



Division of Hydro-Thermal Corporation PROVIDING SOLUTIONS WORLDWIDE

WIZARD DRUM TOOL CO.

STATIONARY FIBER DRUM DECHIMER

OPERATING AND SERVICE MANUAL



Serial No. _____



Stationary Fiber Drum Dechimer Operating and Service Manual; Version 2.0, Rev B

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SECTION 1 -- GENERAL WARNINGS AND PRECAUTIONS**ATTENTION**

This section must be read thoroughly before operating any equipment supplied by WIZARD Drum Tool Co. Failure to do so may result in damage to equipment and/or severe injury to personnel.

- When using the unit, make sure you are wearing all personal safety equipment such as gloves, safety glasses, and steel toe boots.

DANGER
ELECTRICAL
HAZARD

1. To avoid serious injury or death from electrical shock, make certain the unit is properly grounded.
2. Do not operate any of the electrical units in wet areas.
3. Always use the correct voltage supply as indicated on the unit motor nameplate.
4. Do not use power cord if damaged or frayed.

DANGER
MECHANICAL
HAZARD

1. In the event of a temporary power loss, there is the potential that the unit may be restarted automatically if the power switch is left in the "ON" position!
2. Keep all body parts away from the cutter wheel and roller whenever the power is on!
3. If the unit stalls due to blockage between the cutter wheel and the roller, always turn the unit off before attempting to dislodge any debris!
4. The chime of a cut drum may be sharp! Caution should be used when attempting to remove the lid from the drum. It is recommended that leather work gloves be worn when handling cut chimes.
5. Disconnect the power supply (electrical or air) before performing any maintenance on the unit!
6. Do not operate unit on flooring that is not level. The drum may tip over during operation.

The following applies to units purchased for use in non-explosive environments:

DANGER
EXPLOSIVE
HAZARD

1. Do not use any of the units to remove the lids off drums which may contain explosive materials.
2. THE UNITS ARE NOT TO BE OPERATED IN EXPLOSIVE ENVIRONMENTS!
3. Extreme care must be taken so that the unit is not operated in any manner to potentially ignite the drum contents and/or any explosive material.

SECTION 2 -- GENERAL INFORMATION

PRODUCT DESCRIPTION

The Stationary Fiber Drum Dechimer is a heavy duty machine designed to remove the top and bottom chimes from the fiber shell in large volumes.

The unit requires minimal set up. The unit is designed for quick and easy removal of normal wear parts such as the cutting wheels and drive rollers. Standard tools may be used to disassemble the machine for complete refurbishing.

SECTION 3 -- HOW TO USE YOUR FIBER DRUM DECHIMER

! WARNING !

To avoid serious injury or potential death from electric shock, make sure the unit is properly grounded. Do not use the unit in wet areas.

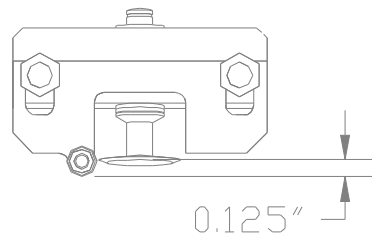
! WARNING !

Keep all body parts away from the cutter wheel, drive roller and cutting blades whenever the power is "ON". If ANY parts blockage and/or hang up, always turn the power "OFF" before attempting to dislodge any debris.

MACHINE SET UP

1. Find a level open area near the supply of drums to be dechimed.
2. Position the machine in a convenient location and level it by adjusting the five frame leveling pads if supplied with the standard duty frame. The heavy duty frame has mounting holes which can be anchored to the floor.
3. Prior to running the machine, check that the frame shafts are perpendicular (at least 90 degrees) with the top of the frame where the drums sit. If they are not, adjust the angle by rotating the support rods until the shafts are perpendicular.
4. Wire the machine for 110V AC (or 220V AC if European version). The power supply must maintain 105 - 120 (or 210 - 230) volts while the machine is running. A grounded extension (12 Ga. or larger) cord may be used if it is able to maintain 105 - 120 (or 210 - 230) volts to the machine.

5. Pipe an air supply to the machine. 90-110 psi (620-760 kPa) is recommended. All piping (including portable air hose) must be able to maintain the recommended air pressure to the machine.
6. Adjust the upper cutting block assy. (11444) so the base of the roller is about 1/8" below the cutting edge of the cutter wheel when the cutter wheel is in its highest position.



AUTOMATIC MACHINE OPERATION

1. Make sure air and electric power are on.
2. Press the master start button to turn the machine on. The master start switch light should illuminate.
3. Set the chime cut switch to "AUTO" and the palm switch to "HOLD".
4. Adjust the height of the upper cutting mechanism by moving it up or down by turning the lead screw switch to either "UP" or "DOWN" and holding it until the mechanism has reached the desired height. Adjust the height to approximately three inches above the drum.
5. With the machine in the "ready" position (cutting wheels and drive rollers open), place the drum in the machine with the bottom side of the drum (closed end) facing up. The drum chimes should be located between the cutting wheels and drive rollers.
6. Depress the cycle start palm buttons and hold throughout the entire cycle. There is a slight delay between the end of the cutting cycle and the beginning of the slicing cycle. Be sure to keep the palm buttons activated throughout the entire cycle.
7. Release the palm buttons after the chimes have been cut and the slicing blade has penetrated through the chime. The slicing blade and upper cutting mechanism will automatically open and reset for the next drum when the palm buttons are released.
8. Remove the drum. The lower chime will be completely separated.

9. The upper chime must be removed by prying it away from the fiber shell. Wedge one end of the chime against the upper cutting wheel. Pull the drum away from the cutting wheel while giving it a slight twist. The remainder of the chime can then be pulled off the fiber shell by hand.
10. Place all drum pieces away from the unit.

OPTIONAL OPERATIONS

1. The machine has an optional mode which allows the operator to release the palm buttons prior to the completion of the cutting cycle.
2. Turn the palm switch to "RELEASE".
3. Depress the cycle start palm buttons to begin the cutting operation. The palm buttons may be released after the drive wheel motors begin to rotate the drum. The machine will stop before the slicing blade begins its cycle.
4. Hold the palm buttons in to activate the slicing blade cycle. The palm buttons must be held throughout this cycle.

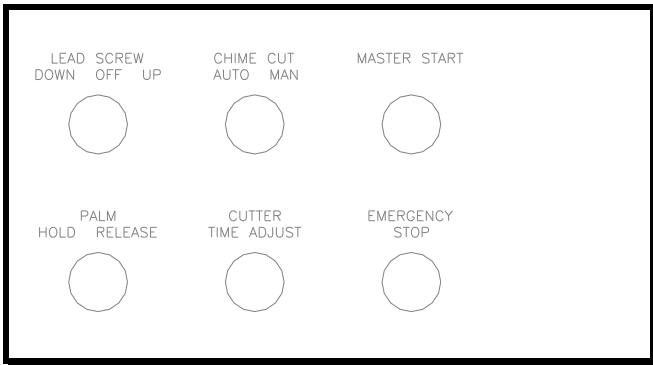


Figure 1: Control Panel Switches

10. Depress the palm buttons throughout the slicing cycle until the slicing blade has penetrated through the drum chime.
11. Release the palm buttons and the unit will reset itself.

CHANGING THE CUTTING CYCLE TIME

The machine's cycle time can be adjusted to fine tune it to a particular diameter drum. The machine is set up to drive the drum for 20 seconds before releasing the cutting wheels. Smaller drums require less time to cut and the machine's cycle time can be adjusted to accommodate different diameters.

To *decrease* the cycle time, set the chime cut switch to "AUTO" and depress the cutter time adjust button. Each depression decreases the cycle time by 1 second.

To *increase* the cycle time, set the chime cut switch to "MAN" and depress the cutter time adjust button. Each depression increases the cycle time by 1 second.

5. After the slicing is complete, the palm buttons may be released which will reset the machine to the ready position.
6. Remove the drum as described above.
7. The machine is equipped with an optional slicing mode which allows an operator to slice the chime in several places.
8. Set the chime cut switch to "MAN".
9. Position the drum as described above.

SECTION 4 – PROPER USE AND CARE**! WARNING !**

To avoid serious injury or death, always disconnect the power supply (air and electric) to the unit before attempting to perform any maintenance tasks.

With proper use and care, your fiber drum dechimer will provide long and dependable service.

Keep the unit clean of debris and other foreign material. If drum content residue builds up between the cutting wheels and drive rollers, they may need to be cleaned regularly or replaced.

Keep the ACME lead screw clean and lubricated with a light machine oil.

Be certain that all air and electric connections are correct and safe. Make sure that there is no damage to any power connections or lines.

The unit is not designed for outdoor use. Keep the unit in a dry area.

Recommended Maintenance schedule

Every 100 drums (About one per week)

1. Inspect and wipe clean upright supports. If the unit is in a very dirty environment, this may be required more often.
2. Wipe clean and lubricate the ACME screw with a light machine oil.
3. Inspect and clean the serration's on the drive rollers
4. Adjust lid Roller to standard height for drums used (See machine setup)

Every 1000 drums (about once per month)

1. Tighten all hardware on entire assembly.
2. Verify all guards are in place and securely tightened.
3. Clean and replace filter on air line.
4. Verify gap between cutter wheel and drive roller is zero. (See Cutting Wheel / Drive Roller Gap Adjustment section) Readjust if necessary. If cutter wheel is worn, replace with new cutter wheel.

Every 5,000 drums (about twice a year)

1. Repack upper and lower cutter wheel bearings. Replace if worn or damaged.
2. Replace Cutter wheel and Drive roller.

3. Thoroughly clean entire assembly using a stiff brush (No water).
4. Check all air and cable ties to insure the cables can travel freely with the cutting mechanism without binding or catching.
5. Check level of base assembly and readjust upright supports to be perpendicular to base.

Every 10,000 drums (About one a year)

1. Replace Stationary (11489) and movable (11488) chime cutting blade
2. Inspect Bronze and oillight bushings on Uprights, and cutter wheel bores, replace if worn.
3. Inspect cutter wheel housing extension shafts. Replace if they show signs of wear.
4. Rebuild Air cylinders. Contact Local Bimba Representative for rebuild kits.
5. Carefully inspect the entire unit for signs of wear, or damage. Replace all damaged parts.
6. Examine ACME screw threads carefully for signs of wear. If any wear is found, replace ACME thread and nut as a unit.

BEARING LUBRICATION

Bearing lubrication should be a part of a general maintenance schedule in which all bearings should be checked and repacked approximately every 5,000 drums depending on the severity of the cutting environment. In addition, the bearings should be checked and repacked whenever the machine has been taken apart for other maintenance. This will ensure a long bearing life.

Grease, because of its ability to be retained within the bearing, compounded with a mineral or synthetic oil whose viscosity is greater than 100 S.U.S or 20 cSt is recommended. Grease or oil with less than these recommendations may reduce the life of the bearings.

SECTION 5 – GENERAL MAINTENANCE AND REPAIR

! WARNING !

To avoid serious injury or death, always disconnect the power supply (air and electric) to the unit before attempting to perform any maintenance tasks.

WIZARD® designs its Stationary Fiber Drum Dechimers for long life, maximum reliability, and simplified maintenance. Replacement parts are readily accessible for quick and easy maintenance. Please reference the assembly drawings during maintenance.

MAINTENANCE FOR INDUSTRIAL UNITS

Daily checks should be:

- Make sure all nuts and bolts are securely fastened
- Check cutter wheels for any chips and/or wear
- Check drive roller for wear
- Check proper alignment of chime rollers
- Make sure there is no binding of any gears or bearings
- Make sure drive roller is free of debris

Bi-monthly checks:

- Take nameplate off to make sure there is enough grease on gears
- Check air lines for cracking and pinching
- Check electrical lines for cracking and pinching
- Check T-handle for wear or thread damage

! WARNING !

Always use personnel safety equipment (PSE) when using this machinery.

The grease we prefer is food grade grease. It is safer for the environment.

FIELD SERVICING

Servicing and maintenance is possible with ordinary hand tools. Replacement parts are available from factory stock. Use and experience will determine which parts to keep on hand for routine maintenance, such as cutting wheels, drive rollers, and thrust bearings.

DRIVE ROLLER REPLACEMENT

Refer to assembly drawing 1.

1. Disconnect the air and electric power.

2. Notice the general orientation of the drive roller grooves.
3. Remove the snap ring (11562) located at the end of the drive roller shaft (26480) using a snap ring pliers.
4. Slide the drive roller (11443) off the drive roller shaft (26480).
5. Slide the new drive roller (11443) on the drive roller shaft (26480), groove facing away from the housing (11444 or 11487), with the key and thrust bearing (11564) in place.
6. Hold the drive roller (11443) against the housing (11444 or 11487) and replace the snap ring (11562).

UPPER & LOWER DRIVE ROLLER SHAFT REPLACEMENT

1. Refer to assembly drawing 1.
2. Disconnect the air and electric power.
3. Notice the general orientation of the parts to be removed.
4. Follow the instructions for removing the drive motor.
5. Remove the snap ring (11562) inside the housing (11444 or 11487).
6. Remove the drive roller (11443) and drive roller shaft (26480) from the housing (11444 or 11487).
7. Place the drive roller (11443), key (10110), and thrust bearings (11564) on the new drive roller shaft (26480) in the correct orientation.
8. Repack the bearings (11511 and 11512).
9. Slide the drive roller shaft (26480) back into the housing (11444 or 11487).
10. Replace the other thrust bearing (11564), key (10110), and snap ring (11562).
11. Replace the motor by following the motor replacement directions.

CUTTING WHEEL REPLACEMENT

Refer to assembly drawings 2 and 3.

1. Disconnect the air and electric power.
2. Notice the general orientation of the parts to be removed.
3. Remove the snap ring (8070) from the cutting wheel (11477) using snap ring pliers.

4. Slide the cutting wheel (11477) and oilite bearings (10004) out of the housing (11476 or 11440).
5. Repack the bearings (10001). Replace the seals (11439) if damaged.
6. Place two oilite bearings (10004) on the cutting wheel (11477) shoulder and slide the new cutting wheel (11477) into the housing.
7. Hold the cutting wheel (11477) against the housing (11476 OR 11440) and place four oilite bearings (10004) over the top of the lower housing (11476) OR one oilite bearing (10004) over the top of the upper housing (11440).
8. Replace the snap ring (8070) on the cutting wheel (11477).

LOWER DRIVE ROLLER AND ACME SCREW MOTOR ACCESS

Refer to assembly drawings 5 and 6.

1. Disconnect the air power only.
2. Notice the general orientation of the parts to be removed.
3. Remove the top support bracket (11492) from the frame shafts (11480) and the acme screw (11445).
4. Power the upper cutting mechanism (11444 assy) up the acme screw (11445) using the acme screw switch on the control box until it rests at the top of the acme screw (11445).
5. With support, lift the upper cutting mechanism (11444 assy) from the unit.

! CAUTION !

The upper cutting mechanism (11487 assy) weighs approximately 100 lbs and the weight is not centered. Make certain that the support can handle at least 100 lbs. Be careful not to let the mechanism tip off the support!

7. Disconnect the electric power.
8. Refer to assembly drawing 8 and 9.
9. Remove the acme screw (11445) and frame shafts (11505) from the unit.
10. Remove the bottom drive roller housing assembly (11444 assy) from the frame and supports.

! NOTE !

For proper machine operation, adjust the frame shaft supports such that the frame shafts are at 90 to 95 degrees from the frame after reassembly.

DRIVE ROLLER MOTOR REPLACEMENT

Refer to assembly drawings 4 and 1.

1. Disconnect the air and electric power.
2. Notice the general orientation of parts that will be removed.
3. Conduct the steps listed in Lower Drive Roller and Lead Screw Access if replacing the Lower Drive Roller Motor.
4. Disconnect the motor power line at the junction.
5. Remove the socket head cap screws (11579) and lock washers (5622).
6. Remove the motor (11496).
7. Place the new motor (11496) on the housing (11444 or 11487) with the motor shaft and key inserted into the drive roller shaft (26480).
8. Replace the socket head cap screws (11579) and lock washers (5622). Loctite® is recommended to keep the bolts from loosening.
9. Reconnect the motor power line at the junction.

LEAD SCREW MOTOR REPLACEMENT

Refer to assembly drawings 6 and 5.

1. Notice the general orientation of the parts that will be removed.
2. Disconnect the air and electric power.
3. Conduct the steps listed in Lower Drive Roller and Lead Screw Access.
4. Disconnect the motor power line at the junction.
5. Remove the ACME lead screw bearing block (11470) from the lower housing (11444).
6. Remove the motor mounting bolts and lock washers.

7. Remove the motor (11497) from the lower housing (11444).
8. Remove the motor shaft coupling (11502), coupling spacer (11566), and key from the motor (11497) shaft.
9. Replace the shaft coupling (11502), coupling spacer (11566), and key on the new motor (11497).
10. Replace the new motor (11497) on the lower housing (11444).

OTHER COMPONENT REPLACEMENT

Other components can be replaced by examining the general orientation of the parts as they are removed. Follow the exploded view for additional assistance. If necessary, please call the factory at 1 - 800 - 628 - 8628 for more help.

CUTTING WHEEL / DRIVE ROLLER GAP ADJUSTMENT

The gap between the cutting wheel and drive roller must be adjusted to zero in order for the cutting wheel to fully penetrate the drum chime. If the gap is more than zero, the drum chime may not be fully separated from the drum after cutting. Conversely, if the gap is less than zero (cutting wheel presses against the drive roller), the cutting wheel edge may dull or become serrated and the life severely shortened.

Refer to assembly drawing 7.

1. Disconnect the air and electric power.
2. Disconnect the ¼" air hoses from the quick disconnects in the air cylinder (11498).
3. Make sure the air cylinder (11498) is fully seated in the air cylinder bracket (11478).
4. Pull the air cylinder (11498) back away from the upper (11444) or lower (11476) cutting mechanism to close the gap between the cutting wheel (11477) and the drive roller (11443).
5. Adjust the gap by threading the air cylinder shaft into or out of the upper (11444) or lower (11476) cutting mechanisms until the desired gap is achieved.

PHOTOELECTRIC SWITCH AND TOP CUTTING WHEEL HEIGHT ADJUSTMENT

If the top cutting wheel cuts too high (cutting wheel tends to ride up the side of the drum chime) or cuts too low (cutting wheel tends to dig into the drum lid), it is likely that the photoelectric switch is out of adjustment.

The photoelectric switch tells the control box when to stop the upper cutting mechanism from coming down the lead screw when the light beam emitted from the switch is broken by the top of the drum.

The beam is factory set for most fiber drums. However, the height can be adjusted for special drums by moving the mounting plate up or down. Adjustments are somewhat trial and error, but the basic steps are as follows:

Refer to assembly drawing 8.

1. Disconnect the air power only (electric must be kept on in order to move the upper cutting mechanism and to power the photoelectric switch).

! CAUTION !

Make certain the all personnel and objects are clear of the machine when attempting to activate mechanisms with the power on!

2. Place a drum into the machine.
3. Bring the upper cutting mechanism down by turning the lead screw switch to "down" until the beam is broken by the drum.
4. Measure the distance the cutting wheel is from the proper cutting position (bottom of cutting wheel should just touch the top of the drum lid and the cutting wheel should wedge under the drum chime when cutting).
5. Move the reflector up (to adjust the cutting height lower) or down (to adjust the cutting height higher). Check that the LED light on the back of the switch is on indicating a transmitted beam.
6. Test the height again and repeat if needed.

LOWER CUTTING WHEEL HEIGHT ADJUSTMENT

The lower cutting mechanism has been set to cut most drums. Height can only be adjusted by shimming the entire bottom assembly. Please call WIZARD for help in adjusting the lower cutting wheel height

SECTION 6 – TROUBLESHOOTING**!! CAUTION !!**

Do not put hands inside machine while it is running. Many pinch points exist and could cause serious injury.

PROBLEM	PROBABLE CAUSE	REMEDY
Erratic electrical operation.	Poor electrical ground.	Replace power cable. Use 12 GA cord or larger.
Lead screw does not move. (Motor not running).	Photoelectric switch out of adjustment.	Realign reflector.
	Faulty electrical connection.	Check wiring.
Lead screw does not move. (Motor running).	Coupling damaged.	Check and/or replace coupling.
Drive roller motor does not run.	Faulty power connection.	Check / replace the power cord.
	Loose power connection.	Reconnect. Tighten power connection.
	Damaged motor.	Replace motor.
Unit stalls or does not start.	Drive roller slips.	Clean serration's on drive roller. Check air cylinder engagement.
		Check that frame shafts are perpendicular to the frame. Adjust supports accordingly.
Electric components do not actuate.	Fuse blown.	Replace fuse.
System does not operate. Fault light on or blinking	Processor fault.	Unplug unit from main power, plug back in and restart.
Power light goes out during operation.	Insufficient power supply.	Rewire main power.
Top cutting wheel rides up	Position of upper cutting wheel incorrect.	Adjust photoelectric switch chime to position cutting wheel into chime lip.
	Drum chime damaged.	CAREFULLY guide drum through the damaged section.
Top cutting wheel cuts into the lid of the drum (cuts too low).	Photoelectric switch out of adjustment.	Realign photoelectric switch.
Lower cutting wheel cuts too high or too low.	Factory setting incorrect.	Call factory for assistance.
Blade does not slice through chime.	Not enough force exerted.	Check air pressure. Adjust regulator.
Does not cut drums.	Cutting wheel dull or chipped.	Replace cutting wheel.
	Not enough passes around drum.	Set cycle time for more time.
	Not enough cutting force.	Check for proper air pressure. Adjust regulator.
	Cutting wheel gap too large	Adjust for smaller gap.
All functions do not work.	Program error.	Call factory for assistance.

SECTION 7 – PARTS LIST (by part no.)

PART NO.	DESCRIPTION
2110	SCREW CAP HX HD 3/8-16X1L
2151	SCREW CAP SOC HD 3/8-16X1.5L
2161	SCREW CAP HX HD 3/8-16X1.5L
3045	ADAPTOR AIRLINE 1/4 NPT
3291	PLUG ELECTRICAL 15A 125V NEMA
3452	WIRE SJ-16/3 300V
3659	CONNECTORS PYLE SEAL GRIP*
3659A	NUT LOCK CONDUIT*
3807	NIPPLE CLOSE .25' NPT BRASS
3812	TEE STRAIGHT .25' BRASS
5041	NUT JAM HEX 3/4-16 304SS
5238	NUT LOCK HEX NYLN INSRT 3/8-16
5342	NUT LOCK JAM NYLN INSRT 1/2-13
5601	WASHER FLAT 0.313D STEEL ZC
5606	WASHER LOCK 0.375D ZC
5611	WASHER FLAT 0.5D ZC
5621	WASHER LOCK 3/8" ID
8514	CONNECTOR MALE 4X4 BRASS*
8519	ELBOW MALE 4X6 BRASS*
8523	HOSE OPAQUE 0.25OD POLY
10001	BEARING NEEDLE 0.88ODX0.63ID
10002	BEARING OILITE .88ODX.75IDX
10004	BEARING OILITE 1.19ODX.63IDX
10028	NUT LOCK HEX NYLN INSRT 5/8-11
10033	WASHER LOCK 0.25D ZC
10034	KEY 1LX.188WX.188H STEEL
10046	WASHER FLAT SAE 0.625D ZC
10092	WASHER FLAT 1.125ODX0.63IDX
10108	NUT FULL HEX 1/2-13 ZC
10942	CONTROLLER MICROLOGIX 1000
11431	PLATE NAME STATIONARY FIBER
11438	STAND STANDARD
11439	SEAL .625D*
11440	HOUSING WHEEL TOP CUTTING
26480	SHAFT WHEEL DRIVE STAT FIB DE
11443	ROLLER DRIVE STAT FIB DECHIMER
11444	BOTTOM DRIVE WHEEL HOUSING
11445	SCREW ACME MACHINED
11472	BRACKET CLAMP BOTTOM SUPPORT
11473	SUPPORT BOTTOM THICK
11474	SUPPORT BOTTOM THIN
11475	SHAFT GUIDE STAT FIB DECHIMER
11476	HOUSING WHEEL BOTTOM CUTTING
11477	WHEEL CUTTING STAT FIB DECHIMR
11478	BRACKET CYLINDER CW AIR

PART NO.	DESCRIPTION
11479	HOUSING BEARING BOTTOM
11480	SHAFT FRAME 2.0D X 74.25 1018
11481	UPPER FRAME SHAFT BUSHING HOUSING
11482	LOWER FRAME SHAFT BEARING HOUSING
11483	ACME NUT COVER
11484	BAR EXTENSION
11485	BRACKET CYLINDER LEFT AIR
11486	BRACKET CYLINDER RIGHT AIR
11487	HOUSING TOP DRIVE WHEEL
11488	BLADE MOVEABLE STAT FIB DECHMR
11489	BLADE STATIONARY
11490	BRACKET BLADE STATIONARY
11491	BRACKET CLEVIS
11492	BRACKET SUPPORT TOP
11493	NUT ACME MACHINED
11496	MOTOR ELECTRIC DC 1/4HP 42RPM
11497	MOTOR ELECTRIC DC 1/4HP 250RPM
11498	CYLINDER AIR 3DX2 STROKE*
11499	CYLINDER AIR 4DX12 STROKE*
11502	COUPLING JAW HALF .75 BORE*
11503	SPYDER HYTREL*
11506	CUP BEARING*
11507	SWITCH LIMIT PUSH BUTTON*
11508	SWITCH PHOTOELECTRIC*
11511	BEARING NEEDLE SEALED 1.125D*
11512	BEARING NEEDLE 1.125D*
11513	BEARING OILITE .50ODX.38IDX
11515	BOLT LATCH JIG*
11516	REGULATOR/FILTER AIR*
11523	PANEL CONTROL SFD 110VAC
11528	SCREW CAP HX HD 3/8-16X1.25L
11529	SCREW CAP HX HD 3/8-16X3L
11530	SCREW CAP HX HD 3/8-16X5L
11531	SCREW CAP HX HD 3/8-16X7L
11532	SCREW CAP HX HD 1/2-13X2L
11533	SCREW SOCKT HD 3/8-16 X 1
11534	SCREW CAP SOC HD 3/8-16X2L
11535	SCREW CAP SOC HD 3/8-16X2.25L
11536	SCREW CAP SOC HD 3/8-16X2.5L
11538	DOWEL PIN .5DX1.5L
11542	GUARD FRONT
11546	LABEL STATIONARY FIBER DECHIME
11548	LABEL WARNING GUARDS

11549	CONE BEARING SEALED*
11562	RING RETAINING EXT 1.125D *
PART NO.	DESCRIPTION
11564	BEARING THRUST OILITE MOD 1.12
11565	PLUG SHAFT SFD
11566	SPACER COUPLING MOD OILITE
11567	NUT FULL HEX 3/8-16 ZC
11568	SCREW CAP HX HD 1/2-13X1L
11569	SCREW SHDR SOC HD 0.625DX1.25L
11570	SCREW CAP SOC HD 1/4-20X2L
11571	BRACKET REFLECTOR SFD
11572	BRACKET PHOTOELECTRIC SFD
11576	STOP LOWER SFD
11577	SPACER STOP LOWER SFD
11578	STOP UPPER SFD
11579	SCREW CAP SOC HD 1/4-28X2L
11580	SCREW SET SOC HD 1/2-13 X .75
11584	SCREW CAP SOC HD 10-24X.75
11585	SCREW CAP SOC HD 10-24X1.5
11586	SCREW SET SOC HD 3/8-16 X .75
11589	WASHER FLAT 3/8D RUBBER
11608	TAPE REFLECTIVE 2LX2W*
11609	SPACER GUARD BOTTOM SFD
11611	CONNECTOR 110V TWIST LOCK MALE
11612	CONNECTOR 110V TWIST LOCK FEM*
11613	FRAME SHAFT BEARING MOD 2.015ID
11627	PLUNGER SPRING 1/2-13 X 1.25
11629	SCREW CAP HX HD 5/16-18X1L
11630	SCREW SHDR SOC HD 0.5DX1.5L
11634	BUSHING .5X.25 GALVANIZED
11659	ROD SUPPORT
11661	END ROD MALE PLAIN BALL JOINT
11662	END ROD MALE PLAIN BALL JOINT
11663	SCREW CAP HX HD 3/8-16X5.5L
11664	NUT FULL HEX 1/2-20
11665	NUT FULL HEX 1/2-20 LH THD
11666	SCREW CAP HX HD 1/2-13X3.5L
11668	LABEL 'LIFT HERE' FOR SFD
11669	LABEL 'NO LIFT POINT' FOR SFD
11670	LABEL 'SHARP EDGE' FOR SFD
11671	LABEL 'PINCH POINT' FOR SFD
11685	GAUGE PRESSURE AIR 0-100 PSI
11688	BOLT EYE SHOULDERED 3/8-16
11689	GUARD BOX SFD STEEL MESH
11691	GUARD BOTTOM SFD STEEL MESH
11692	GUARD FRONT LEFT SFD
11693	GUARD FRONT RIGHT SFD
11694	BAR EXTENSION LEFT
11842	BEARING OILITE .75ODX.38IDX

11843	PIN ROLLER LID FOR SFD
11844	BRACKET ROLLER LID FOR SFD
PART NO.	DESCRIPTION
11845	NUT JAM HEX 3/8-16
11858	FLAT 3.00WX.25H ALUM 6061-T651
11860	KEY .75LX.19WX.19H
11878	SCREW THUMB SHLDR 5/16-18X.75
12011	SETSCREW 3/8-16
10110	KEY .875LX.188WX.188H, STEEL
8070	RETAINING RING EXT .625 ID
12073	SCREW SET SOC HD 8-32X.125
5622	WASHER LOCK .25 304SS
12075	PIVOT PIN AIR CYLINDER
8064	COTTER PIN 1/8 DIA
24789	SCREW CAP HEX HD 3/8-16X1

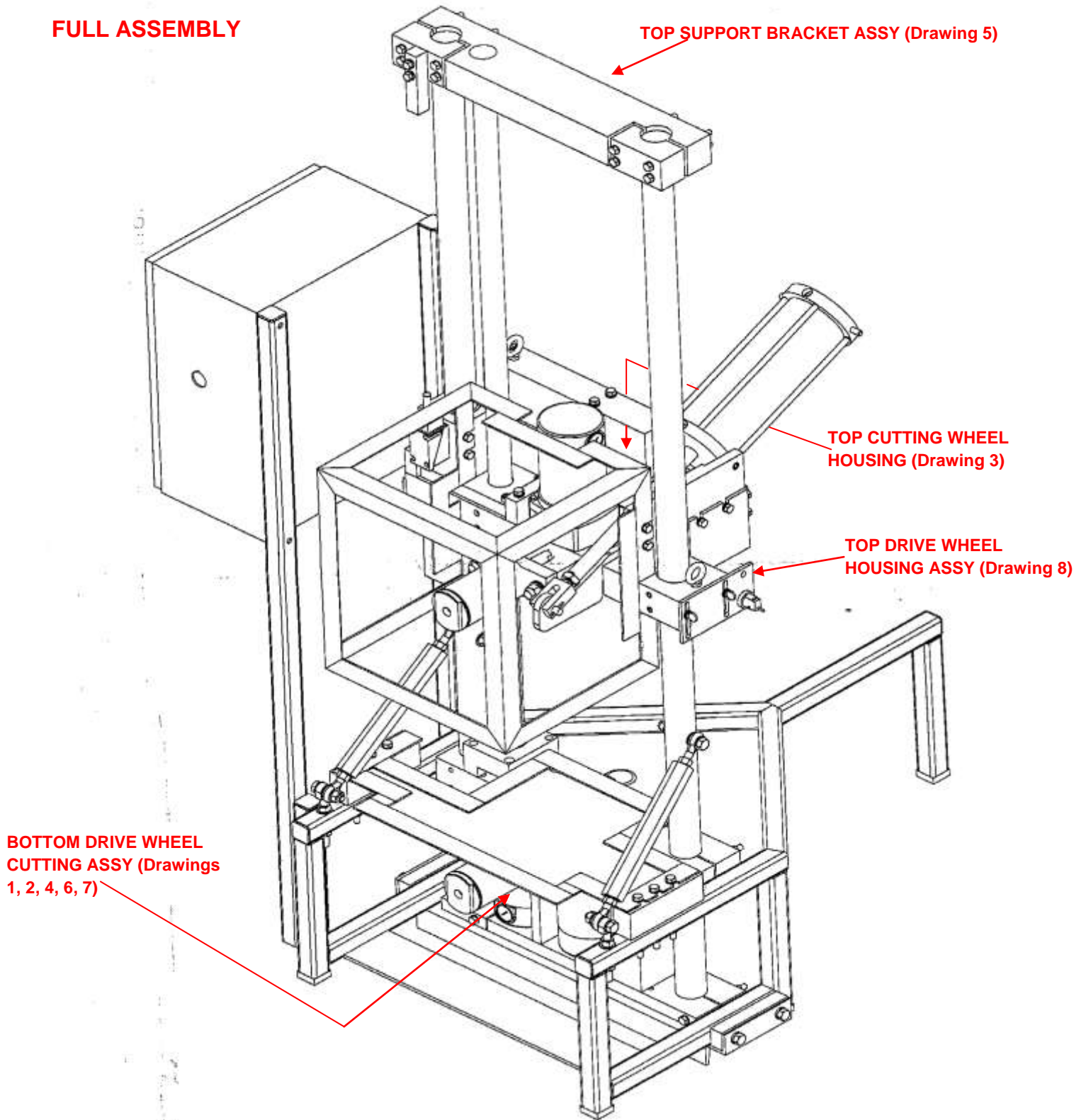
SECTION 8 – RECOMMENDED SPARE PARTS LIST

- (2) 11477 CUTTER WHEEL
- (2) 11443 DRIVE ROLLER
- (2) 11511 NEEDLE BEARING
- (2) 11512 NEEDLE BEARING
- (1) 11562 SNAP RING
- (4) 11564 SEAL
- (4) 10001 NEEDLE BEARING
- (1) 8070 SNAP RING
- (1) 11499 CYLINDER AIR 4DX12 STROKE*

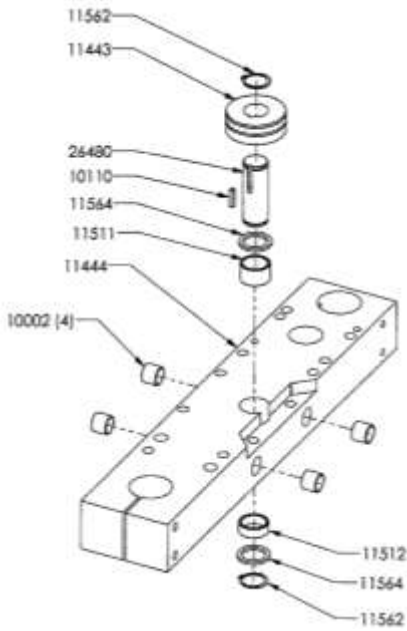
PLEASE CONTACT YOUR LOCAL DISTRIBUTOR FOR PRICING AND AVAILABILITY FOR REPLACEMENT PARTS.

SECTION 9 -- ASSEMBLY DRAWINGS

FULL ASSEMBLY

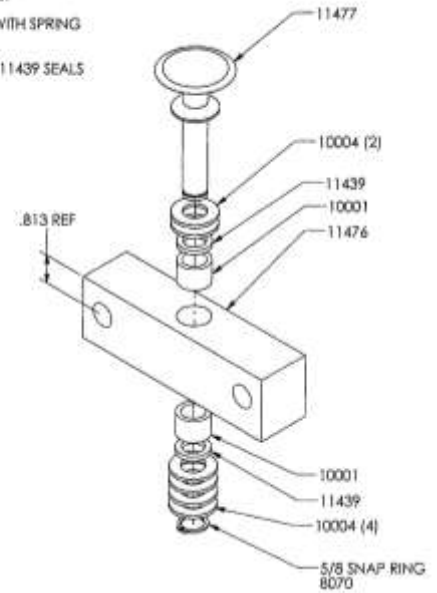


Drawing 1: BOTTOM DRIVE WHEEL HOUSING ASSY



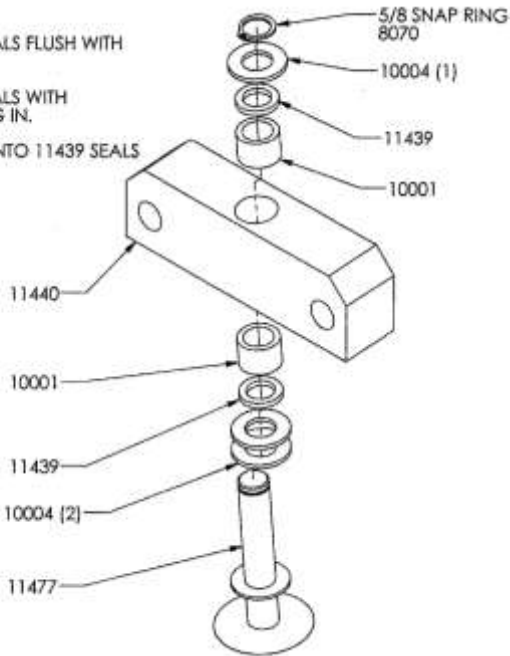
Drawing 2: BOTTOM CUTTING WHEEL ASSY

NOTE:
PRESS 11439 SEALS FLUSH WITH 11476 SURFACE.
PRESS 11439 SEALS WITH SPRING FACING IN.
THREAD 11477 INTO 11439 SEALS DURING ASSEMBLY.

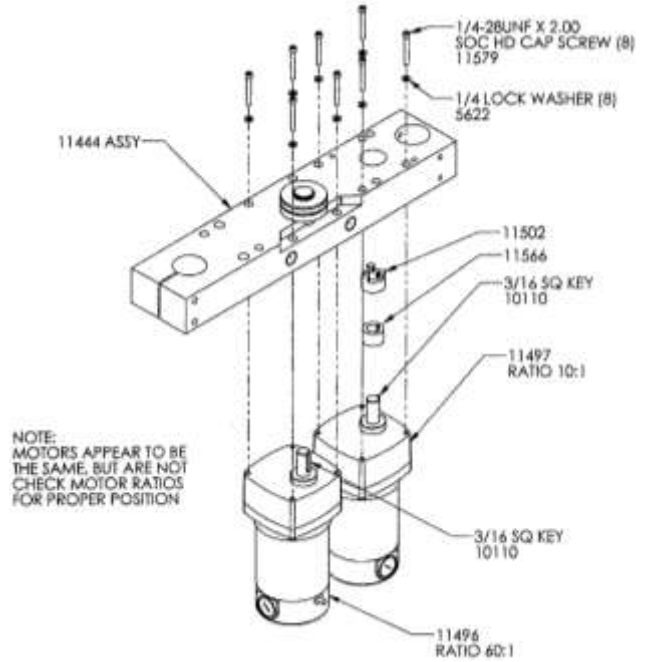


Drawing 3: TOP CUTTING WHEEL HOUSING

NOTE:
PRESS 11439 SEALS FLUSH WITH 11440 SURFACE.
PRESS 11439 SEALS WITH SPRING FACING IN.
THREAD 11477 INTO 11439 SEALS DURING ASSY.

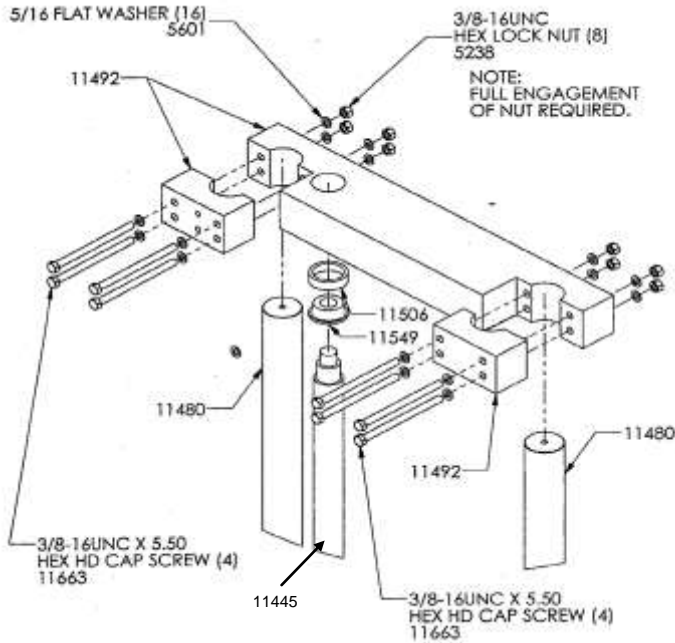


Drawing 4: BOTTOM DRIVE WHEEL HOUSING ASSY (WITH MOTORS)

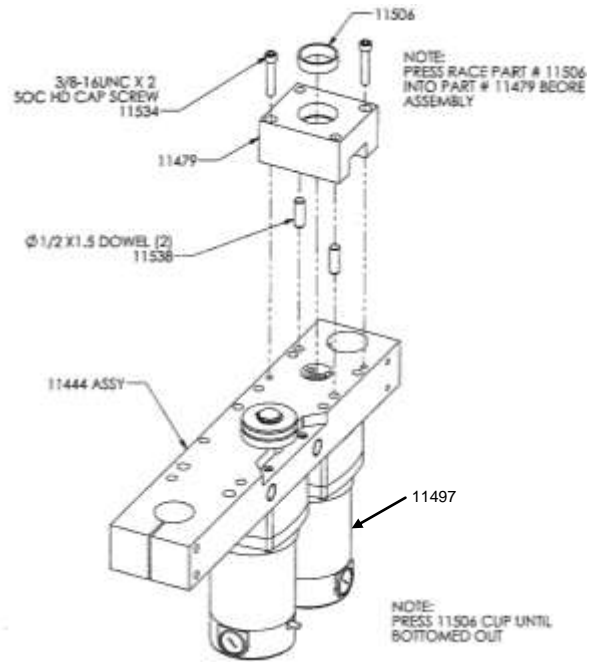


NOTE:
MOTORS APPEAR TO BE THE SAME, BUT ARE NOT CHECK MOTOR RATIOS FOR PROPER POSITION

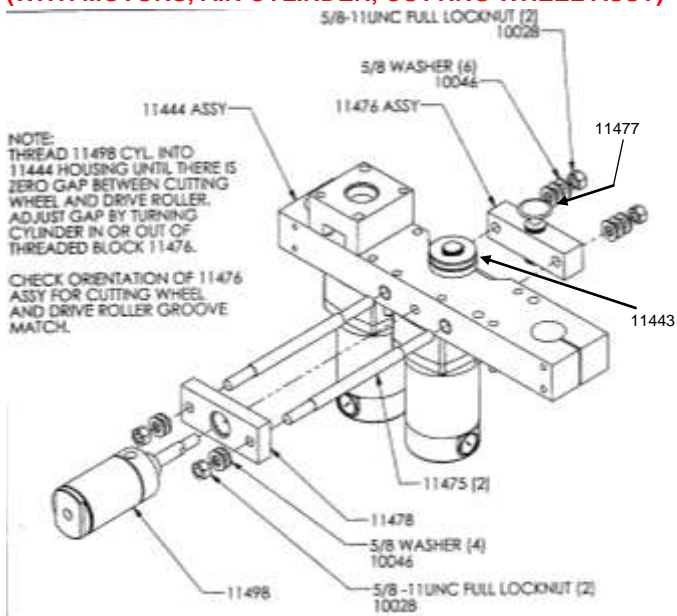
Drawing 5: TOP SUPPORT BRACKET ASSY



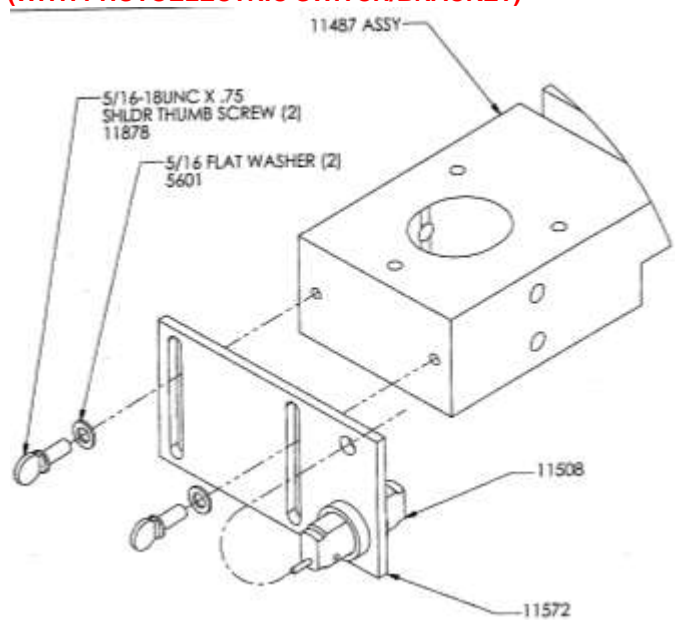
Drawing 6: BOTTOM DRIVE WHEEL HOUSING ASSY (WITH MOTORS, BOTTOM BEARING HOUSING)



Drawing 7: BOTTOM DRIVE WHEEL HOUSING ASSY (WITH MOTORS, AIR CYLINDER, CUTTING WHEEL ASSY)



Drawing 8: TOP DRIVE WHEEL HOUSING ASSY (WITH PHOTOELECTRIC SWITCH/BACKET)



SECTION 10 -- GLOSSARY

The following terms are often used to describe the drum and the use of the fiber drum dechimer. A proper understanding of these terms will help you use your dechimer and instruction manual.

CHIME -- The rolled edge of the top and bottom of the drum. Most fiber drums have a metal seam comprised of one layer of metal.

DRUM SHELL -- The fiber body of the drum usually comprised of 6-10 layers of thin fiber.

Limited Warranty

Wizard® Drum Tool Company guarantees the materials, components, and workmanship in its drum tool products to be of the highest quality and to be free of defects in material and workmanship for a period of 1 year from the delivery date. Any defective component or parts will be exchanged at our factory with replacement parts, shipped to you prepaid, if found to be defective from other than overload, abuse, careless or negligent use, or failure to maintain the unit as recommended by company operating and service manuals. The company's liability does not extend to damage or malfunction resulting from alterations from original design of the equipment or failure to follow normal operating procedures.

There are no warranties, either express or implied, of fitness for a particular purpose which shall extend beyond the warranty period of 1 year from the date of delivery. No responsibility is assumed from any incidental or consequential damages except for those allowed under state law. The company reserves the right under its product improvement policy to change construction or design details and furnish equipment when so modified without reference to illustrations or specifications.