø x .135K x .090" plate x 2812 rpm
- saw guides: bolt on babbitt, steel guides, 6" spline 37 ½ involute
  - babbitt fixture included, "T" style in bolt on babbitt
- 4 pairs rolls in, 4 pairs rolls out
- cylinder dia = 6", 2" manifolds
- 2 wire hose on pneumatics
- 50 gallon lube panel
- 3 complete sets of saw guides
- 4 tooth prox wheel, switch #64815 (U-joint)
- 2 door switches #AB871T-L4B12
- send out arbor motor work sheet, (done)
- spare arbor assy c/w housing less sheave & sleeve
- plumb each air cylinder with its own valve no plumbing under machine
- clarify arbor bearing seal orientation on assy drawings
- guide bar photocells, location same as per Sunpine if possible, 1 in and 1 out
- resurfacer required

### **ITEM 140 HYDRAULIC POWER UNIT**

- A)
  - 120/220 volt heaters
  - 120/220 volt cooler fans
  - wired to "J" box
  - pumps: Vickers
  - supplier: Hypower
- b) Setworks:
  - 2 @ 60 GPM / 75 HP
  - 1 @ 3HP recirc.
  - dump valves

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- d) Accumulators-2 @ log turner
  - 1 @ infeed bed lift
  - 1 @ top head
  - 2 @ system - 5 gal.
  - 2 @ float

**ITEM 150 OPERATOR CAB**

- Location of wonder ware screen see dwg C63846
  - indoor duty
  - colors: outside VK blue, inside beige, console grey

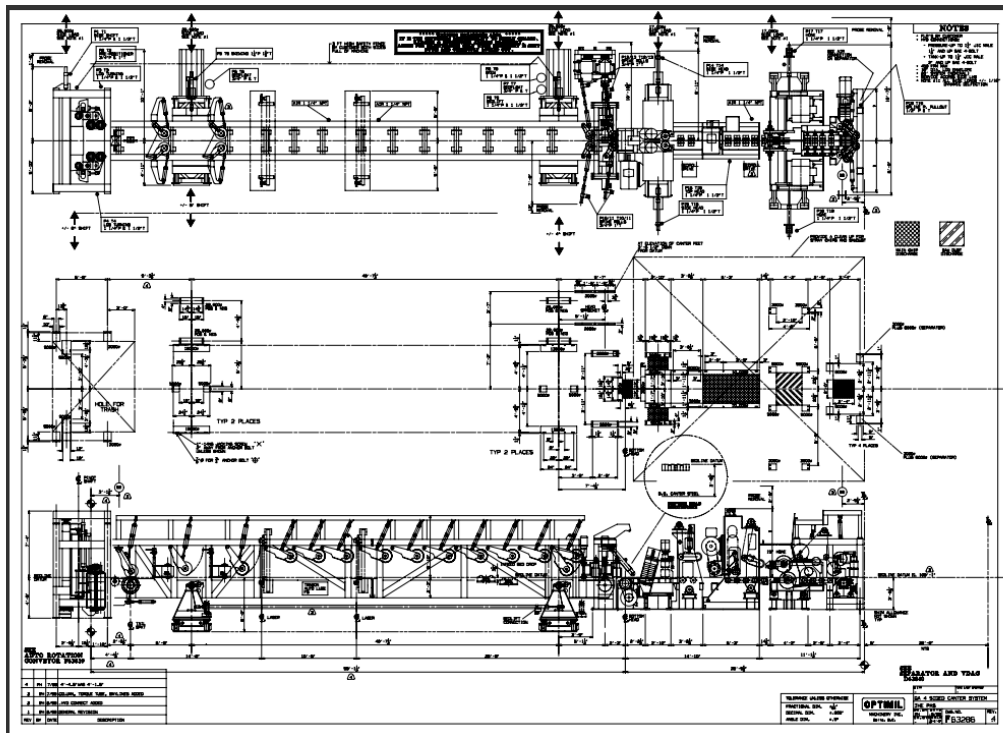
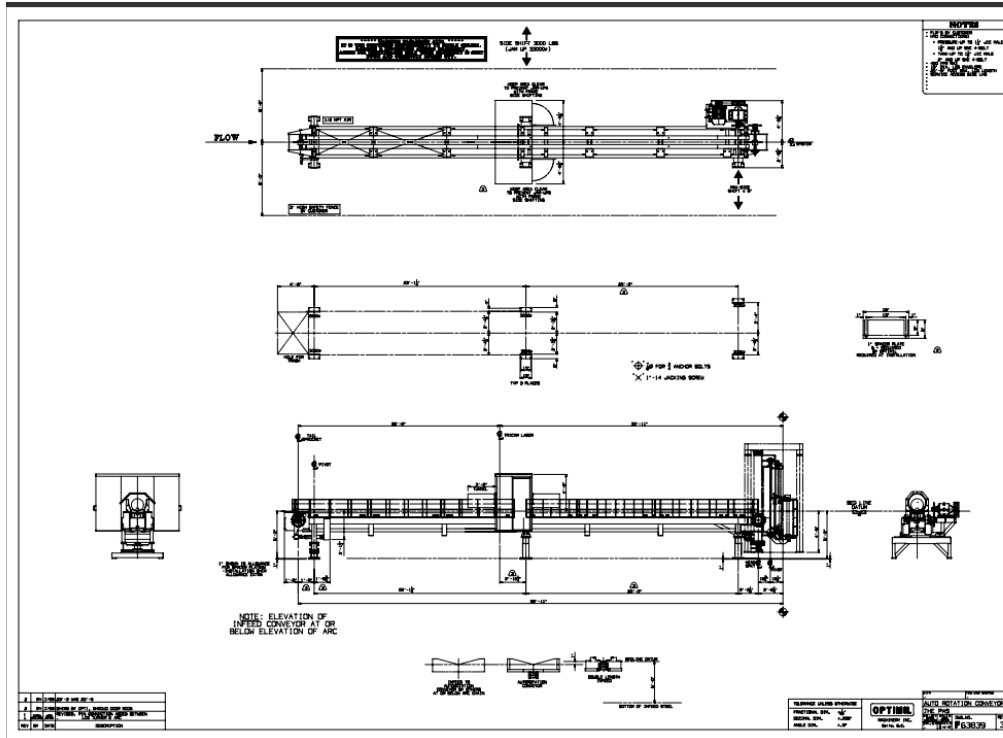
**ITEM 160 PLC / SCANNER**

- A/B
- wonderware
- Computer HP

**SCANNING**

- 1 zone ARC
- 2 zone Infeed

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