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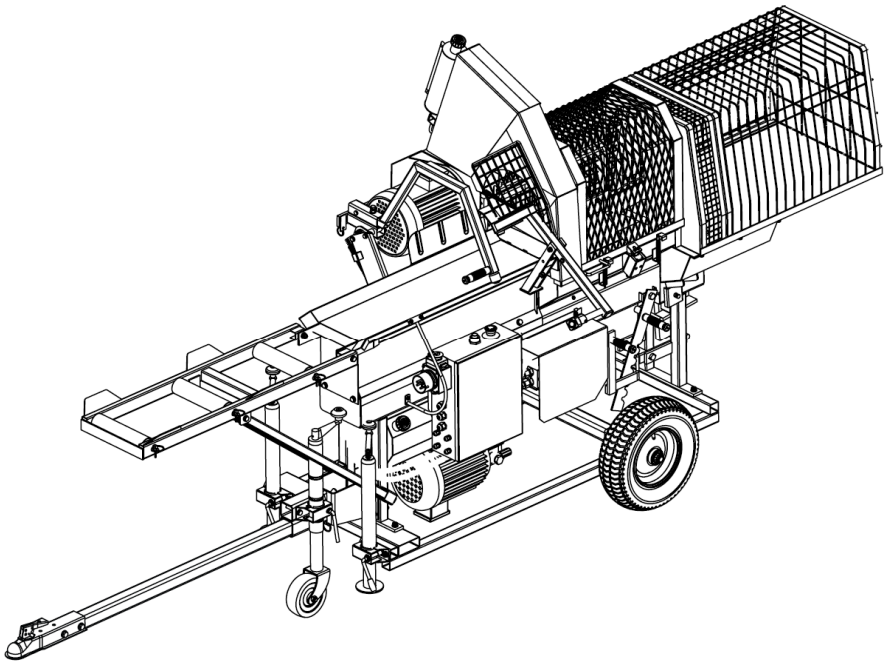


FOR YOUR SAFETY

READ AND UNDERSTAND THE ENTIRE MANUAL BEFORE OPERATING THE MACHINE

MODEL: VARIMATIC 300

SERIAL NUMBER:

Both model number and serial number may be found on the main label.
You should record both of them in a safe place for future use.

Save This Manual for Future Reference

WOOD PROCESSOR

Instructions for use (Original instructions for use) 2019

TABLE OF CONTENTS

INTRODUCTION

Your new wood processor will more than satisfy your expectations. It has been manufactured under stringent quality standards to meet superior performance criteria. You will find your new unit easy and safe to operate, and with proper care, it will give you many years of dependable service.

The wood processor is designed to cut and split large volumes of wood efficiently and safely. It consists of a log cutter and a log splitter. The log is cut to length, and a hydraulic ram pushes the cut portion against a cross wedge, which splits the log in 4 sticks.

Carefully read through this entire operator's manual before using your new wood processor. Take special care to heed the cautions and warnings.

RECYCLING AND DISPOSAL

This marking indicates that this product should not be disposed with other household wastes. To prevent possible harm to the environment or human health from uncontrolled waste disposal, recycle it responsibly to promote the sustainable reuse of material resources. To return your used device, please use the return and collection systems or check with your local authority or local stores for advice of environmental safe recycling.

SYMBOLS

The rating plate on your machine may show symbols. These represent important information about the product or instructions on its use.

Read these instructions in full before using the machine.

Wear eye protection.
Wear hearing protection.

Wear dustproof mask.

Wear safety footwear.

Wear safety gloves.

Keep your work space tidy!
Untidiness may result in accidents.

Do not remove or tamper with any protection or safety devices.

Don not smoke or have open flames.

Dispose of the used oil in an environment-friendly way.

Do not use in the rain.

Do not remove jammed logs with your hands.

Always pay full attention to the movement of the log pusher. Keep hands out of the way of all moving parts.

Do not attempt to load or unload logs until the log saw has stopped

Caution! Thrown objects.

Before starting any repairs, maintenance or cleaning, always disconnect the power.

Keep bystanders away from the working area.

SAFETY

SAFETY WARNINGS & INSTRUCTIONS

- **UNDERSTAND YOUR WOOD PROCESSOR**

Read and understand the owner's manual and labels affixed to the wood processor. Learn its application and limitations as well as the specific potential hazards peculiar to it. Be thoroughly familiar with the controls and their proper operation.

- **DRUGS, ALCOHOL AND MEDICATION**

Do not operate the wood processor while under the influence of drugs, alcohol or any medication that could affect your ability to use it properly.

- **AVOID DANGEROUS CONDITIONS**

Always operate your wood processor on dry, solid, level ground. Never operate your wood processor on slippery, wet, muddy or icy surfaces. The location you choose should be free from any tall grass, brush or other interferences. There should be plenty of room for handling, and help the operator stay alert. Keep your work area clean and well lighted. Cluttered areas invite injuries. To avoid tripping, do not leave tools, logs or other components lying around the work area. Do not use the wood processor in wet or damp areas or expose it to rain. Do not use it in areas where fumes from paint, solvents or flammable liquids pose a potential hazard.

- **INSPECT YOUR WOOD PROCESSOR**

Check your wood processor before turning it on. Keep guards in place and in working order. Form a habit of checking to see that keys and adjusting wrenches are removed from tool area before turning it on. Replace damaged, missing or failed parts before using it. Make sure all nuts, bolts, screws, hydraulic fittings, hose clamps, etc. are securely tightened. Always check the oil level in the hydraulic oil tank. Never operate your wood processor when it is in need of repair or is in poor mechanical condition. Before starting work, test the stopping devices to keep them in safe working condition.

- **DRESS PROPERLY**

Do not wear loose clothing, gloves, neckties or jewellery (rings, wrist watches). They can be caught in moving parts. Protective, electrically non-conductive gloves, non-skid footwear, hearing protection and dustproof mask are recommended when working. Wear protective hair covering to contain long hair, preventing it from get caught in machinery.

- **PROTECT YOUR EYES AND FACE**

Any wood processor may throw foreign objects into the eyes. This can cause permanent eye damage. Always wear safety goggles. Everyday eyeglasses have only impact resistant lenses. They are not safety glasses.

- **EXTENSION CORDS**

Improper use of extension cords may cause inefficient operation of the wood processor, which can result in overheating. Be sure the extension cord is not longer than 10 m and its section is not less than 2,5 mm^2 to allow sufficient current flow to the motor. Avoid use of free and inadequately insulated connections. Connections must be made with protected material suitable for outdoor use.

- **AVOID ELECTRICAL SHOCK**

Check that the electric circuit is adequately protected and that it corresponds with the power, voltage and frequency of the motor. Check that there is a ground connection. Ground the wood processor. Prevent body contact with grounded surfaces. Never open the electric box. Should this be necessary, contact a qualified electrician. Make sure your fingers do not touch the plug's metal prongs when plugging or unplugging the wood processor.

- **PREVENT FIRES**

Do not smoke or have open flames when operating or refilling the wood processor. Never operate the wood processor near a flame or candle. Oil is flammable and can explode.

- **KEEP BYSTANDERS AWAY**

Allow only one person to load and operate the wood processor. Always keep bystanders, including visitors, children and pets away from the work area, especially when the wood processor is under operation. Only the operator should stand near the machine and only within the safe operating area prescribed in this manual. Never use another people to help you with freeing jammed log. No one under the age of 18 should be allowed to operate the wood processor. Any individual to operate the wood processor should have the necessary training, skills to perform the functions properly and safely.

- **INSPECT YOUR LOG**

Never attempt to cut or split logs containing nails, wire or debris. Always make sure that both ends of the log you are splitting are cut as square as possible. Branches must be cut off the trunk.

- **DON'T OVERREACH**

Keep proper footing and balance at all times. Never stand on wood processor. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted. Do not store anything above or near the wood processor where anyone might stand on the tool to reach it.

- **AVOID INJURY FROM UNEXPECTED ACCIDENT**

Do not attempt to load or unload logs until the log saw has stopped. Keep hands out of the way of all moving parts. Never use a damaged saw blade or chain. Do not reach around the saw blade with either hand while the cutter is running. Do not stand or have any part of your body in line with the path of the saw blade. Avoid awkward cutting operations and hand positions where a sudden slip could cause your hand to move into the saw blade. Never pile logs to be split in a manner that will cause you to reach across the log saw. Only use your hands to operate the control handle. Never use your foot, knee or any other extension device. Never attempt to free a stalled saw chain without first turning the log saw off.

- **PROTECT YOUR HANDS**

Keep your hands away from splits and cracks which open in the log. They may close suddenly and crush or amputate your hands. Do not remove jammed logs with your hands.

- **DON'T FORCE TOOL**

It will do a better and safer job at its design rate. Don't use wood processor for a purpose for which it was not intended. Do not alter the equipment, or use the equipment in such a way as to circumvent its design capabilities and capacities. Never try to split logs larger than those indicated in the specifications table.

- **DISCONNECT POWER**

Unplug when not in use, before making adjustments, changing parts, cleaning or working on the wood processor. Consult technical manual before servicing.

- **NEVER LEAVE TOOL RUNNING UNATTENDED**

Don't leave tool until it has come to a complete stop.

- **MAINTAIN YOUR WOOD PROCESSOR WITH CARE**

Before cleaning, repair, inspecting or adjusting, shut off the machine and make certain all moving parts have stopped. Always clean the unit after each use. Keep the wood processor clean for best and safest performance. Follow instructions for lubricating. Inspect all hydraulic seals, hoses and couplers for leaks prior to use. Control levers and power switch must be kept clean, dry and free from oil and grease at all times.

- **PROTECT THE ENVIRONMENT**

Take used oil to an authorized collection point or follow the stipulations in the country where the wood processor is used. Do not discharge into drains, soil or water.

- **MAKE THE WORKSHOP CHILDPROOF**

Lock the shop. Store the wood processor away from children and others not qualified to use it.

- **DEAL WITH ACCIDENT**

Always have a fire extinguisher and a first aid kit available for use should the need arise. In emergency always know the location of the nearest phone or keep a phone on the job site. Also know the phone numbers of the nearest ambulance, doctor and fire department. This information will be invaluable in the case of an emergency.

- **SPECIAL WARNING**

- The splitting operation of the machine is designed to be activated by one person. While there is the possibility that additional operators could be working with the machine (e.g. for loading and unloading), only one operator should activate splitting operations;
- The machine shall not be used by children;
- Description of functional tests of the machine;
- The installation and maintenance requirements including a list of those devices e.g. two-hand control device which should be verified, how frequently the verification shall be carried out and by what method.

SPECIFICATIONS

Model number		**65638**
Trade Name		**VARIMATIC 300**
Splitter Motor		5000 W 400 V 3~ 50 Hz 9,1 A S6 40 % IP54
Splitting Force		7 ton ± 10 %
Splitting Capacity	**Diameter**	5-30 cm
	Length	20-55 cm
Hydraulic Pressure		17,8 MPa
Hydraulic Oil Capacity		18 l
Ram Travel		94,5 cm
Speed	**Forward**	32 cm/s
	Retract	110 cm/s
Chain Saw Motor		4000 W 400 V 3~ 50 Hz 7 A S6 40 % IP54
Cutting Capacity	**Diameter**	5-30 cm
	Length	30-110 cm
Noise Pressure Level (LpA)		≤ 109 dB (A)
Vibration		3 m/s^2
Overall Sizes (LxWxH)		289 x 93 x 165 cm
Weight		353 kg

** S6 40%, continuous operation periodic duty: time of one load cycle is 10 minutes, operation time at constant load is 4 minutes, operation time at no-load is 6 minutes.*

APPLICATION CONDITIONS

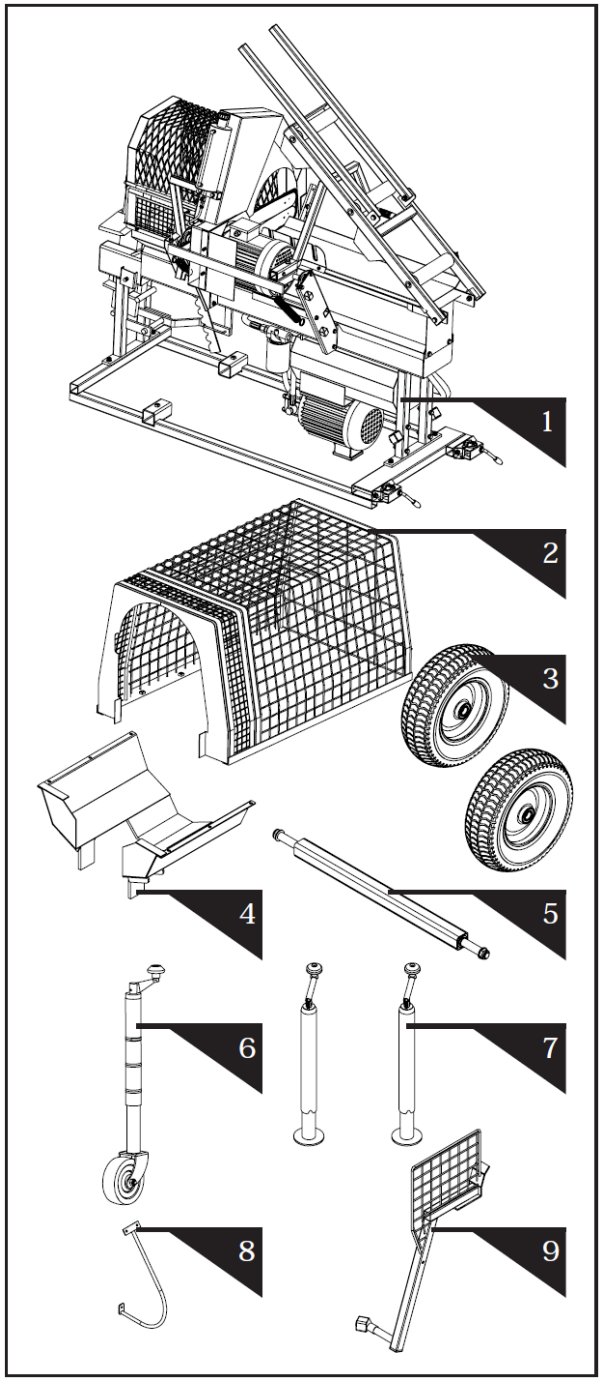
This wood processor is designed for operating under ambient temperatures between +5℃ and +40℃ and for installation at altitudes not more than 1000 m above M.S.L. The surrounding humidity should be less than 50 % at 40℃. It can be stored or transported under ambient temperatures between –25℃ and +55℃.

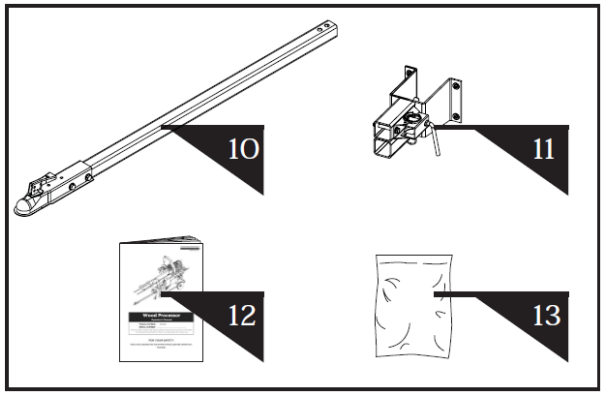
ELECTRICAL REQUIREMENTS

With 3 phase 400 Volt / 50 Hz motor, the wood processor should be connected to standard 400 V ± 10 % / 50 Hz ± 1 Hz electrical supply which has protection devices of under-voltage, over-voltage, over-current as well as a residual current device (RCD) with maximum residual current rated at 0,03 A.

The mains connection and extension cable must have 5 wires = 3P + N + PE (3/N/PE). The mains connection must have maximum 8 (saw) / 10 (splitter) A fuse. Electrical connection rubber cables must comply with IEC 60245, which are always marked with symbol H 07 RN. Cables should be identified, as it is a legal requirement. The cable is not supplied with the machine.

CONTENTS SUPPLIED

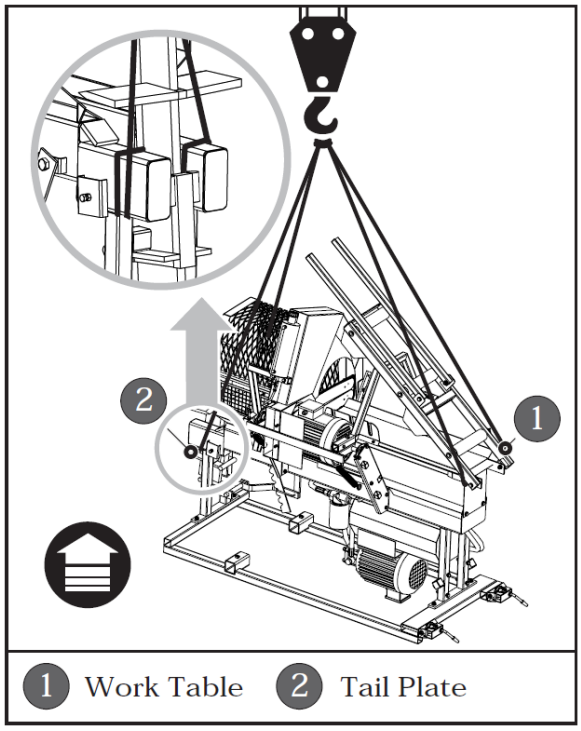




1. Main body
2. Protecting wire net
3. Transport wheel
4. Side rail
5. Wheel shaft
6. Nose wheel
7. Support leg
8. Bent bar
9. Log lock handle
10. Processor coupler assembly
11. Connecting piece
12. Operator's manual
13. Hardware bag

ASSEMBLY

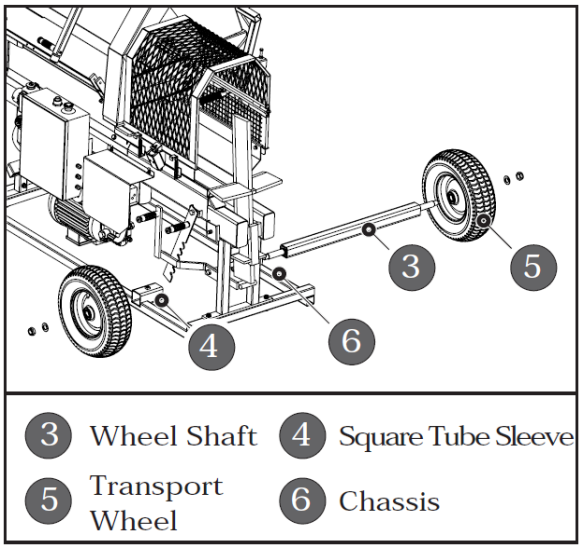
Following the assembly directions below, you will assemble the wood processor in a few minutes.

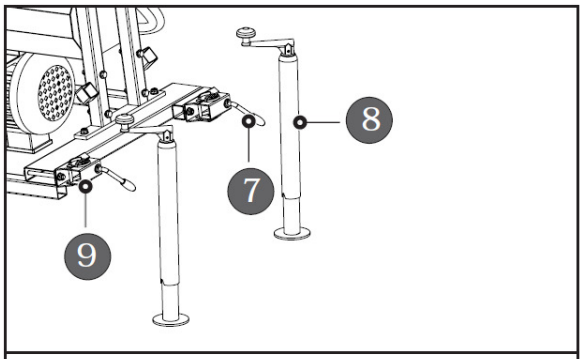


The processor can be lifted with ropes suitable to support its weight. When lifting the machine, firmly tie up the ropes at work table (1) and tail plate (2).

When the processor is lifted, there is a danger of its falling down. Therefore, never come too close.

Insert the wheel shaft (3) to square tube sleeve (4) as shown. Secure the transport wheels (5) on both sides of the wheel shaft with two washers and M20 lock nuts. Adjust the transport wheels on both sides of the chassis (6) to a proper position and secure the wheel shaft on square tube sleeve with two M10x25 bolts and M10 lock nuts.

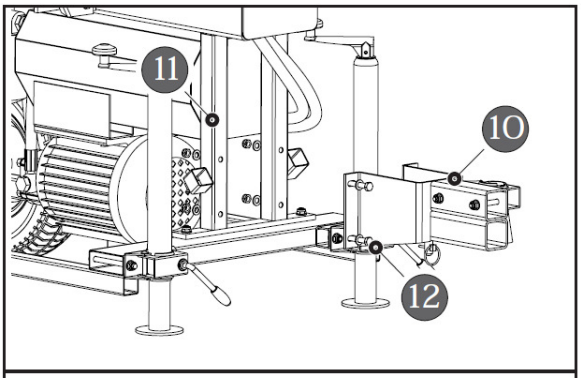




7 Locking Handle 8 Support Leg
9 U-clamp

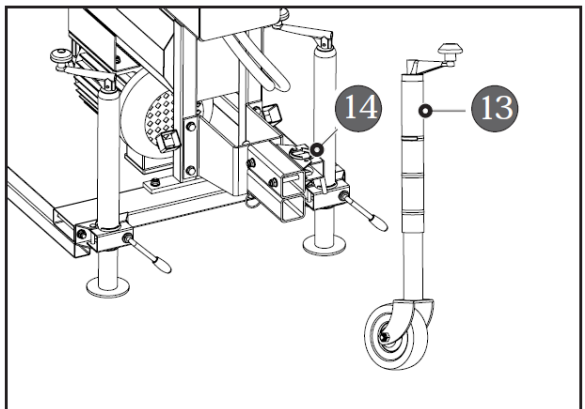
Loosen the locking handles (7) in the anticlockwise direction. Install the support legs (8) to U-clamps (9). Fasten the locking handles in the clockwise direction. Lower the machine on the ground and release the ropes. Loosen the locking handles in the anti-clockwise direction to adjust the support legs on the same level of the transport wheels until processor is level. Fasten the locking handles in the clockwise direction.

⚠	The support legs can be lowered to stand on the ground during the work and lifted to the air during the transportation.



10 Connecting piece 11 M10X60 bolt
12 M10 Lock Nut
Washer 10

Fasten the connecting piece (10) to the front stand with M10x60 bolts (11), M10 lock nuts and washers (12).

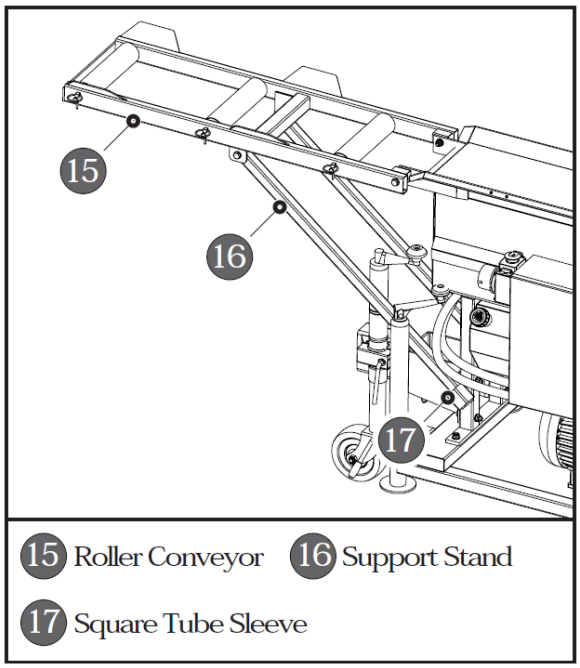


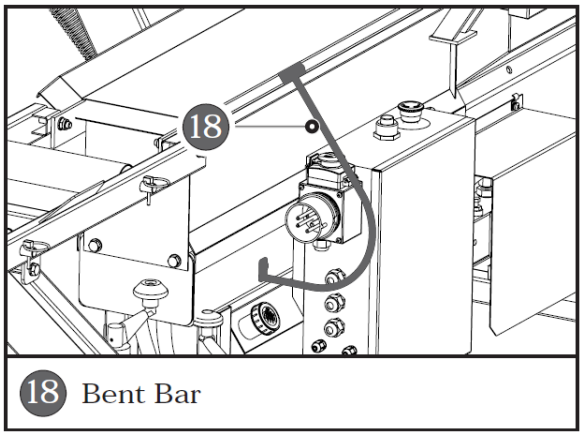
13 Nose Wheel 14 U-clamp

Install the nose wheel (13) to U-clamp (14) and adjust it on the same level of the transport wheels and support legs. Fasten the locking handle in the clockwise direction.

⚠	The nose wheel can be lowered to the ground for minor moving of the processor and should be lifted to the air during the work and transportation.

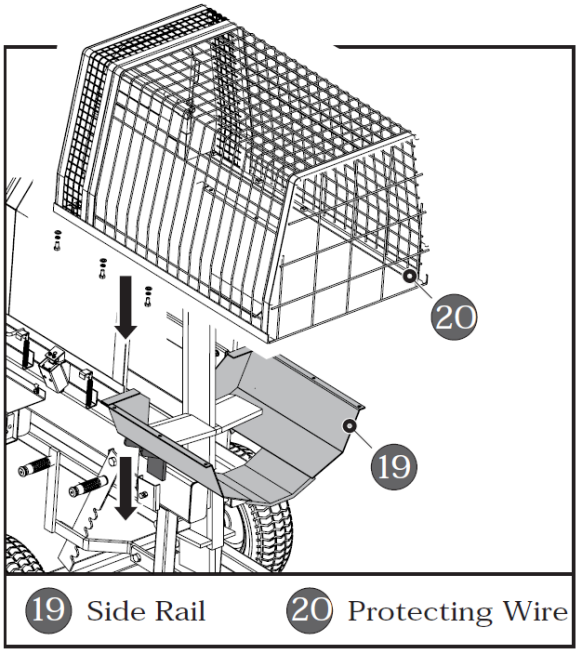
Unfold the roller conveyor (15) horizontally and fix the support stands (16) to square tube sleeves (17) as shown.

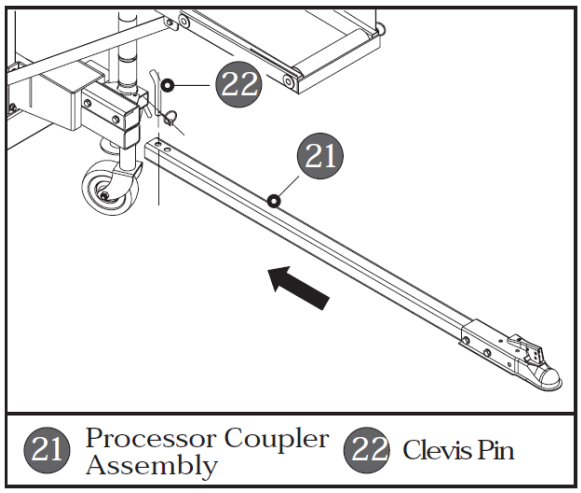




Fix the bent bar (18) to machine case and machine body with three pieces of M16x10 screws as shown.

Insert the side rail (19) to U-type groove and fix it. Fasten the protecting wire net (20) onto the side rail (19) with washers, bolts and nuts.





Install the processor coupler assembly (21) into the connecting piece. Line up the holes in the processor coupler assembly and the connecting piece. Insert the clevis pin (22) through the holes in the processor coupler assembly and the connecting piece. Insert lock pin through the hole in the clevis pin to secure it.

⚠	The installation of the processor coupler assembly is only necessary for transportation. It should be detached from the processor in work.

DELIVERING WOOD PROCESSOR TO WORK SITE

For long-distance transportation, complete the installation of the processor coupler assembly. Connect the coupler to tow vehicle's trailer hitch. Lift the support legs and nose wheel to the air and drive tow vehicle to work site. Please pay attention that nose wheel should be off the ground during transportation. Position the processor in the selected location and then disconnect the coupler from tow vehicle's trailer hitch. Drive tow vehicle clear. Detach the processor coupler assembly. Adjust the support legs until processor is level.

⚠ The machine is not approved for travelling on roads and public areas. Transportation of the machine using a towing vehicle is not permitted on roads and public areas.

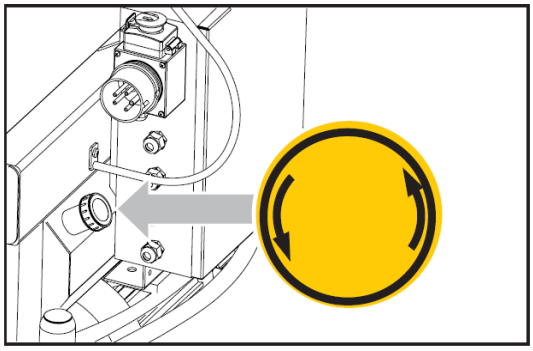
For minor moving at work site, lower the nose wheel to the ground and lift the support legs off the ground. Move the processor by nose wheel and transportation wheels for relocation. And then adjust the support legs until processor is level and lift the nose wheel off the ground. Block the transportation wheels firmly so the processor cannot roll in either direction.

OPERATION

Plan your work site. Work safely and save effort by planning your work beforehand. Have your logs positioned where they can be easily reached. Have a site located to stack the split wood or load it onto a nearby truck or another carrier. Position the wood processor on solid level ground.
Applying a thin coat of grease to the surfaces of the ram before operation will lengthen the durability of the ram.

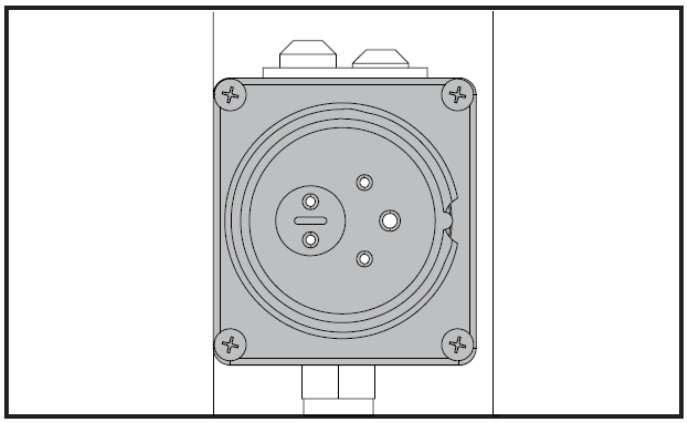
Test whether the emergency stop switch functions properly. Once the emergency stop switch is pushed down, pressing down the button switches on the log lock handle and the log saw handle simultaneously cannot activate the rotation of the chain saw to cut wood and pushing down the cylinder control switch on the electric box cannot activate the push block into forward stroke to split wood, although the machine is still in power.
Turn the emergency stop switch in the clockwise direction and return to its original position. Press down both of the button switches simultaneously, and the chain saw returns to its normal cutting rotation. Push down the cylinder control switch on the electric box, the push block returns to its normal splitting movement.

Bleed the air out of the hydraulic system before starting the wood processor. The cover of the hydraulic oil tank should be loosened by some rotations until air can go in and out of the oil tank smoothly.
Air flow thru the oil tank filler should be detectable during the operations.
Before moving the wood processor, make sure the cover of the oil tank is tightened to avoid oil leaking from this point.



FAILED TO LOOSEN THE OIL TANK COVER WILL KEEP THE SEALED AIR IN HYDRAULIC SYSTEM BEING COMPRESSED AFTER BEING DECOMPRESSED. SUCH CONTINUOUS AIR COMPRESSION AND DECOMPRESSION WILL BLOW OUT THE SEALS OF THE HYDRAULIC SYSTEM AND CAUSE PERMANT DAMAGE TO THE WOOD PROCESSOR.

Turn the motor switch to the ON position to start the wood processor. To stop the machine, just turn the motor switch to the OFF position.

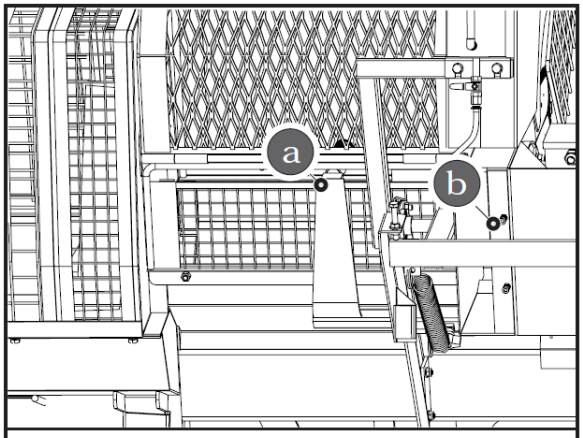


Make sure the direction of motor rotation is correct. Turn the motor on and hold the log saw handle and the log lock handle respectively with each hand and press down the button switches C/D on both handles simultaneously to activate the rotation of the chain saw.

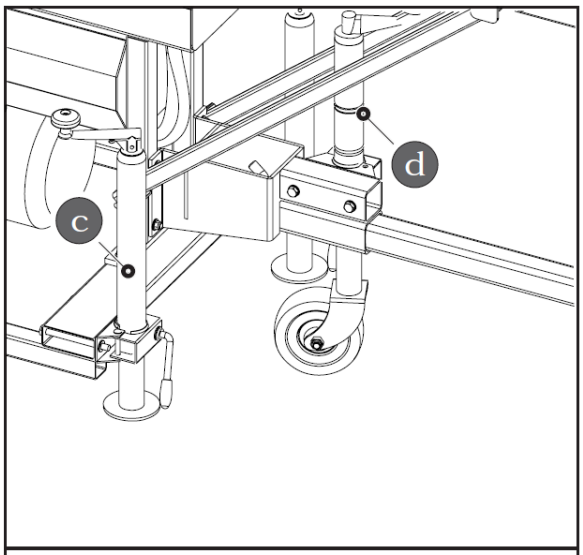
If no rotation motion is detected after the motor starts, power off the motor immediately to change motor polarity by turning the pole switching device inside the plug with a screwdriver.

400 V 3N

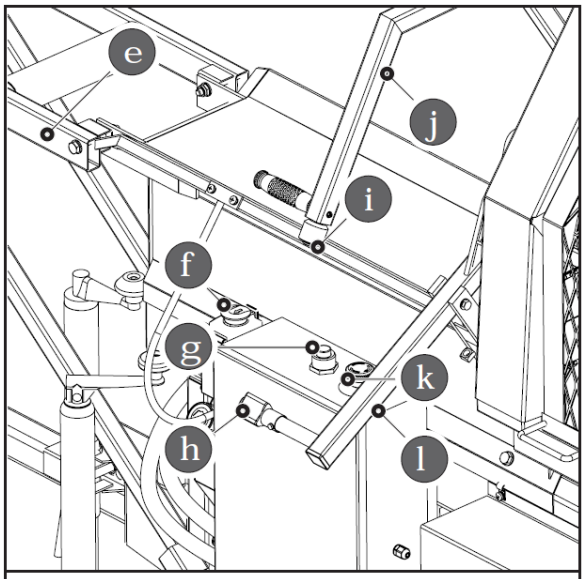
Never allow motor running at counter direction. This will damage the pump and will void the warranty.



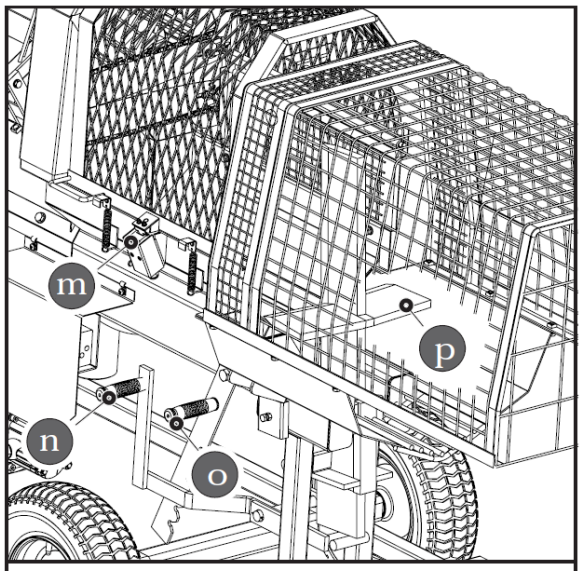
a Cut-off Length Gauge
b Chain Tension Bolt



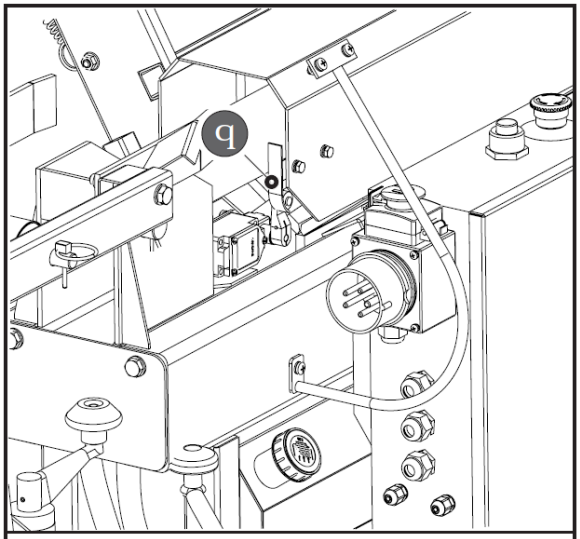
c Support Leg
d Nose Wheel



e Roller Conveyor
f Motor Switch
g Cylinder Control Switch
h Button Switch D for Log Lock Handle
i Button Switch C for Log Saw Handle
j Log Saw Handle
k Emergency Stop Switch
l Log Lock Handle



m Limit Switch A for steel mesh
n Wedge Lock Handle
o Wedge Adjusting Handle
p Cross Wedge



q Limit Switch B for cylinder backstroke

1. Test whether the emergency stop switch functions properly. Once the emergency stop switch is pushed down, pressing down the button switches on the log lock handle and the log saw handle simultaneously cannot activate the rotation of the chain saw to cut wood and pushing down the cylinder control switch on the electric box cannot activate the push block into forward stroke to split wood, although the machine is still in power.
2. Turn the emergency stop switch in the clockwise direction and return to its original position. Press down both of the button switches simultaneously, and the chain saw returns to its normal cutting rotation. Push down the cylinder control switch on the electric box, the push block returns to its normal splitting movement.
3. After assembly, make sure that all the parts are tight to exclude dangerous factors.
4. Take the use of the correct power supply and cables. Put the plug in the socket and turn on the motor switch. Close the steel mesh, insert the key (part of the steel mesh) into the limit switch A for steel mesh, hook the steel mesh.
5. Place the log on the roller conveyor and adjust the log cut length by the cut-off length gauge. Hold the log saw handle and the log lock handle respectively with each hand and press down the button switches C/D on both handles simultaneously to activate the rotation of the chain saw. Press down evenly until the log is sawed and dropped right into position in the splitting area. Release the button switches C/D to stop the chain saw which returns to its original position automatically.

Do not start the day with a dull or damaged chain. If the chain is loose, turn the chain tension bolt in the clockwise direction to tighten it. Grease the chain saw mount every 4 to 6 hours of operation.

6. Lock the cross wedge to the proper position by the wedge adjusting handle and the wedge lock handle based on the log's size. Check whether the sawed log that drops into the splitting area needs to be repositioned. If necessary, open the steel mesh to place the sawed log to the proper position for splitting and then hook the steel mesh to hold down the limit switch.
7. Push down the cylinder control switch on the electric box and activate the hydraulic driven push block into forward stroke. The log is pushed against the cross wedge which splits the log in 4 sticks. After forward stroke is completed, the push block returns to fully retracted position automatically, which activates the limit switch B for cylinder backstroke to make the hydraulic system idle. Take off the split log and clean the splitting area.

Applying a thin coat of grease to the surfaces of the push block before operation will lengthen the durability of the push block. Good maintenance keeps the push block sliding smoothly for efficient operation and reduced wear.

Log splitter is equipped with auto cycle valve for hands-free operation. With auto-cycle valve engaged, splitter automatically completes forward stoke and returns to fully retracted position.

Stay clear of the wedge area once a log begins to split.

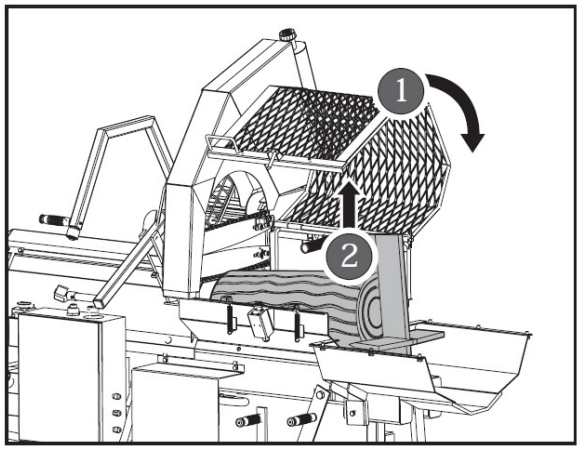
Keep hands away from the splitter during the return stroke.

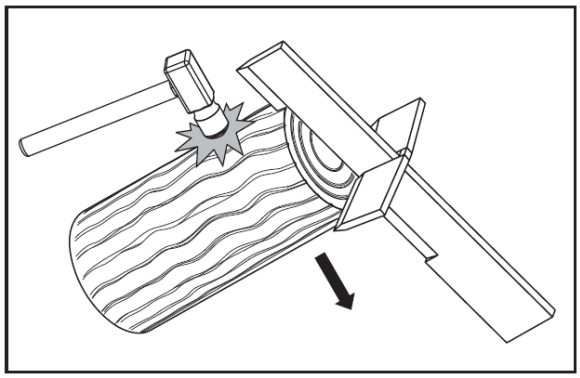
8. Continue next cycle until the work is accomplished. To stop the machine, detach the key and open the steel mesh. Turn the motor switch off and put the plug out of the socket and clean the machine with cloth.

Stack as you work. This will provide a safer work area, by keeping it uncluttered, and avoid the danger of tripping, or damaging the power cord.

Accumulated split wood and wood chips can create a hazardous work environment. Never continue to work in a cluttered work area which may cause you to slip, trip or fall.

FREE A JAMMED LOG



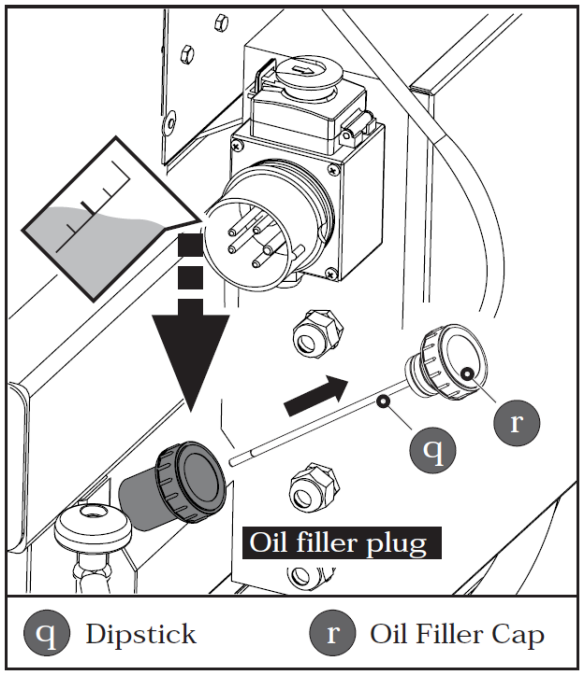


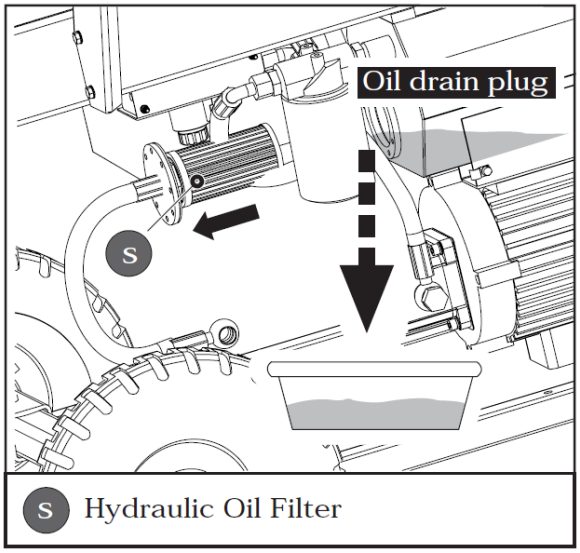
Open the main steel mesh, dismantle the protecting wire net and take out the jammed log and cross wedge.
Knock the jammed log with a hammer off the cross wedge.
Put the cross wedge into the groove.

REPLACING OIL

The hydraulic system is a closed system with oil tank, oil pump and control valve. Low oil levels can damage the oil pump.
Check oil level regularly with dipstick. The oil should be completely changed once a year.

Following hydraulic oils or equivalent are recommend for the wood processor's hydraulic transmission system:
SHELL Tellus 22
MOBIL DTE 11
ARAL Vitam GF 22
BP Energol HLP-HM 22
Mogul/Paramo OTHP 3

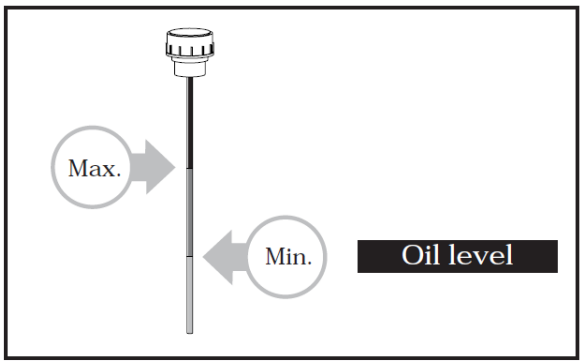




Use a drain pan to aid in the removal of all used oil and particles.

Dismantle hydraulic oil filter to take out filter net, lift nose wheel, and place a drain pan under oil outlet to drain oil from the hydraulic transmission system. Examine oil for metal chips as a precaution to future problems.

Plan to replace hydraulic filters every 150 hours of operation (roughly monthly).
Changing hydraulic oil filter regularly can help keep the processor running well and reduce downtime.



Read dipstick to determine the maximum and minimum of the oil level. Low oil can damage the oil pump. Overfilling can result in excessive temperature in the hydraulic transmission system.

Apply sealant to filler plug and reinstall it.
Following an oil change, activate the wood processor a few times without actually cutting or splitting.

MAINTENANCE

Maintaining your wood processor will insure long life to the machine and its components.

Preventive Maintenance

Inspect the general condition of the wood processor. Check for loose screws, misalignment or binding of moving parts, cracked or broken parts, and any other condition that may affect its safe operation. Remove all debris from the wood processor with a soft brush, vacuum or compressed air.

Never use a pressure washer to clean your wood processor. Water can penetrate tight areas of the unit and cause damage to its components. The use of pressure washers will result in shortened life and reduce serviceability.

Make maintenance a regular part of daily operation. Check:

- Hydraulic oil and hydraulic oil filter for refill or replacement.
- Cutting chain condition – sharpen or replace a dull or damaged chain.

Sharpening Chain

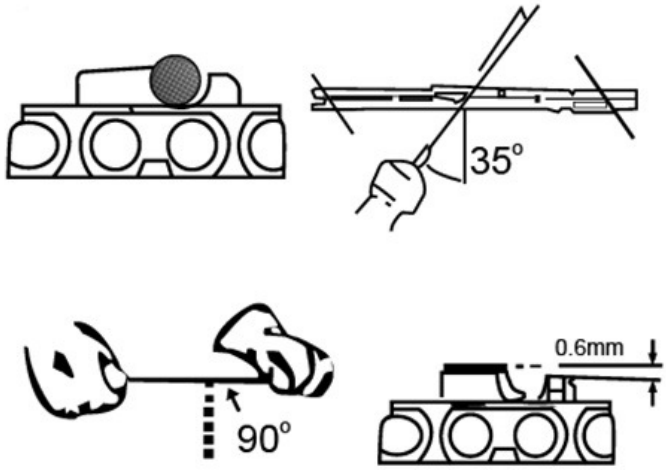
Disconnect the cable from the mains connection. Put on protective gloves.

Use a round file with a diameter corresponding to 1,1x height of the tooth. File under the horizontal angle of 35° against the guide plate. File only in the direction from the inner side of the tooth towards the outer side.

Sharpen each tooth equally using the same number of moves.

File under the angle of 90° against the guide plate.

Check the safe height of the tooth after each fifth sharpening. Use a toothe height gauge to check the tooth height.



- Splitting wedge condition – sharpen a blunt wedge.

Sharpening Wedge

This wood processor is equipped with reinforced splitting wedge which blade is specially treated. After long periods of operation, and when required, sharpen the wedge using a fine-toothed file removing any burrs or flat spots on the edge.

- Hydraulic line condition – keep track of wear; save on downtime by replacing hoses before they fail.
- Nuts, bolts, and fittings – make sure all are tight and secure.
- Welds – check high-stress joints.
- Cut off length gauge – adjust if necessary.

STORAGE

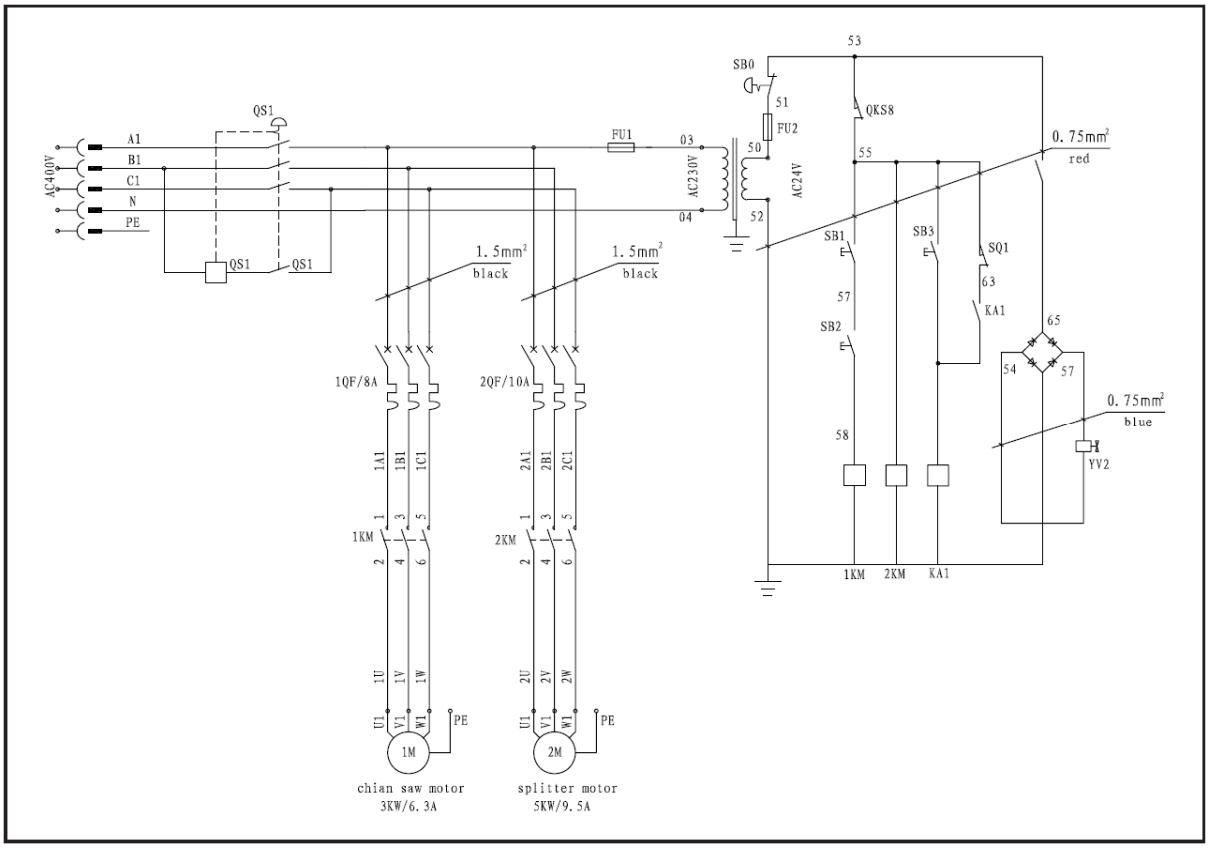
Store your unit on flat ground in a clean and dry building that has good ventilation. Never store the machine out of doors, because its sensitive electric appliances may get damaged. Use clean cloths to clean off the outside of the machine and keep the air vents free of obstruction.

TROUBLESHOOTING

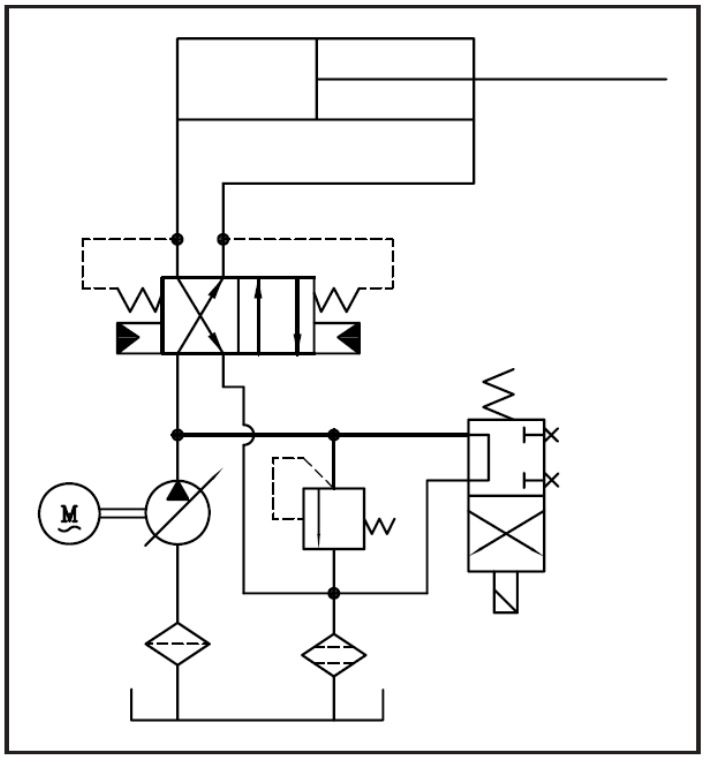
PROBLEM	PROBABLE CAUSE	REMEDY SUGGESTED
Motor does not start	No current in the socket	Check mains fuse
	Electrical extension line defective	Unplug, check and replace
	Switch or capacitor defective	Have checked by electrician
	The key is not inserted into limit switch A or limit switch A is broken	Insert the key into limit switch A or replace limit switch A
Incorrect motor rotation direction	Incorrect connection	Change pole switching device in the plug with a screwdriver
		Reverse polarity by electrician
Wood processor does not work while motor running	Valve is not opened owing to the connection parts loosening	Check and tighten the parts
	Connection parts bent	Repair the bent parts
	Lower hydraulic oil level	Check and refill hydraulic oil
Cylinder works with abnormal vibration and noise	Lower hydraulic oil level	Check and refill hydraulic oil
Chain saw works with abnormal vibration and get worn easily	Chain tension bolt gets loose	Clockwise to tighten up
	Insufficient supply of lubrication oil	Check and refill lubrication oil
Insufficient splitting pressure	Oil relief valve sets up insufficient pressure	Turn pressure-adjusting knob to sufficient pressure
	Cylinder is leaking inside	Replace piston seal or cylinder
	Hydraulic pump supplies insufficient pressure	Repair or Replace hydraulic pump
	Big resistance for oil suction	Check filter to clean or replace filter net
Log Saw cannot start	Button switch C for log saw handle or button switch D for log lock handle is broken	Repair or replace button switches
The circuit breaker of pump motor is tripped off	Blocked cylinder movement with high pressure	Check and clear the foreign object on the slideway or replace the deformed slideway

ATTENTION: ALL REPAIR WORK MUST BE DONE BY A SPECIALIST FOR THIS PRODUCT.

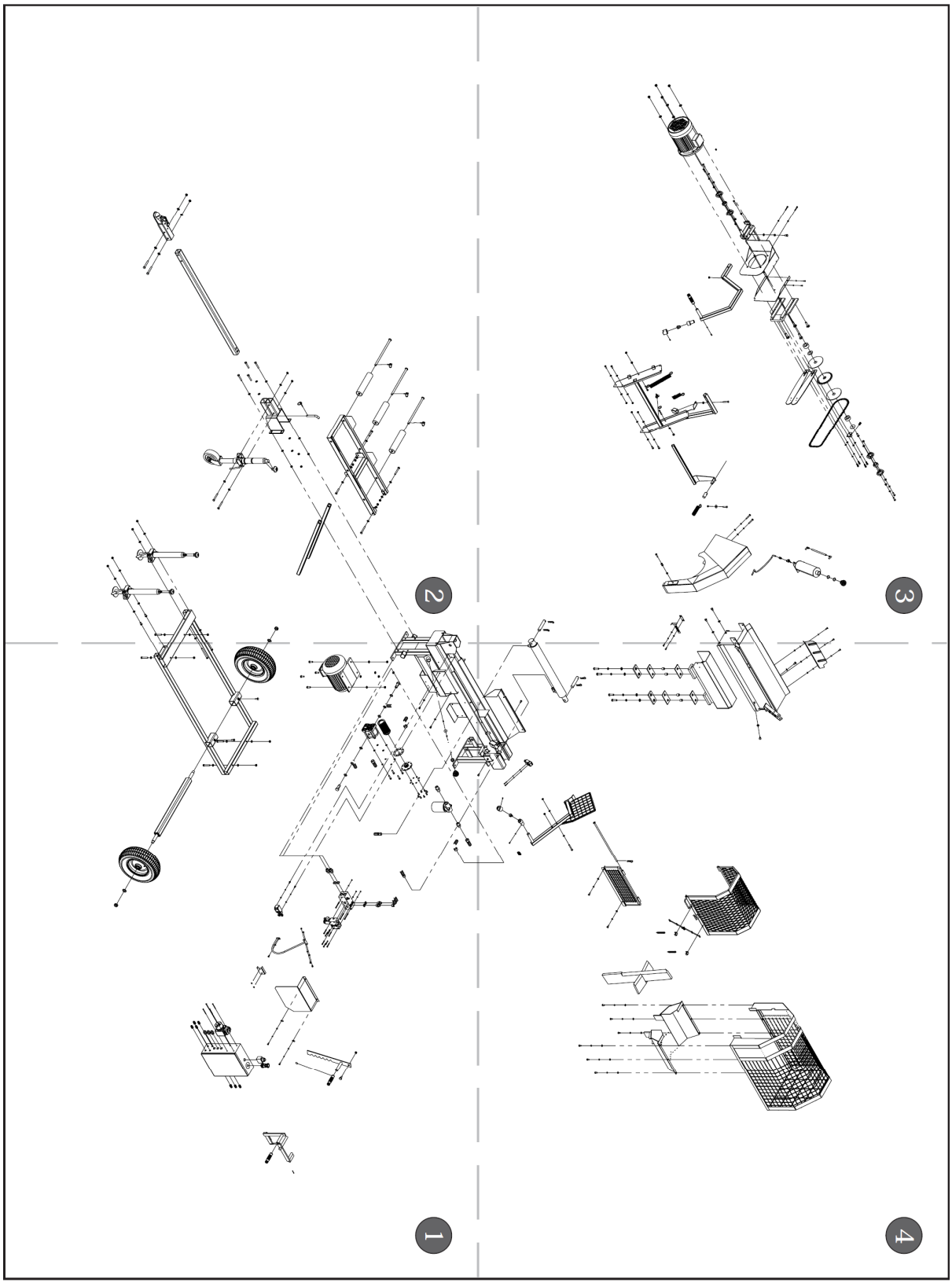
WIRING DIAGRAM

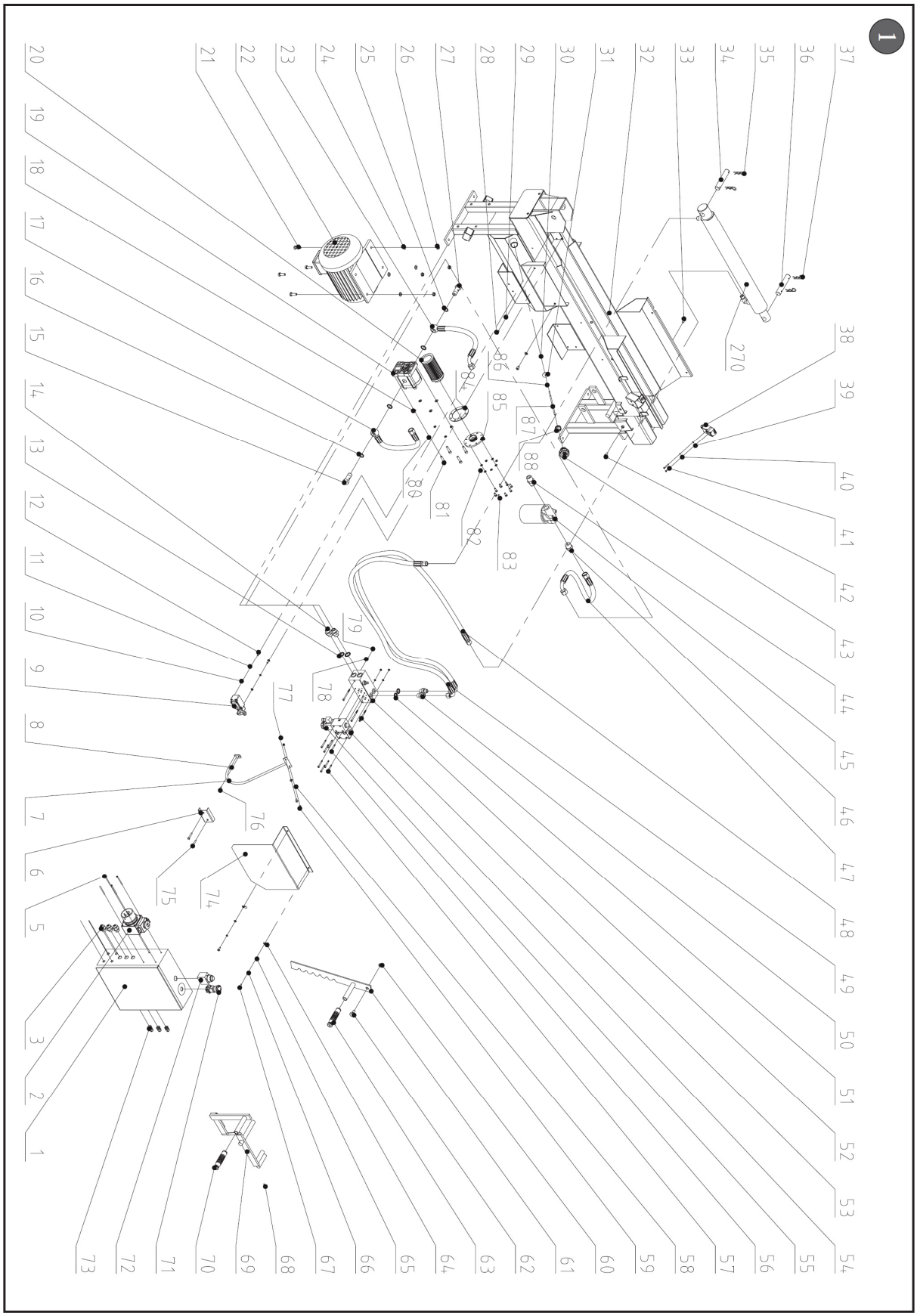


PLUMBING DIAGRAM



PART LIST

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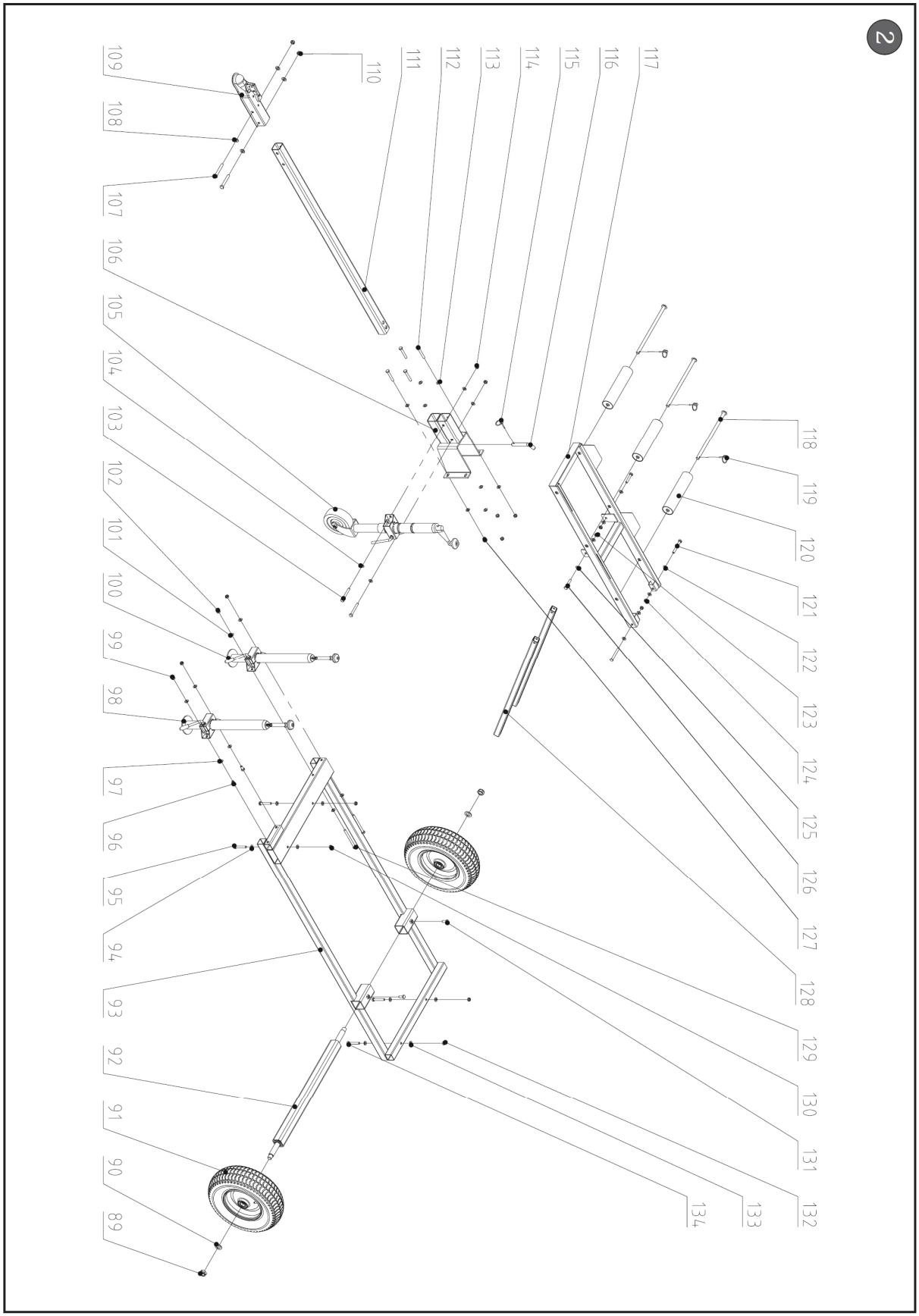
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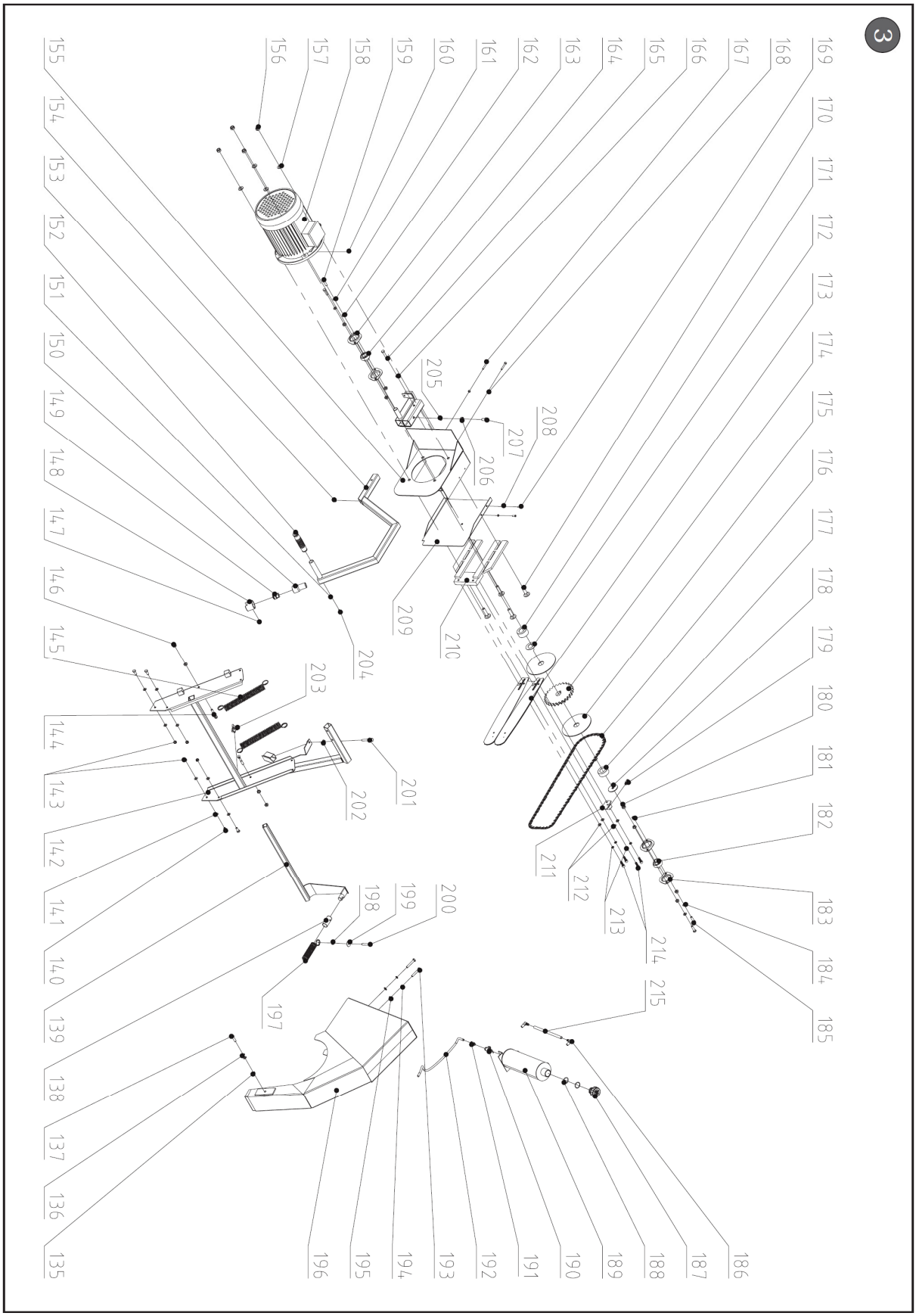
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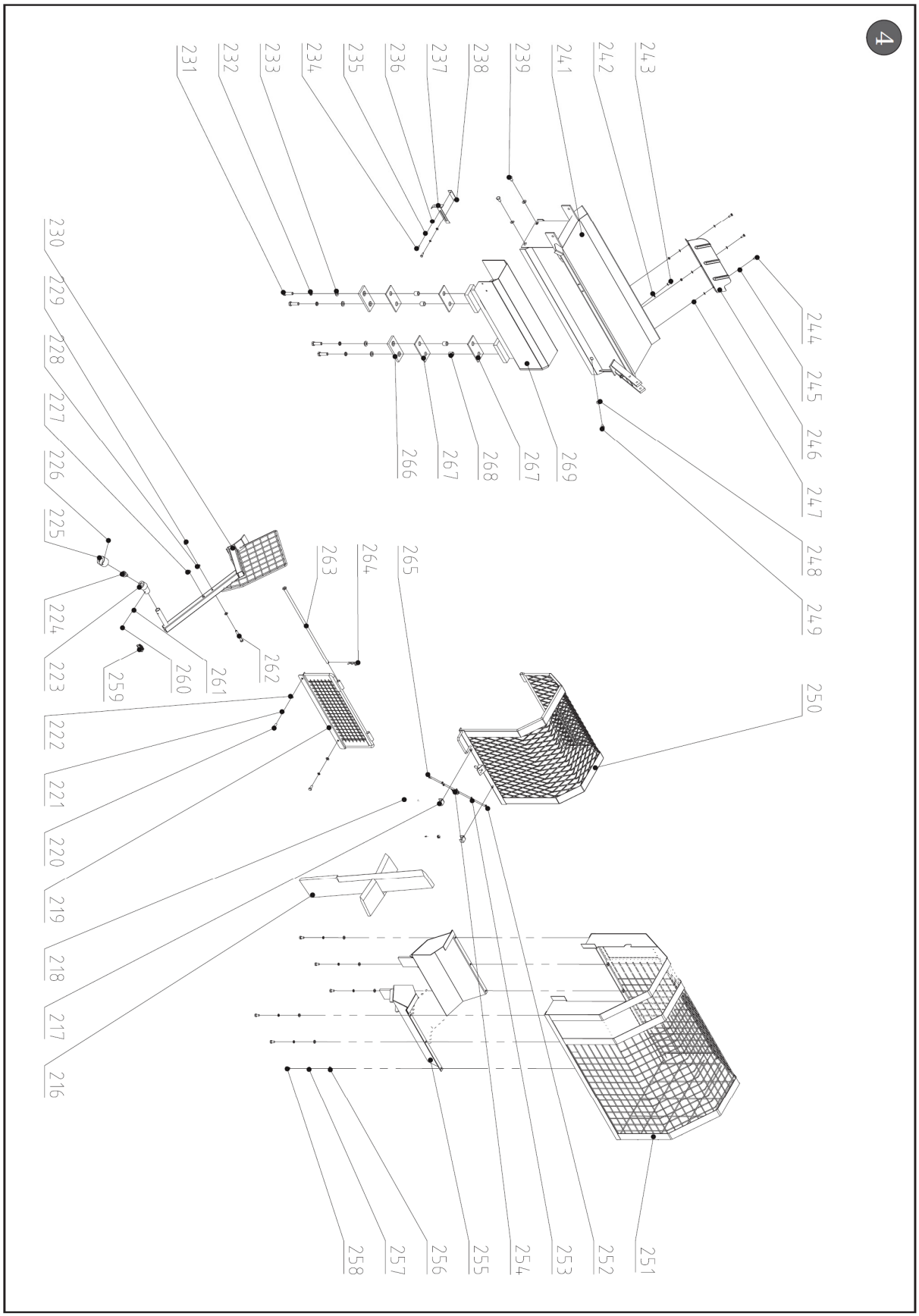
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Pos.	Part No.	Name	Pcs		Pos.	Part No.	Name	Pcs
1	230001	Electric Box	1		42	230042	Bolt M8x16	1
2	230002	Motor Switch	1		43	230043	Oil Plug Z	1
3	230003	Strain Clamp	3		44	230044	Oil Outlet	1
5	230005	Screw M4x60	4		45	230045	Oil Return Filter SP06-25	1
6	230006	Pipe Clamp	1		46	230046	Oil Inlet	1
7	230007	Bent Bar	1		47	230047	Oil Return Pipe D3	1
8	230008	Plain Washer 6	1		48	230048	Cylinder Retract Oil Pipe D3	1
9	230009	Limit Switch For Cylinder Backstroke	1		49	230049	Cylinder Forward Oil Pipe D3	1
10	230010	Plain Washer 6	2		50	230050	Valve Joint 1	2
11	230011	Elastic Washer 6	2		51	230051	Washer Groupware 18	2
12	230012	Screw M6x16	2		52	230052	Valve Body D3	1
13	230013	Washer Groupware 22	2		53	230053	Screw M5x70	3
14	230014	Valve Joint 2	2		54	230054	Automatic Shuttle Valve	1
15	230015	Short Oil Plug M1	1		55	230055	Electromagnetic Reversing Valve	1
16	230016	Washer Groupware 20	2		56	230056	Screw M5x45	4
17	230017	Oil Suction Pipe D3	1		57	230057	Screw M5x40	4
18	230018	Plain Washer 8	4		58	230058	Plain Washer 6	2
19	230019	Gear Pump D3	1		59	230059	Screw M6x16	2
20	230020	Oil suction Filter	1		60	230060	Locknut M10	1
21	230021	Bolt M10x30	4		61	230061	Regulator 2	1
22	230022	Pump Motor	1		62	230062	Adjusting Bolt	1
23	230023	Outlet Pipe D3	1		63	230063	Handle Sleeve	1
24	230024	Plain Washer 10	4		64	230064	Tablet	2
25	230025	Washer Groupware 20	2		65	230065	Plain Washer 6	2
26	230026	Locknut M10	4		66	230066	Elastic Washer 6	2
27	230027	Short Oil Plug M1	1		67	230067	Screw M6x16	2
28	230028	Screw M8x10	2		68	230068	Cotter Pin 2.5X25	1
29	230029	Plain Washer 8	2		69	230069	Regulator 1	1
30	230030	Nut M5	1		70	230070	Handle Sleeve	1
31	230031	Oil Seal	1		71	230071	Emergency Stop Button	1
32	230032	Main Body	1		72	230072	Cylinder Control Switch	1
33	230033	Bolt M8x16	1		73	230073	Strain Clamp M12x1.5	7
34	230034	Clevis Pin	1		74	230074	Valve Guard	1
35	230035	Clip 3	2		75	230075	Bolt M6x35	2
36	230036	Clevis Pin	1		76	230076	Screw M6x16	1
37	230037	Clip 3	2		77	230077	Locknut M6	2
38	230038	Limit Switch For Steel Mesh	1		78	230078	Plain Washer 5	3
39	230039	Plain Washer 4	2		79	230079	Locknut M5	3
40	230040	Elastic Washer 4	2		80	230080	Elastic Washer 8	4
41	230041	Screw M4x30	2		81	230081	Screw M8x35	4

Pos.	Part No.	Name	Pcs		Pos.	Part No.	Name	Pcs
82	230082	Plain Washer 6	8		122	230122	Plain Washer 10	4
83	230083	Bolt M6x16	8		123	230123	Locknut M10	2
84	230084	Gasket	1		124	230124	Locknut M10	2
85	230085	Oil suction Filter Joint	1		125	230125	Plain Washer 10	4
86	230086	Plain Washer 5	1		126	230126	Bolt M10x55	2
87	230087	Dipstick	1		127	230127	Locknut M10	4
88	230088	O-Ring 25x2.65	2		128	230128	Support Stand	2
89	230089	Locknut M20	2		129	230129	Bolt M10x120	2
90	230090	Plain Washer 20	2		130	230130	Locknut M10	2
91	230091	Transport Wheel	2		131	230131	Bolt M10X25	2
92	230092	Wheel Shaft	1		132	230132	Locknut M10	2
93	230093	Chassis	1		133	230133	Plain Washer 10	4
94	230094	Plain Washer 10	4		134	230134	Bolt M10X65	2
95	230095	Bolt M10x65	2		135	230135	Locknut M8	1
96	230096	Bolt M10X20	2		136	230136	Plain Washer 8	2
97	230097	Plain Washer 10	4		137	230137	Bolt M8x30	1
98	230098	Support Leg	1		138	230138	Sleeve	1
99	230099	Locknut M10	2		139	230139	Cut-off Length Gauge	1
100	230100	Support Leg	1		140	230140	Bolt M8x20	4
101	230101	Plain Washer 10	4		141	230141	Plain Washer 8	8
102	230102	Locknut M10	2		142	230142	Saw Bracket	1
103	230103	Bolt M10x80	2		143	230143	Locknut M8	4
104	230104	Plain Washer 10	4		144	230144	Bolt M8x50	2
105	230105	Nose Wheel	1		145	230145	Spring	2
106	230106	Connecting Piece	1		146	230146	Flange Nut M8	4
107	230107	Bolt M12x80	2		147	230147	Screw M4x8	1
108	230108	Plain Washer 12	4		148	230148	Button Cover	1
109	230109	Coupler 2*2	1		149	230149	Button Switch For Log Saw Handle	1
110	230110	Locknut M12	2		150	230150	Button Plug	1
111	230111	Connecting Tube	1		151	230151	Plain Washer 4	1
112	230112	Bolt M10x65	4		152	230152	Handle Sleeve	1
113	230113	Plain Washer 10	8		153	230153	Bushing	1
114	230114	Locknut M10	2		154	230154	Log Saw Handle	1
115	230115	Lock Pin	1		155	230155	Log Saw Motor Bracket	1
116	230116	Clevis Pin	1		156	230156	Locknut M12	4
117	230117	Rolling Support	1		157	230157	Plain Washer 12	4
118	230118	Fixed Shaft	3		158	230158	Log Saw Motor	1
119	230119	Shaft End Bolt	3		159	230159	Bolt M8x30	2
120	230120	Roller	3		160	230160	Flat Key 8x7x10	1
121	230121	Bolt M10x80	2		161	230161	Plain Washer 8	2

Pos.	Part No.	Name	Pcs		Pos.	Part No.	Name	Pcs
162	230162	Flange Nut M8	4		202	230202	Flange Nut M8	1
163	230163	Rhombic Block PFL204	1		203	230203	Star Knob	1
164	230164	Bearing UB204	1		204	230204	Screw M4x12	1
165	230165	Bolt M8x50	1		205	230205	Plain Washer 10	1
166	230166	Locknut M8	1		206	230206	Nut M10	1
167	230167	Screw M6x40	2		207	230207	Bolt M10x20	1
168	230168	Nut M6	2		208	230208	Plain Washer 5	2
169	230169	Screw M5x16	2		209	230209	Side Guard	1
170	230170	Bolt M12x50	4		210	230210	Holder	1
171	230171	Inner Bushing	1		211	230211	Nozzle	1
172	230172	Sprocket Adjusting Pad	1		212	230212	Plain Washer 8	4
173	230173	Guide Plate	1		213	230213	Elastic Washer 8	4
174	230174	Sprocket D3	1		214	230214	Screw M8x25	4
175	230175	Sprocket Pad	2		215	230215	Oil Hose	1
176	230176	Saw Chain	1		216	230216	Cross Wedge	1
177	230177	Outer Bushing	1		217	230217	Hook	2
178	230178	Washer K	1		218	230218	Spring	2
179	230179	Quick Joint	1		219	230219	Minor Steel Mesh	1
180	230180	Bolt M8x25	1		220	230220	Bolt M8x20	2
181	230181	Flange Nut M8	4		221	230221	Elastic Washer 8	2
182	230182	Bearing UB204	1		222	230222	Plain Washer 8	2
183	230183	Rhombic Block PFL204	1		223	230223	Iron Handle Sleeve	1
184	230184	Plain Washer 8	2		224	230224	Button Switch for Log Lock Handle	1
185	230185	Bolt M8x30	2		225	230225	Button Cover	1
186	230186	Oil Hose Joint	2		226	230226	Screw M4x8	1
187	230187	Oil Plug Z	1		227	230227	Bushing	1
188	230188	O-Ring 25X2.65	2		228	230228	Plain Washer 8	2
189	230189	Lubricating Oil Tank	1		229	230229	Locknut M8	1
190	230190	Globe Valve	1		230	230230	Log Lock Handle	1
191	230191	Quick Joint	1		231	230231	Bolt M12x45	4
192	230192	Lube Hose	1		232	230232	Elastic Washer 12	4
193	230193	Bolt M8x50	2		233	230233	Plain Washer 12	4
194	230194	Elastic Washer 8	2		234	230234	Bolt M6x18	2
195	230195	Plain Washer 8	2		235	230235	Elastic Washer 6	2
196	230196	Saw Guard	1		236	230236	Plain Washer 6	2
197	230197	Spring	1		237	230237	Limit Plate	1
198	230198	Locknut M8	1		238	230238	Clamping Plate	1
199	230199	Big Washer 8	1		239	230239	Bolt M10x16	2
200	230200	Bolt M8x40	1		240	230240	Plain Washer 10	2
201	230201	Bolt M8X55	1		241	230241	Machine Case	1

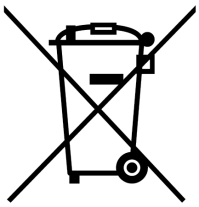
Pos.	Part No.	Name	Pcs		Pos.	Part No.	Name	Pcs
242	230242	Plain Washer 10	1		257	230257	Elastic Washer 8	6
243	230243	Bolt M10x16	1		258	230258	Bolt M8x16	6
244	230244	Screw M6x16	3		259	230259	Tube Plug 30	1
245	230245	Plain Washer 6	6		260	230260	Screw M5x10	1
246	230246	Guard Plate	1		261	230261	Plain Washer 5	1
247	230247	Locknut M6	3		262	230262	Bolt M8x65	1
248	230248	Plain Washer 10	1		263	230263	Connecting Shaft	1
249	230249	Bolt M10x16	1		264	230264	Clip 3	1
250	230250	Main Steel Mesh	1		265	230265	Screw M4x12	2
251	230251	Protecting Wire Net	1		266	230266	Retaining Plate	2
252	230252	Locknut M4	2		267	230267	Sliding Plate D3	4
253	230253	Plain Washer 4	4		268	230268	Spacer	4
254	230254	Key For Limit Switch	1		269	230269	Cylinder Cover	1
255	230255	Side Rail	1		270	230270	Cylinder D3	1
256	230256	Plain Washer 8	6					

DISPOSAL OF PACKAGING AND MACHINE AFTER THE END OF SERVICE LIFE

After unpacking the machine, you are obliged to provide for the disposal of packaging material with taking into account the use of secondary raw materials according to the legislation valid in your country and with respect to the decrees of local town or municipal authorities.

The following procedure is recommended for machine disposal after the end of its service life:

1. Dismount all parts from the machine that can still be used.
2. Dismount plastic machine parts and parts made of non-ferrous metals. The dismantled machine remainder and the dismounted parts are to be disposed according to the legislation valid in your country and with respect to the decrees of local town or municipal authorities.
3. Regarding waste from the electrical device, use the opportunity of **return buy-out** in the shop, where you purchased the device **(points 1 and 2 are not valid in this case)**.
4. The machine is in accordance with the RoHS Directive (2002/95/EC, 2002/96/EC, 2003/108/EC).
5. The product is in accordance with the requirements of the above-mentioned EC Directive regarding the quantities of forbidden dangerous substances.



This pictograph means that the product was introduced on the market after 13th September 2005 and shall not be disposed to a waste container or a dustbin.

INSTRUCTIONS FOR ORDERING SPARE PARTS

The following data are to be used for an easier identification when ordering the spare parts:

1. Machine type, engine type, machine serial number and year of manufacture;
2. Ordering number given by manufacturer and its name in the part list;
3. Number of ordered pieces separately for each item;
4. Precise address, telephone number, fax number or e-mail address;
5. Should you be uncertain about the correct identification of the component, send the damaged component either to the nearest service shop or directly to the manufacturer;
6. All components should be ordered in the nearest service shop or at your dealer's.

In the case of any confusions concerning the spare parts or technical issues, the VARI a.s. commercial, customer-service or technical departments are prepared to answer all your inquiries.

ADDRESS OF THE MANUFACTURER

TIYA Hydraulics Co., Ltd., Fuqian Street North, Gaoze, 262300 Wulian, Shandong, P. R. China; TIYA Hydraulics Co., Ltd. is a production facility of TIYA International Co., Ltd.

ADDRESS OF THE IMPORTER AND DISTRIBUTOR

VARI, a.s.	phone:	(+420) 325 637 276
Opolanska 350	fax:	(+420) 325 607 264
Libice nad Cidlinou		
CZECH REPUBLIC	e-mail:	vari@vari.cz
289 07	internet:	http://www.vari.cz/

EC DECLARATION OF CONFORMITY[1]

We herewith declare

that the following machine complies with the appropriate basic safety and health requirements of the EC Directive based on its design and type, as brought into circulation by us.

In case of alteration of the machine, not agreed by us, this declaration will lose its validity.

Description:	Wood Processor
Type:	65638
Applicable EC Directives:	EC Directive of Machinery 2006/42/EC EC Low Voltage Directive 2014/35/EU EC Council Directive 2014/30/EU Electromagnetic Compatibility
Applicable Harmonized Standards:	EN ISO 12100:2010 EN 60204-1:2006+A1:2009+AC:2010 2006/42/EC- Annex I EN 55014-1:2017 EN 55014-2:2015 EN 61000-3-2:2014 EN 61000-3-11:2000
Name of Company:	TIYA International Co., Ltd.
Address:	B12B, Shenye Center, 9 Shandong Road, Qingdao, China Tel: (532) 8582 3333 Fax: (532) 8582 4444
Name / Title:	Yuan Yue Director

Signature:

Place / Date: Qingdao, China / Sep. 7th, 2019

[1] *The original declaration of conformity as issued by the manufacturer of the product.*