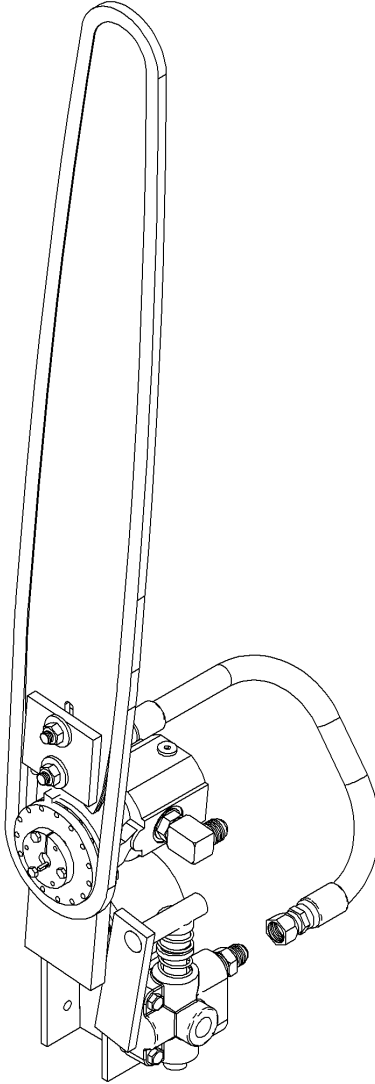


OPERATION AND PARTS MANUAL

DH0648 8G24 Simple Saw Assembly



6KProducts

Bringing reliability to high pressure hydraulic systems

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Information subject to change without notice.

SAFETY PRECAUTIONS

- ⇒ **The unit you have purchased may require you to install additional guarding to meet State and Federal safety requirements.**
- ⇒ **Do not move the log when it is being cut or when the saw is down. This action may damage the bar, chain or other components or could cause bodily harm or injury.**
- ⇒ **The log must be clamped before cutting. The bar, chain or other components could be damaged. You could suffer bodily harm or injury.**
- ⇒ **Do not make repairs or adjustments to this product other than those listed in this manual except when directed to do so by 6K Products.**
- ⇒ **All persons working near this machine must wear eye protection and hearing protection.**
- ⇒ **Use extreme caution around the cutting chain. It is sharp and may cause bodily harm or injury.**
- ⇒ **Petroleum products are used with this product. Use appropriate caution when operating or servicing. These products are flammable and may cause eye or skin irritation.**
- ⇒ **Always use 6K Products approved parts when making repairs. Replacement parts must meet or exceed the specifications of the original equipment manufacturer.**
- ⇒ **The information in this manual is subject to change without notification.**
- ⇒ **This manual is intended for safe operation and maintenance of the 6K Products, 8G24 Simple Saw Assembly. 6K Products, welcomes any and all suggestions on how to improve this manual or the 8G24 Simple Saw Assembly.**

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Introduction

Thank you for purchasing a 6K Products product. Our goal is to provide quality products for your job. This manual contains warranty information, installation information, operation instructions, parts ordering information, and service contact information.

Warranty

This 6K Products product carries a one year or 2000 hour warranty on the 6K Products designed and built components covering material and workmanship. Purchased components carry the manufactures warranty. This warranty does not cover normal wear from use, damage from abuse or misuse, damage from contamination, damage from natural disasters, fire damage or incorrect installation. This warranty does not cover labor to remove and replace parts, shipping and handling of parts, or shipping and handling for items returned for repair. If any component fails you must contact 6K Products at (360)264-2141 before doing any repair work. We will provide assistance to obtain warranty from other manufactures on their components.

Installation

You will receive one box containing all the parts (Fig. 1). You will need to reassembly the saw unit as shown in figure 2.

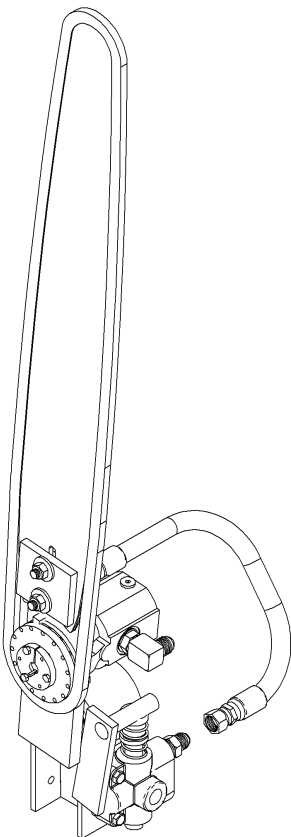


Fig. 1

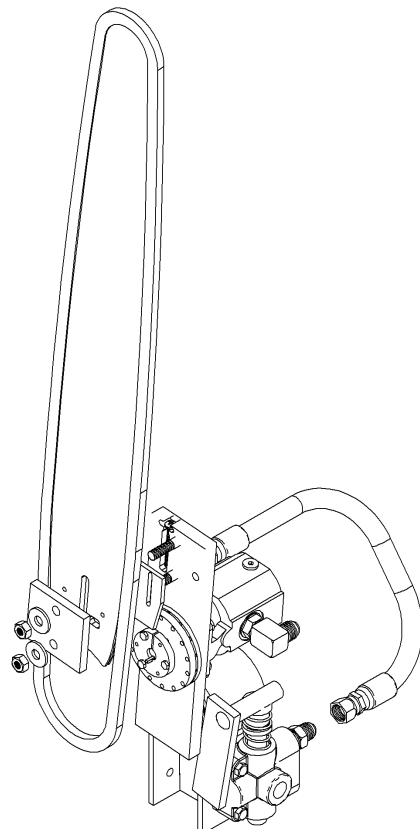


Fig. 2

After assembling the components as shown in figure 2, position the saw bar square to the log, at the correct height with clearance between the bar plate and the side of the largest log and weld down solidly (Fig. 3). The dimensions in figure 3 can be changed as required for your installation. You will need to fabricate and position a lever to feed the saw through the cut and return it to the retracted position. You will need to make guarding to protect the operator from sawdust and touching the chain.

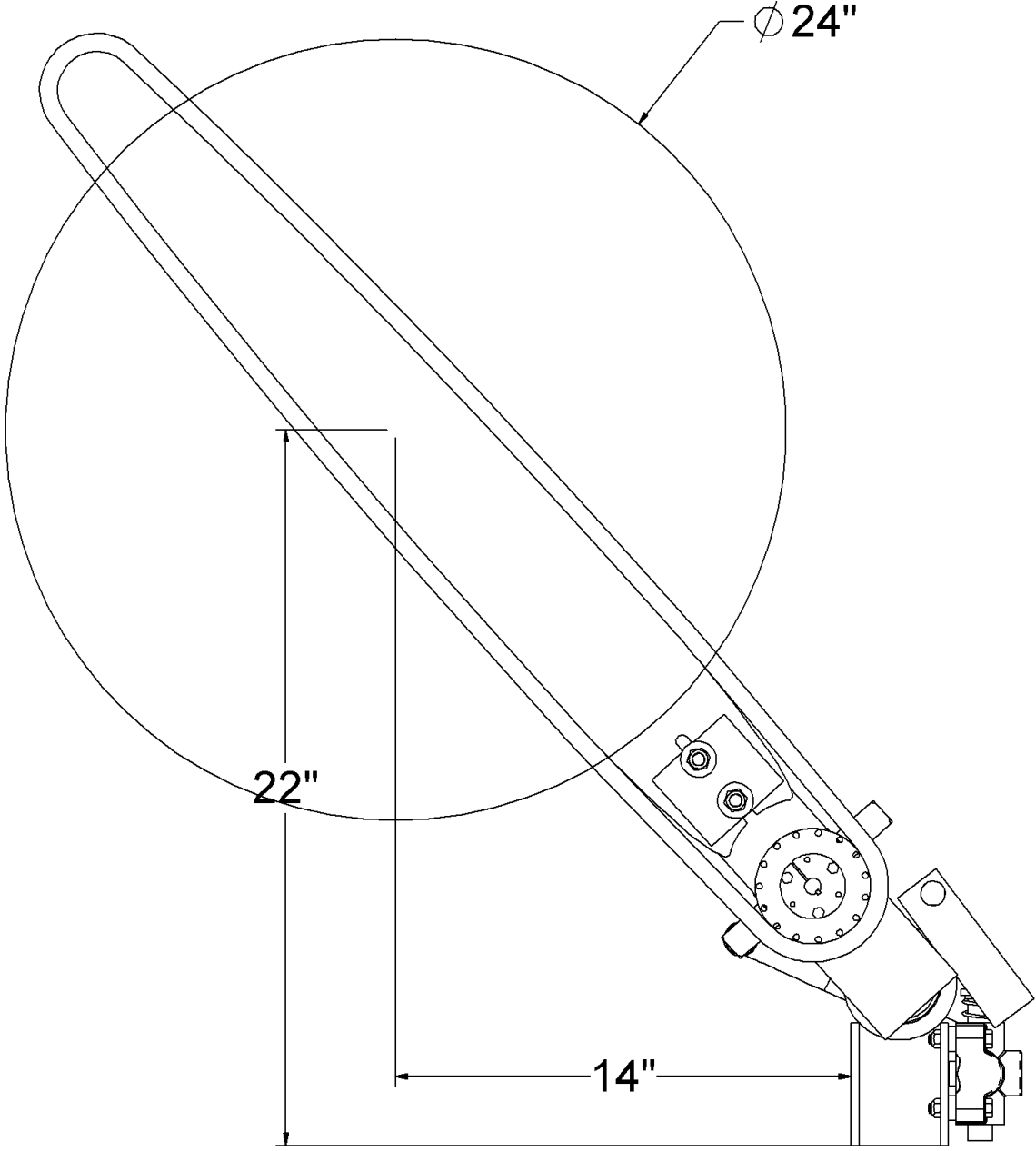


Fig. 3

Hydraulic Connections

The hydraulic requirements to operate the saw are 7 to 9 gallons per minute at 2000 psi from a fixed displacement hydraulic pump. You must install the pressure relief valve between the hydraulic pump and the selector valve to keep from damaging the hydraulic pump. Figure 4 shows hose connections for correct operation.

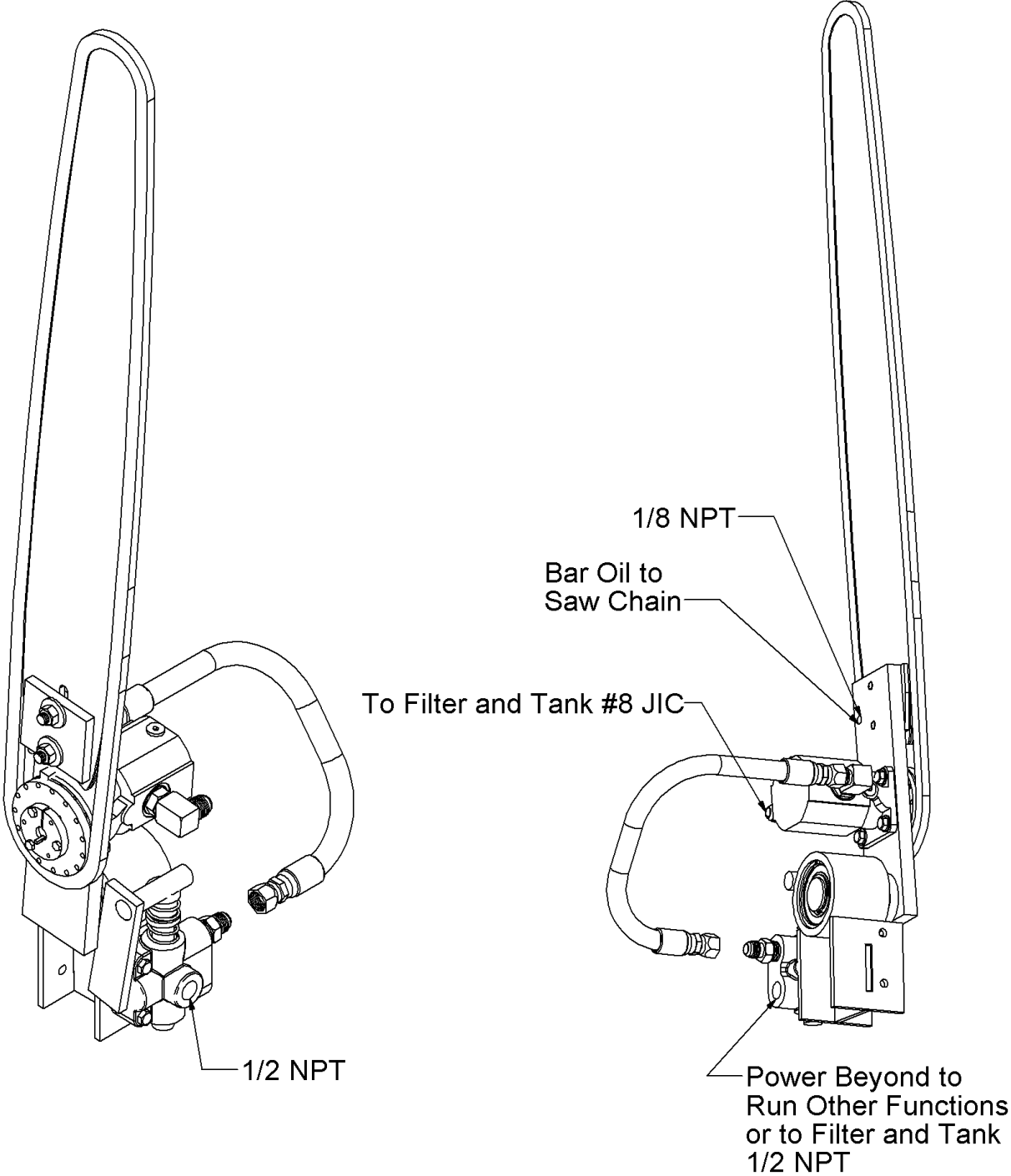


Fig. 4

The Power Beyond Port can connect to another valve for conveyor and clamp, or must go to the filter and tank. The return hose can be #8 or 1/2" diameter for the first five feet. If a longer hose is required it must be #12 or 3/4" up to thirty feet. If the total return hose length is greater than thirty three feet #26 or 1" hose should be used. The filter must be rated for 10 GPM plus any additional pump flowing into it. The saw motor should run between 4000 RPM and 5500 RPM. At this speed the pressure at the return to filter connection should not exceed 80 psi when the saw motor is running. We do not recommend using quick disconnects but if you choose to use quick disconnects in the tank line, first consult the manufacture to determine the correct size to keep the back pressure low enough in cold temperatures. Failure to properly size the hose and filter or properly connect the return hose to a filter and tank will shorten the motor shaft seal life and will not be covered by warranty.

Chain Tension and Sharpening

Figure 5 shows the chain tensioning screw. A #2 or #3 Phillips screwdriver is required to turn the tension screw. With the supplied saw bar, correct tension is when the cutters come off the rails roughly 1/8" with a tug of finger pressure. Refer to the Oregon Mechanical Timber Harvesting Handbook for more tensioning information and sharpening information.

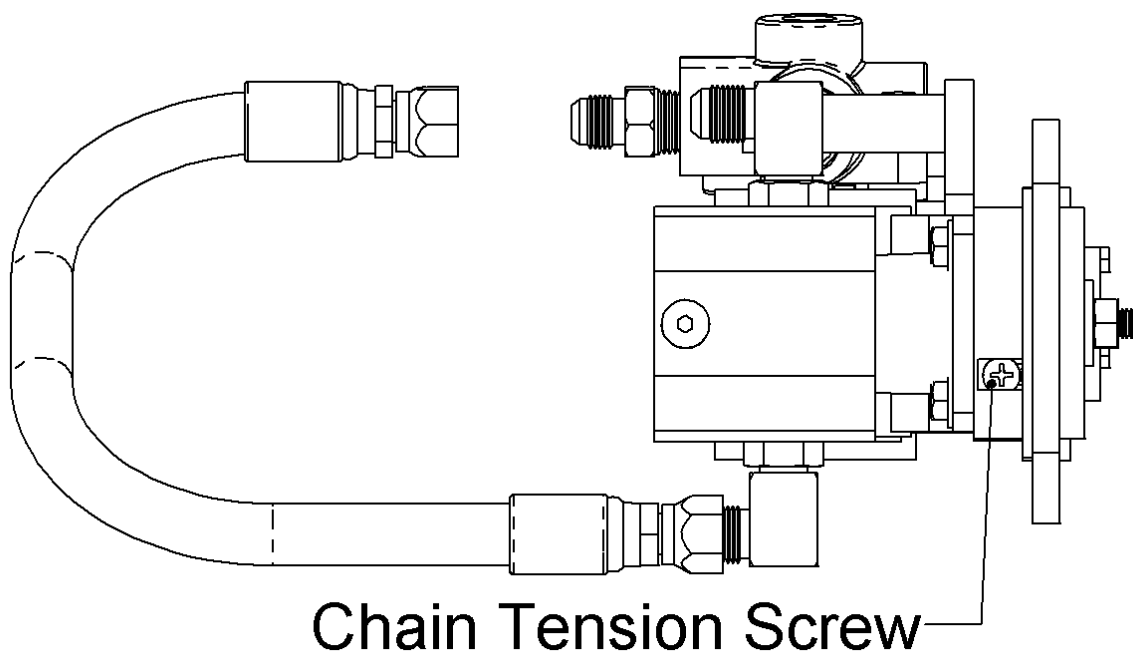


Fig. 5

Sprocket Removal and Replacement

The chain saw sprocket is connected to the shaft with a tapered bushing. To remove the sprocket remove the Cap Screws (Fig. 6, Item 3) and screw them into the Threaded Holes. Tighten up to 36 inch pounds to push the Sprocket (Fig. 6, Item 1) off the Bushing (Fig. 6, Item 2). You may need to tap the Sprocket towards the motor with a hammer to assist in getting the Sprocket loose from the Bushing. Lightly drive a flat blade screwdriver into the slot of the Bushing.

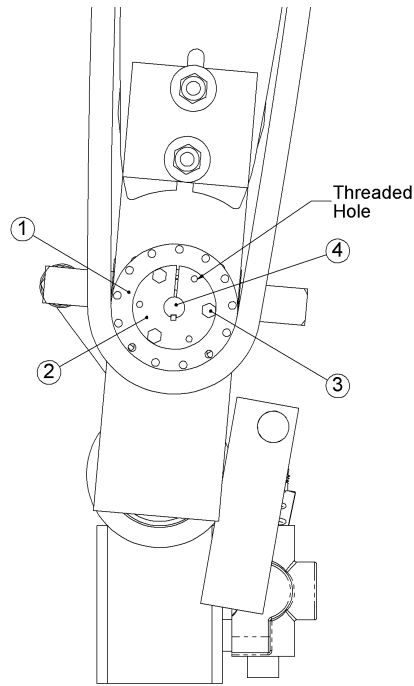


Fig. 6

Pry between the Bushing and the Sprocket to get the Bushing off the shaft. Watch that the Drive Key (Fig. 6, item 4) does not get lost.

To install the Sprocket, slide the Sprocket (Fig. 6, item 1) over the motor shaft, slide the Bushing (Fig. 6, item 2) onto the shaft with the Drive Key (Fig. 6, item 4) aligned. Position the sprocket groove offset towards the motor about the width of the bar groove with the Bushing just contacting the Sprocket. Insert the Cap Screws (Fig. 6, item 3) through the large hole in the Bushing and screw them into the threaded holes of the Sprocket. Torque the Cap Screws (Fig. 6, item 3) to 36 inch pounds. Check to make sure the sprocket groove is aligned with the bar groove. If the alignment is not correct, remove and replace the sprocket and bushing and adjust the position before tightening the cap screws.

Operating Instructions

Before, and periodically during, operation you must check the chain tension. We recommend using a good quality bar oil of the correct viscosity for your areas operating temperatures. Because of the wide temperature range between winter and summer two different viscosity oils may be required. Tension the chain as described on page 7. The log being cut must be clamped prior to sawing. Lowering the saw bar will allow the selector valve to shift starting the saw chain and pumping bar oil. Returning the saw to the up stop will stop the saw chain.

Parts and Service Information

For parts and service contact 6K Products. Our hours of operation are 8:00 AM to 4:30 PM, Monday through Friday, Pacific Time excluding holidays.

Phone: 360-264-2141

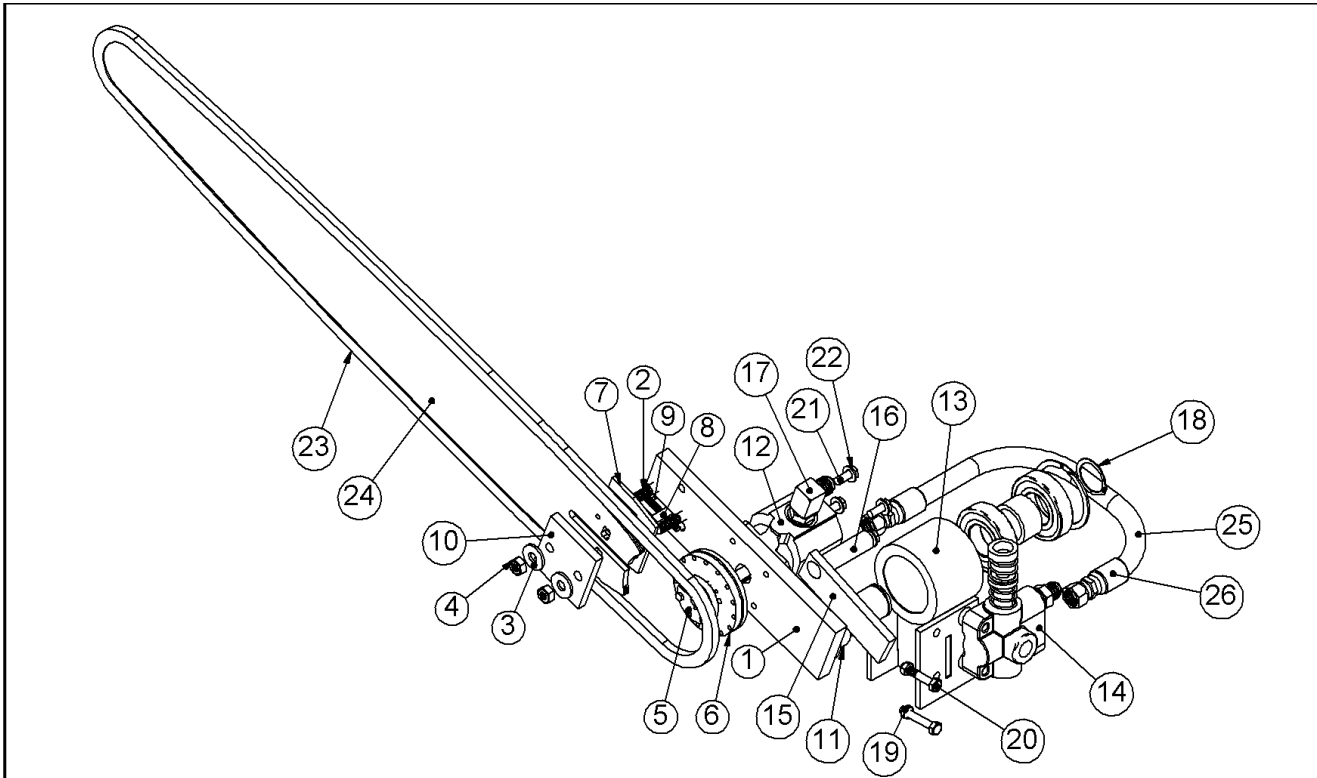
Fax: 360-264-5105

Email ed@6kproducts.com

Mail and shipping address:

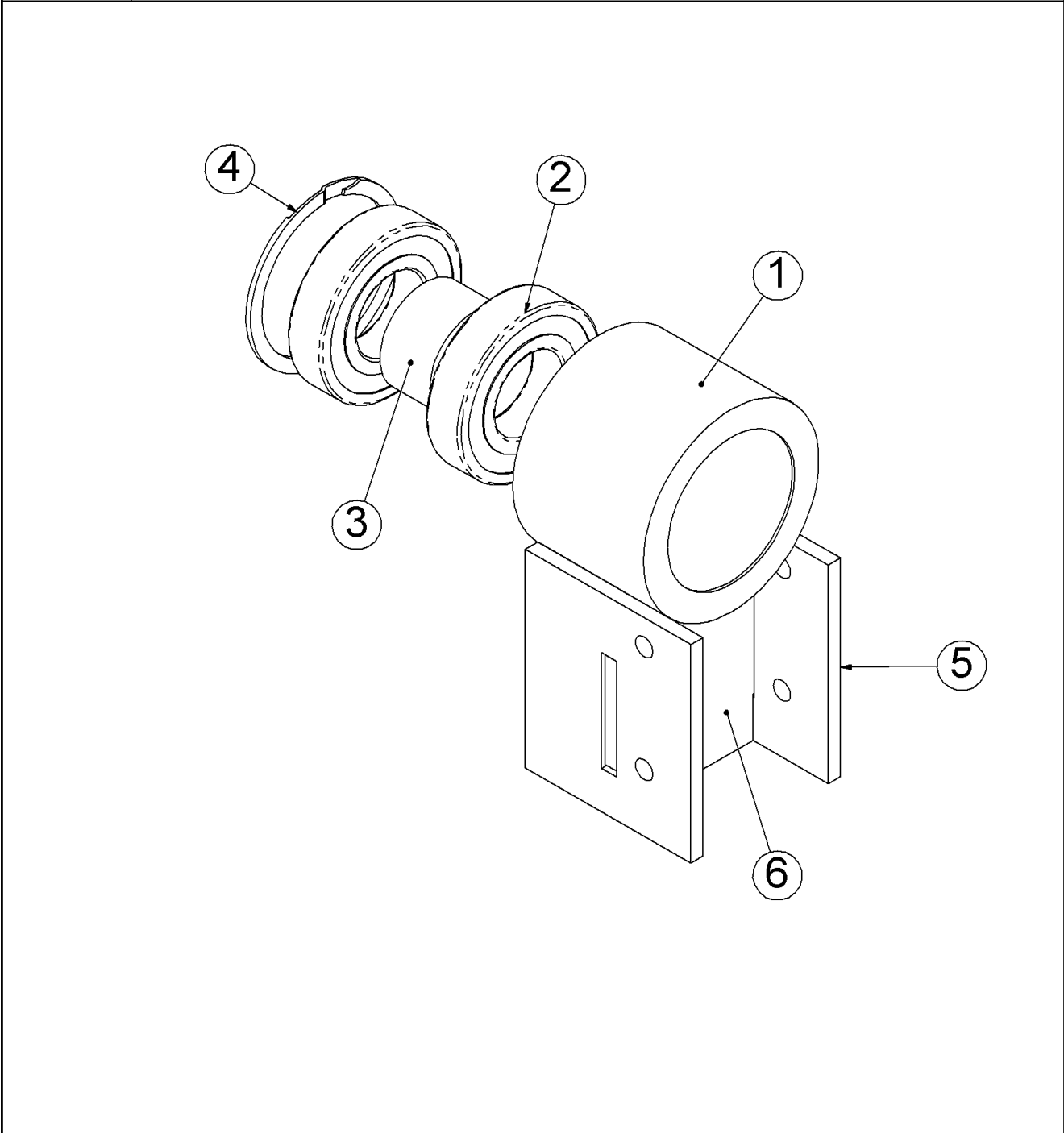
6K Products
1006 143rd Ave. S.E.
Tenino, WA 98589

DH0648 SIMPLE SAW ASSEMBLY



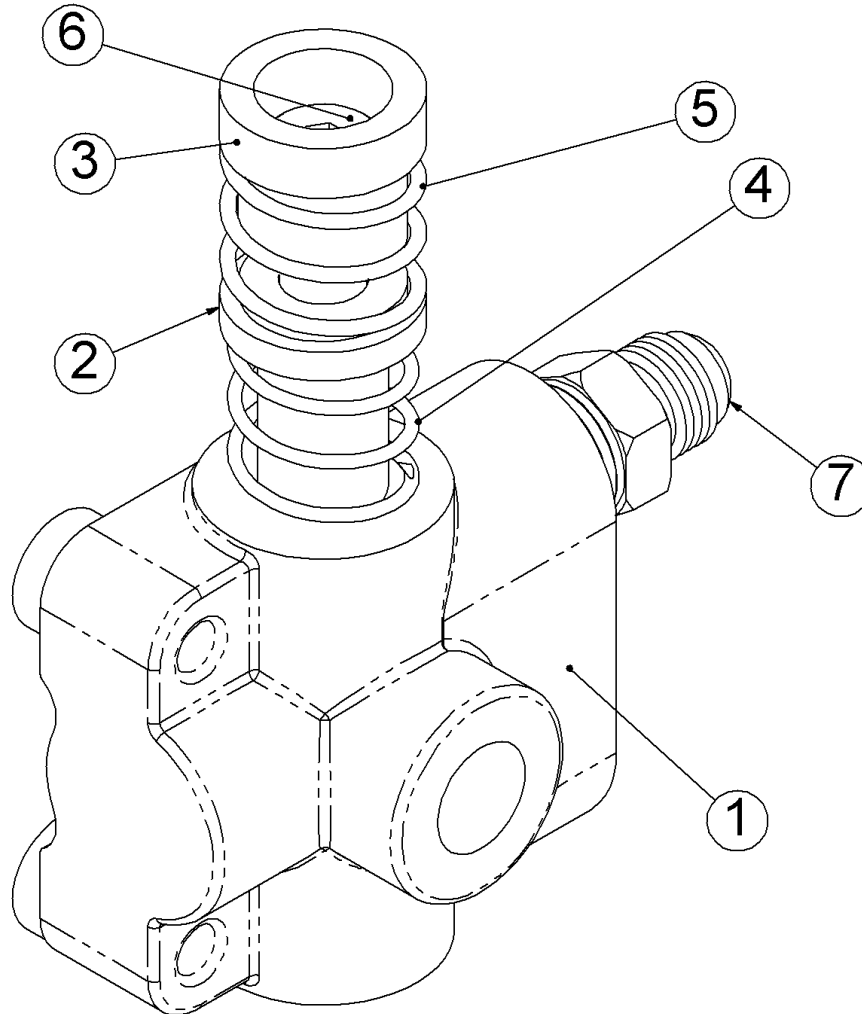
ITEM No.	QTY.	PART No.	DESCRIPTION	REMARKS
1	1	DH0231	BAR PLATE	
2	2	FST004	M10 X 1.5 X 42 STUD	
3	2	FMW100P	10MM REGULAR PLAIN WASHER	
4	2	FMN10CP	M10 X 1.5 NUT	
5	1	GM1000	QD-JA X 1/2 BUSHING	36 in lbf
6	1	DS0146	15T404TL SPROCKET	
7	1	DH0034	BAR SPACER	
8	1	DH0033	TENSION BAR	
9	1	FSM42P	1/4 -20 X 2 SS PAN HD PHILLIPS SCREW	
10	1	DH0122	CLAMP PLATE	
11	1	DH0126	PIVOT PIN	
12	1	VMH002	HALDEX MOTOR, VENDOR NO. 10566	
13	1	DH0235	PIVOT ASSEMBLY	
14	1	DH0238	SMALL SELECTOR VALVE ASSY.	
15	1	DH0241	STOP BAR	
16	1	DH0242	VALVE PIN	
17	2	HH0750	90° ADJUSTABLE MALE ORB TO JIC, 853-8-8	
18	1	FRS137	1.375 ø SHAFT, RETAINING RING	
19	2	FNC10S	5/16" NC STOVER NUT	
20	2	F8C105	5/16 X 1 3/4 GRADE 8 NC HEX HEAD CAP SCREW	
21	4	F8C101	5/16 X 3/4 GRADE 8 NC HEX HEAD CAP SCREW	
22	4	FWZ10H	5/16 HT WASHER	
23	1	DH0055	SAW CHAIN, 80 GAUGE, 89 DRIVE LINKS	
24	1	DH0066	HARVESTER BAR, 75 CM	
25	1	DH0143	MOTOR HOSE. 8M3K, 21"	
26	2	HFG118	HOSE END, #8 2 WIRE X #8 FJX	

DH0235 PIVOT ASSEMBLY



ITEM No.	QTY.	PART No.	DESCRIPTION	REMARKS
1	1	DH0127	PIVOT HOUSING	
2	2	B62R07	BALL BEARING, 6207-2RS	
3	1	DH0173	BEARING SPACER	
4	1	FRI283	SPIRAL RETAINING RING, WHM-283	
5	2	DH0236	VALVE PLATE	
6	1	DH0237	SPACER PLATE	

DH0238 SELECTOR VALVE ASSEMBLY



ITEM No.	QTY.	PART No.	DESCRIPTION	REMARKS
1	1	VH0001	CROSS 20 GPM SELECTOR VALVE	
2	1	DH0239	SPRING HEAD	
3	1	DH0240	SPRING HEAD	
4	1	FXC017	1.10 OD X 1.5 X .082 WIRE	
5	1	FXC018	1.18 OD X 1.53 X .091 WIRE	
6	1	FZS18S	1/2 X 1 SOCKET SHOULDER SCREW- STRIPPER BOLT	
7	1	HH0440	MALE JIC TO PIPE ADAPTER,816-8-8	