



## **Tram Alignment Procedure**

Tram Alignment is the adjustment of the saw arbor and tooling assemblies' alignment in reference to the flow of product. Tram alignment is necessary for the quality of the cuts in the material of the product and longevity of the equipment. Although equipment design may vary, all designs will follow the same guidelines as listed for the 1<sup>st</sup> and 2<sup>nd</sup> Pass Saws.

### **1<sup>st</sup> Pass Saw**

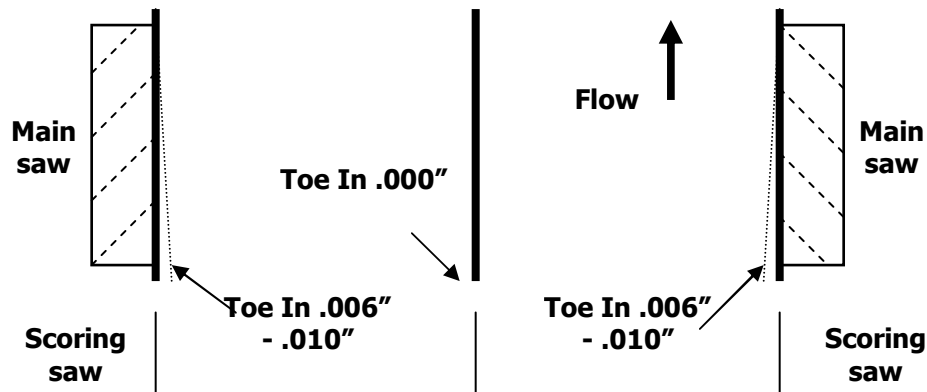
Proper "Tram Alignment" will require the use of a 'GLOBE Tramming Fixture' and a dial indicator with a magnetic base. The 'GLOBE Tramming Fixture' is an aluminum weldment that has been machined precisely to fit the saw's drive rolls and provide an alignment reference within .001". The 'GLOBE Tramming Fixture' can be purchased or leased by contacting Globe Machine Mfg parts department.

With the equipment locked out into a 'Zero' energy state, move or remove the dust collector hoods, saw throat plates, and adjust the hold down wheel assemblies in to the 'maximum UP' position. Depending on which saw assembly being adjusted, the hold down wheel assembly either in front or behind the saw assembly may have to be relocated in order to place the tramming fixture upon the drive roll. Locate the tramming fixture onto the clean drive roll so that the machined arm is beside the tooling assembly being adjusted and resting on the drive roll on the opposite side.

Next, place the dial indicator onto the outside of clean and straight tooling using the magnetic base so that the indicator will read the machined surface of the tramming fixture arm at locations upstream and downstream of the saw assembly when the tooling is rotated.

Position of the arbor housing should be as such that the tooling is aligned with the centerline of saw and saw line. The outside saw assemblies may have a "Toe In" of .006" - .010" and splitter saw assemblies (if used) will be parallel of centerline. See illustration "A".

## Illustration "A"



If adjustments are required, remove the tapered locating pins between arbor housing and the housing mount and loosen the four mounting bolts. Using the Tramming Fixture and the dial indicator, move the arbor housing until above specifications are achieved, tighten mounting bolts, and inspect tram adjustment again to insure the correct position of arbor housing has not changed. Using a #7 tapered reamer, clean and re-align pin seat and install new tapered pins. Pins should seat firmly when tapped into place.

Replace any relocated hold down wheel assemblies, dust collection hoods, and saw throat plates.

### 2<sup>nd</sup> Pass Saw

The adjustment of the 2<sup>nd</sup> Pass Saw assemblies is similar to the adjusting of the 1<sup>st</sup> Pass Saw with the exception of the use of the Tramming Fixture. In place of the Tramming Fixture, the procedure will require the use of properly installed "GLOBE" manufactured chainways that are clean and in good condition.

With the equipment locked out into a "Zero" energy state, remove dust collection hoods and saw throat plates and raise the hold down wheel assemblies in to the "maximum UP" position. Mount the dial indicator to clean and straight tooling as was performed on the 1<sup>st</sup> Pass Saw. Rotating the tooling, measure the alignment of the tooling referencing the side of the "GLOBE" chainway extrusion channel. If adjustments are required, remove the tapered locating pins at the base of the arbor housing and loosen the

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mounting bolts. Adjust the arbor housing to within specifications again using illustration “A”. Tighten mounting bolts and inspect tram adjustment again to insure the correct position of the arbor housing has not changed. Clean and re-align pin seat using the tapered reamer as was performed above and install new tapered pins.

Depending upon design, some splitter saw assembly adjustment may require shimming to attain tram tolerances.

Replace saw throat plates and dust collection hoods.

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