



WWW.HUD-SON.COM • 800.765.SAWS



FREEDOM LINE SAWYER/HUNTER SAWMILL OPERATOR'S MANUAL

8201 STATE ROUTE 12 • PO BOX 345 • BARNEVELD, NY 13304

A N O T E F R O M H U D - S O N

Thank you for your purchase of a Freedom Line Sawmill from Hud-Son Forest Equipment. We are pleased that you chose us as your supplier of your forestry equipment.

Hud-Son Forest Equipment has been in the forestry business since 1965 and prides itself on developing new and innovative products for the forestry business. Our product line is always transforming so please check us out on the web at www.hud-son.com for the up and coming developments we are making.

Should you have any questions with the set-up of your mill or if you have any technical questions please feel free to contact our onsite technician Monday - Friday, 8 to 4:30 and Saturdays from 8 to noon eastern time at 800-765-7297. We are always available to our customers for any questions or concerns that you may have about your equipment.

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INTRODUCTION

Purchaser Agreement

By accepting the delivery of your sawmill by Hud-Son Forest Equipment you agree that you will not modify your mill from it's original assembly. This will VOID any warranty from Hud-Son Forest Equipment.

Please fill out the information for quick reference:

Dealer: _____
Phone Number: _____
Address: _____

Purchase Date: _____
Model: _____
Serial Number: _____

This manual is filled with the latest information and specifications at the time of publication. We have the right to make changes as they are needed. Any of the changes in our product may cause a variation between the illustrations and explanations in the manual and the item that you have purchased.

Safety Guidelines

The reason for the safety section is to inform the operators and maintenance personnel, the precautions that should be taken while operating or servicing the Hud-Son Mills. Please use good judgement and keep safety in mind when operating Hud-Son machinery. Please read and follow ALL the instructions in this manual before operating the Hud-Son Mill safely at all times. These instructions were produced for your benefit. Your ability to understand and follow the instructions is essential for the safe operation of this product. Always call your servicing dealer if you are in doubt before operation of any kind.

General Safety Procedures

- 1 - Always wear safety glasses, ear protection, and gloves while operating or servicing the machine.



- 2 - Keep all body parts and foreign objects away from all moving parts. Do not reach into the machine while it is still operating. (Be Sure The Machine Is OFF.)
- 3 - Do not attempt to override any safety features on the machine.
- 4 - Inspect the machine before every use for wear, damage, and that it's functioning correctly. If the machine has been damaged or is not running correctly, **DO NOT** attempt to operate the machine. Repair or replace all parts when necessary.
- 5 - Do not wear loose clothing or jewelry while operating or servicing the machine.
- 6 - All replacement parts should be of the same specifications as the original parts on your Hud-Son machine.
- 7 - All guards and covers must be in place before operating the machine.
- 8 - Before starting the machine be sure that it is set up properly.
- 9 - **DO NOT** operate or service any machinery while under the influence of drugs or alcohol, while tired or if you are unable to control your movements.
- 10- All worn or damaged decals should be replaced.
- 11- Any modifications to the machine requires written approval from Hud-Son Forest Equipment.
- 12- The sawmill should only be used when it is on level stable ground.

The safety rules are made for the benefit of the persons operating and servicing the machine, to prevent injury to oneself or others. Please review all setup and operating procedures before attempting to run the machine, whether covered in this manual or not, to ensure the safest operation of this product.

CAUTION BEFORE, DURING AND AFTER OPERATION



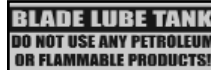
Check the engine compartment for sawdust and wood trash build up in and around the engine compartment and the exhaust area to prevent any possible fires from starting due to excessive build up. Always clean the sawdust out from under the machine after shut down and be sure there is no sawdust build up near or around the muffler area.

Hud-Son Forest Equipment is not liable for damage to property or personal injury due to the failure of any person and/or operator to follow the instructions and recommendations set forth in this manual or any other instructions or recommendations contained in other literature issued by other vendor manuals in the operator's kit.

Product Safety Decals

The decals below are used on the Hud-Son Saw Mills to identify warnings and prohibited actions. It is very important that you understand the meaning of the decals for your safety and the safety of others. Decals are to be replaced if worn or illegible.

BLADE LUBE TANK - Be sure to use the correct lubrication, if incorrect lube is used it may cause personal injury or damage.	CAUTION - All debris need to be removed from machine before transporting, failure to do so may cause personal injury or damage.
CAUTION - Operating equipment without guards may cause personal injury or damage.	DANGER - Be careful around any rotating parts, that may cause personal injury or damage.
CAUTION - Be EXTRA careful around these areas, unsafe practices may cause personal injury or damage.	DANGER - Be sure to be very cautious and alert around areas that may cause personal injury or damage.
CAUTION FIRE HAZARD - Keep all sawdust away from motor.	NOTICE - Please remember to send in warranty card and information.



Set-Up and Operation

The Hud-Son Freedom Line Sawmill requires an extensive amount of set-up before operation.

Be sure to wear safety glasses, gloves and ear protection at all times while operating any piece of Hud-Son equipment.

Receiving and Unit Inspection

- 1 - Upon receiving your unit, inspect the content. Check for instructional steps. Make note of any damage or missing pieces. Contact us immediately with any issue you may have.

Assemble Mill - Follow assembly instructions and DVD (included). Instructional video is also available on Hud-Son Forest's official YouTube channel. Please contact Hud-Son support at (800) 765-SAWS for any questions regarding the Freedom Line sawmill set up.

All Pieces Included:

- End Guards (2 per box)
- Wheels & Bearings
- Lube Tank
- Engine
- Parts Box
- Logs Dogs
- Saw Blade
- Mill Head
- Mill Frame
(1-Left Side, 1-Right Side)
- Center Brace
- Winch Bracket
- Sawyer or Hunter Middle Guards
- Rail Track System
- 3 Rails (LEFT side)
- 3 Rails (RIGHT side)
- 2 End Pieces
- 5 Middle Pieces
- 2 Cheaters
- Decals
- Owners Manual
- DVD

Hunter and Sawyer Hardware

PKG #1 UPRIGHT TO HEAD

- (4) 1/2 - 13X 1 1/2 Bolts
- (8) 1/2" Flat Washers
- (4) 1/2" Nylocks Nuts

PKG #2 CENTER BRACE

- (4) 3/8" - 16 X 2 1/4" Bolts
(Substitute 2" bolt)
- (4) 3/8" Flat Washers
- (4) 3/8" Nylock Nuts

PKG #3 WINCH BRACKET

- (4) 3/8" - 16 x 2 1/4" Bolts
(Substitute 2" bolt)
- (2) 3/8" - 16 x 1 1/2" Bolts
- (12) 3/8" Flat Washers
- (6) 3/8" Lock Washers
- (6) 3/8" Nuts

PKG #4 CABLE BEARING

- (1) Shoulder Bolt (short)
- (2) Plastic Spacers
- (1) 3/8" Nylock Nut
- (1) Cable Bearing

PKG #5 TRACK WHEELS

- (4) 3/4" - 10x4 Track Bolts
- (8) 3/4" Willie Washers
- (4) 3/4" Nylock Nuts
- (6) 3/4" Flat Washers
(4 to start, 2 extra)

PKG #6 ENGINE

- (4) 5/16" x 18 x 1 3/4 Bolts
- (8) 5/16" Flat Washers
- (4) 5/16" Lock Washers
- (4) 5/16" Nuts

PKG #7 MAIN BEARINGS

- (4) 1/2-13 x 4 1/2 Bolts
- (4) 1/2 - 13 x 2 1/4 Bolts
- (8) 1/2" Flat Washers
- (8) 1/2" "THICK" Flat Washers
- (8) 1/2" Lock Washers
- (8) 1/2" Nuts

PKG #8 HEAD ASSEMBLY

- (1) 1/2 - 13 X 4 1/2 GRADE 8B
- (1) CT481 Bearing
- (2) Cup Washers
- (1) 1/2" Nut
- (4) 3/8 - 16 x 3 Tap Bolt
- (4) 5/16 Flat Washers
- (6) 3/8 - 16 Nuts

PKG #9 TENSION PULLEY

- (1) 10mm x 60mm Bolt
- (1) 10mm Lock Nut
- (4) 3/8" Flat Washers (USS)
- (4) 3/8" Flat Washers

**Not all 8 washers may be necessary*

PKG #10 CABLE ASSEMBLY

- (1) 42" 5/32 Cable
- (1) 72" 5/32 Cable
- (4) 1/8" Cable Clamps
- (2) 1/2" Eye Bolts (Modified)
- (4) 1/2" Nuts
- (4) 1/2" Flat Washers
- (2) 1/2" Lock Washers
- (1) 5/32 Swag Connector
- (1) 5/32 Bottom Connector

PKG #11 GUARDS

- (2) 3/8" Washers (Plastic Spacers)
- (2) 3/8" Flat Washers
- (4) 3/8" Fender Washers
- (6) 3/8" Lock Washers
- (6) 3/8" Nuts

PKG #12 LUBE TANK

- (1) Lashing Strap
- (1) Shut Off Valve
- (5) 14" Cable Ties
- (1) Guide Bracket
- (4) Feet of Lube Line
- (1) 1/4" x 1/2" Bolt (Guide Bolt)
- (2) Grease Fittings
- (1) Plastic Insert for Lube Line

PKG #13 MEASURING

- (1) Scale Stick (cut to 20")
- (1) Sight Glass
- (2) 1/8" Cable Clamps

PKG #15 RAIL SYSTEM

- (4) 1/2" x 1 Bolts
- (4) 1/2" Nuts
- (4) Track Stops

PKG #14 CLUTCH

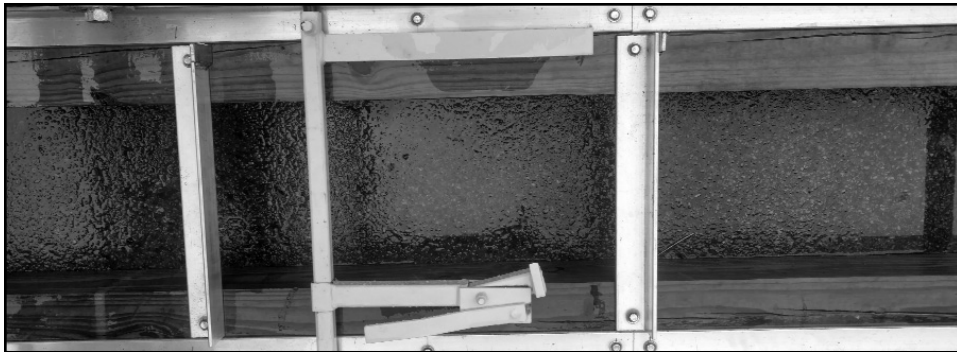
- (1) 5/16" - 24 X 1/4 Clutch
- (1) 5/16" Flat Washer
- (1) 5/16" Lock Washer
- (1) Serrated Washer (#410-803)
- (2) 3/14" Willie Washers
- (1) Key Stock Small

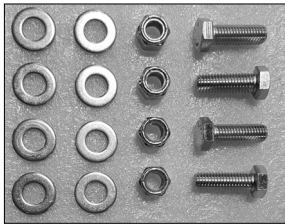
PKG #16 SHIMS

- (4) Shims For Wheel & Bearings

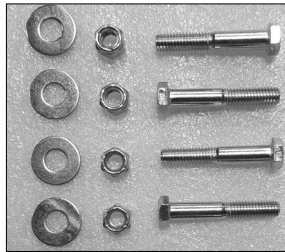
Parts Box

- | | |
|--------------------------------|---------------|
| • (1) T-2000 Winch | # T2000 |
| • (1) Idler Wheel (Belt) | # FA3002SB000 |
| • (4) Track Wheels | # 976-019 |
| • (1) Saw Blade 132" | # WM132 |
| • (4) Small Plastic Cap Plugs | # SQR-1-10-14 |
| • (4) Medium Plastic Cap Plugs | # FP-201 |
| • (2) Blade Guides | # 976-001 |
| • (1) Winch Handle (Modified) | |
| • (1) Small Clutch | #4075P007 |
| • (1) Belt B77 | #B77 |
| • (2) Blade Guide Pins | #M |
| • (1) Hardware Kit | |
| • (1) Qt of Engine Oil | 10W30(1) |

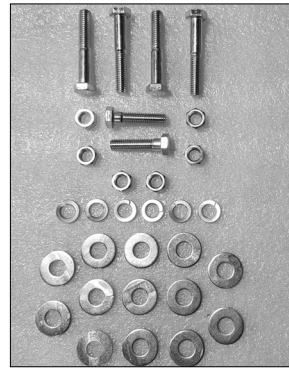




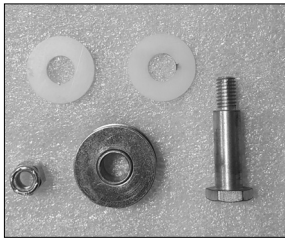
UPRIGHT TO HEAD
PKG#1



CENTER BRACE
PKG #2



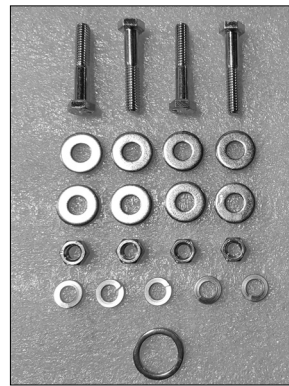
WINCH BRACKET
PKG #3



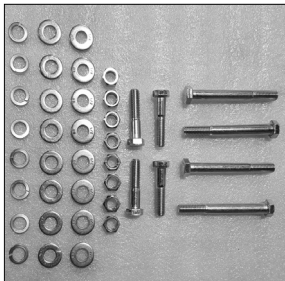
CABLE BEARING
PKG #4



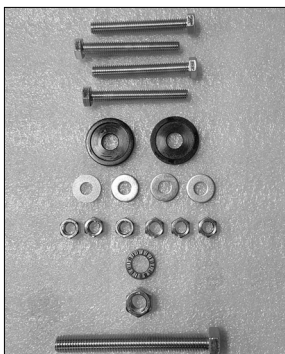
TRACK WHEELS
PKG #5



ENGINE
PKG #6



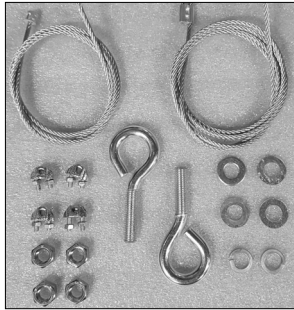
MAIN BEARINGS
PKG #7



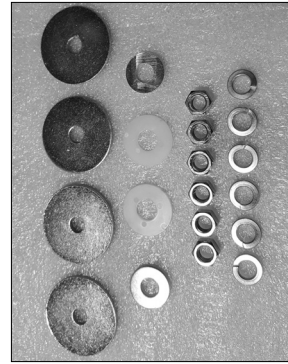
HEAD ASSEMBLY
PKG #8



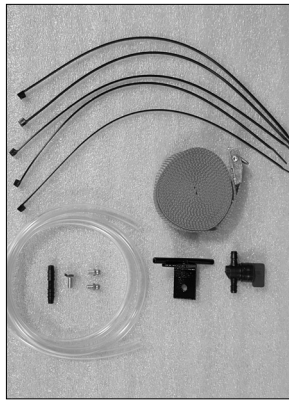
TENSION PULLEY
PKG #9



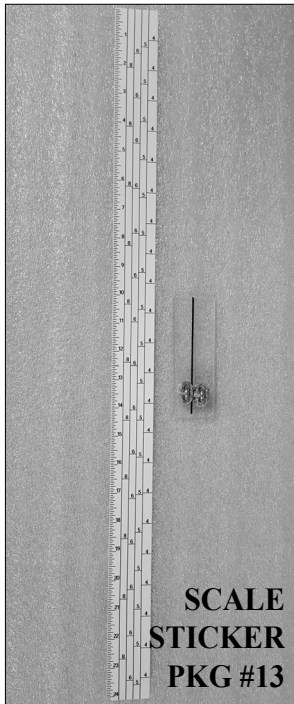
CABLE ASSEMBLY
PKG #10



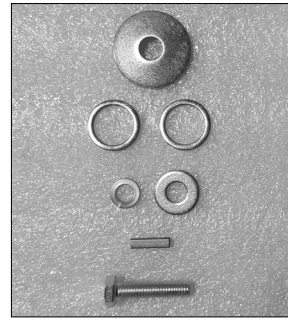
GUARDS
PKG #11



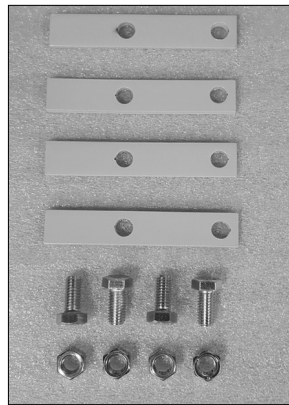
LUBE TANK
PKG #12



SCALE
STICKER
PKG #13



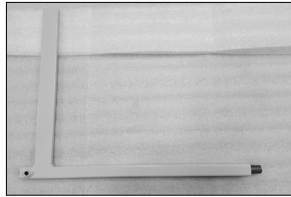
CLUTCH
PKG #14



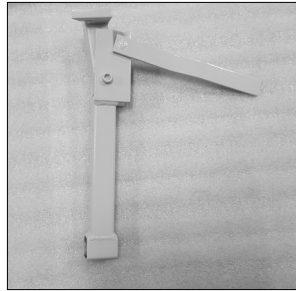
RAIL SYSTEM
PKG#15

STICKERS

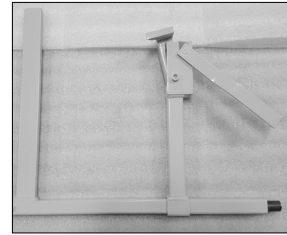




J-BAR/SQUARE
POST/BACKSTOP



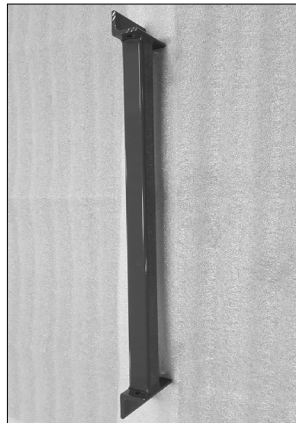
LOG DOG



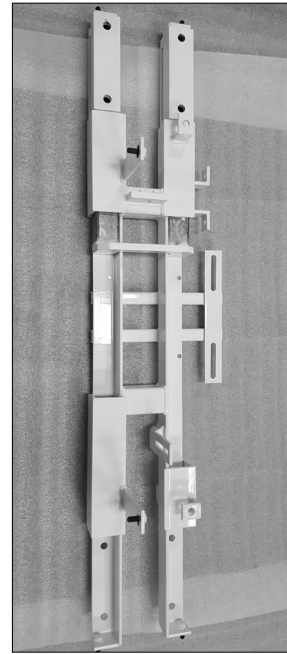
LOG DOG
ASSEMBLY



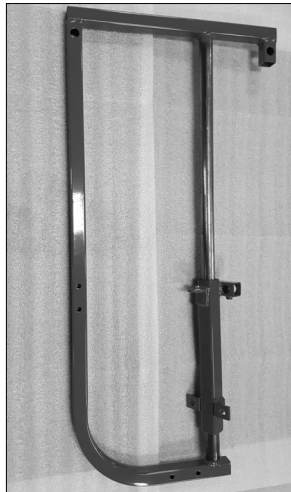
UPPER WINCH
BRACKET



CENTER
SUPPORT BEAM



INNER
MILL HEAD



DISCHARGE CAGE
SIDE (B)



OPERATOR CAGE
SIDE (A)



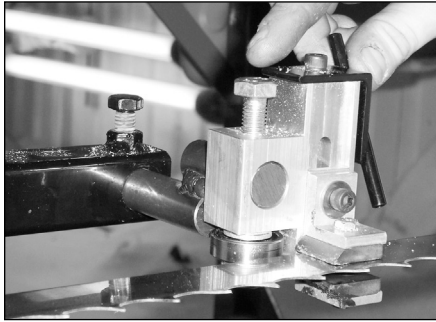
OPERATOR SIDE
BANDWHEEL (A)

DISCHARGE SIDE BANDWHEEL (B)



GUIDE ADJUSTMENT

- a) Set the guide bracket so that the back bearing is on the same plane as the blade, so if the blade was to wander back it would hit the back bearing evenly across the middle of the roller. If the bearing needs to be adjusted up or down, loosen the bolt that holds it to the guide bracket and space it in either direction using the washers that are on either side of the bearing.
- b) Once the bearing is set, position the guide bracket so that the bearing is spaced 1/8" behind the back of the blade. Once the bearing is in position, tighten the bolt on the top of the guide bracket into place. Be sure the guide is 90° to the blade.
- c) The guide shoes are to be set using a sheet of paper to gauge the spacing. Place the paper between the shoe and the blade, slide the shoe so that it is pinching the paper, and tighten the bolt so that the shoe is set in place. Do the same on the bottom of the blade. Note that you do not want the shoes to be pinching the blade so hard that they are prohibiting blade travel.
- d) Make sure that all nuts and bolts are firmly tightened.



Pictured is a close-up of the guide. It shows all the bolts and bearings that can possibly be adjusted. Note how the teeth are outside of the guide.

Tools that will be needed:

1. 17 mm wrench
2. 17 mm socket
3. 9/16" wrench
4. 3/16" Allen wrench

Adjusting Sawmill Guides

Purpose of the Guides

1. Superior Hud-Son guide design with supports on the top, bottom and back of the blade. With our guide design this limits chance of blade wander.
2. The lower guide shoe holds the blade up and decreases the chance of "diving."

Set-Up and Operation

Tensioning the Blade

NEVER tension your blade with the engine running. Your mill is shipped to you without any tension on the blade.

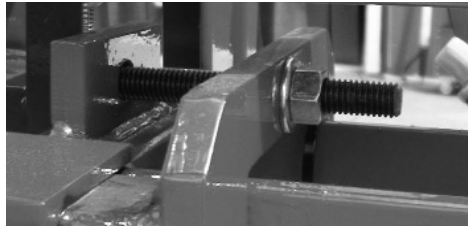
If there is tension left on the blade for a period of time, it can cause flat spots in the wheel belts. This will cause the blade to fall off the wheel. Always remember to de-tension your blade when you are done sawing for the day.

- a) To tension or loosen the blade, turn the adjusting bolt or stud, clockwise until 30-35 pounds of torque is achieved. (See Figure A) The recommended tool for this is a torque wrench. Rotate the blade by hand 3-4 full revolutions; this centers the blade on the wheels.
- b) With gloves on, pull up on the blade at the center guard. Allow for no more than a 1/4" movement up or down on the blade.
- c) Blade guides must not be so tight that they cause the blade to heat up. If this occurs refer to page 11 and re-adjust the guide.
- d) Perform a simple test called the

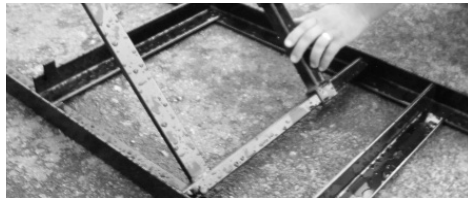
"Flutter"test. Put the guards on and then run the engine at full RPM's (be sure the blade is not in a cut during this test) and watch the blade under the blade guard. The blade must run straight. If it does not, shut the engine down and apply more tension. Keep in mind that over tensioning will also cause the blade to flutter. You should attain proper tension around 30 to 35 pounds.

- e) A tensioned blade should come off the bottom of the band wheel and run straight across to the other bandwheel so there is NO sag in the blade between the two wheels.

Tension nut for smaller units- Figure A



Log Dog Assembly - Figure C



Cheater - Figure B



Log Debarker - Figure D



Setting Logs

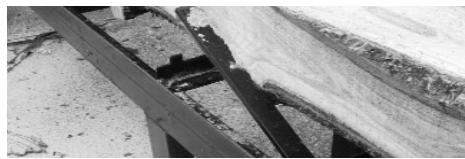
Once the track is set, the head is in place and the blade is tensioned correctly, you are almost ready to cut. Place the log determined by the mills size on the center of the track. Using the log dogs, secure the log to the track. Be sure to dog the log is high enough (1/2" up the log) to ensure the log does not move. If the log you are trying to saw is too large in diameter to fit between the log dog and squaring bar post we have created a cheater bar that can hold the large log by screwing or nailing the V-shaped bar to the end of the log. See Figure B.

Getting Ready to Cut

Now is the time to debark or clean your log. This can be achieved by the simple chainsaw attachment, called a Log Debarker (available through Hud-Son Forest Equipment) or you can pressure wash or use whatever method available to remove any mud or bark from the logs. By debarking and cleaning your log it will extend the life of your blade. (See Figure D)

- a) Adjust the Hud-Son guides so that they are slightly (no more than 2 inches) wider than the maximum width of the log.
- b) Find the top of the log with the blade. Remember, that you may have cheaters in place so be sure these are clear when making the first cut. You will be removing the top portion of the log. (top slab)
- c) Crank your head down to the desired height and click up one notch to set the head. Make sure your blade will clear your dog assembly.
- d) Start your engine and let it idle for at least 5 minutes.
- e) With the engine in idle position, increase the throttle to start the blade. Sawing should always be done with the engine in full throttle.
- f) Gently push the saw head through the log, pushing on the head frame. If the engine starts to labor, you are going too fast, so slow down. Go slow through burls and knots as the engine may bog down through these parts of a log.
- g) When you are at the end of the log, power down the engine, crank the head up so that it will clear the log and roll back to the front of the log. For ease of operation, put the slabs on the operator's side of the mill, this way you will not have to dig through saw dust for your lumber.
- h) You now have a flat surface on top of your log, remove the cheaters (if appli-

- cable), you will no longer need them, as long as the log dogs will hold the log in place.
- i) Set your log dog assembly so that they are standing in the track. Turn the cut side of the log, using a cant hook, 1/4 of a turn. The flat side must be flush against the squaring pin to assure a square cant.
- j) Adjust the log dog at an angle to the track so that the blade can pass over the top, but so that the dogs are effective in securing the log.
- k) Once again, increase the engine throttle to start the blade, and saw another slab. You will repeat step (i) until your log is squared into a cant. You may now saw your dimensional lumber.
- l) Steps (i-k) may not be applicable if a cant is not desired.



Place flat side, flush against squaring pin to ensure a square cant.



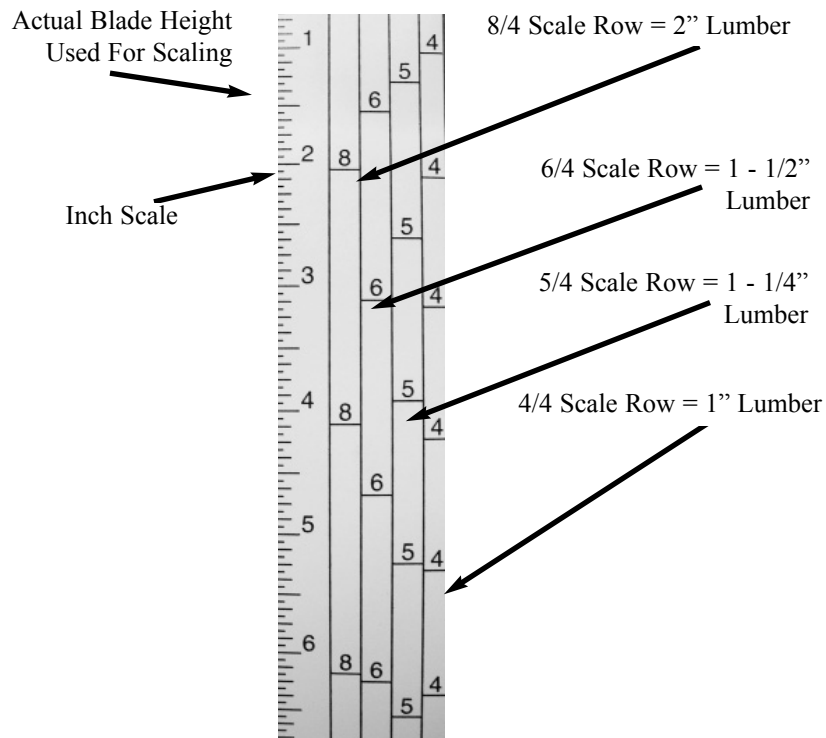
Adjustable dog, set at an angle so that the log can be sawed without interference.

Using the Lumber Scale

- a) All Hud-Son sawmills are equipped with a Lumber Scale. The scale is used to make the dimensioning process simple. The scale incorporates 4 separate scales with the blade kerf factored in for each increment.

Scale	Resulting Thickness
4/4	1"
5/4	1 - 1/4"
6/4	1 - 1/2"
8/4	2"

Note: The 1" standard ruler does NOT account for kerf. When using this scale be sure to plan on kerf. 1" increments will result in approximately a 7/8" end result, depending on what blade is being used.



I. Cutting Dimensional Lumber

You can cut down to a 1" thick bottom board. To achieve this you will use the moveable side of the dog and the short squaring pins welded in the track.

- a) You will need to determine the size of lumber that can be cut and how many, then using the scale start sawing your lumber. Lower the blade to desired thickness and saw your board. Repeat this process until all lumber is cut.
- b) You may need to turn your cant to make the desired lumber.
- c) See pictures 1-5 on the following page.



#1. Place log on track.



#2. Use log dogs to hold log in place.



#3. Adjust blade height, rev engine.



#4. Start cutting.

#5. Cut log into desired dimensional lumber.



End of Processing Lumber

- a) Completely decrease engine throttle and turn engine switch to off position.
- b) The blade will continue to turn automatically and will coast to a stop.
- c) If you are done sawing for the day, de-tension the blade so that you do not cause damage to bandwheel belts.
- d) Lower the mill head so that the lift cable has slack.

Replacing the Blade

No matter how well you care for your blade, they will dull after time and need to be changed. Longevity of your blade depends on how well you maintain it.

- a)** The engine needs to be stopped, turned off and the key removed to ensure that it can not be accidentally turned back on. Engines with a manual start, will need the spark plug wire removed prior to servicing. On electric motors, a lockout/tagout should be used.
- b)** Loosen and remove the guard retainer nuts so you can remove the outside and center guards.
- c)** Loosen band blade tensioner bolt until adjusting bolt is flush with threaded plate.
- d)** With a gloved hand, put hand on the top of the band blade and push down (Use extreme CAUTION, dull blades are still sharp and may be hot).
- e)** Remove band blade from both band wheels and take out of carriage.
- f)** Inspect new or sharpened blade, be sure blade teeth are facing in correct direction. Teeth should always point away from the operator. (Towards discharge chute). Be sure to wipe blade clean of all oily substance prior to installing. A clean, dry rag or cloth works best.
- g)** Starting from your stationary wheel set the blade on the wheel, and then thread through your guides. Work the blade over the tensioning wheel until it is set.
- h)** Lightly tension the blade to remove the slack, and then turn the wheel in the direction of travel (towards the operator) 3-4 rotations to be sure the blade is tracking properly on the wheel.
- i)** Once the new blade is tracking properly, replace the guards and re-tension the blade.

Blade Maintenance

Longevity of band blades depends on how well they are cared for. Using a lube tank, log debarker, band blade sharpener, and/or tooth setter, will help keep your blade in top condition. Be sure to clean your logs by using a pressure washer or debarker to keep them free of mud and debris.

Blade suggestions

- a)** Never force a dull blade, this will result in overheating of the blade and result in wavy lumber.
- b)** Overuse of a blade jeopardizes the ability of the saw blade to be re-sharpened.
- c)** A new blade may stretch after cutting and may have to be re-tensioned to assure quality lumber.
- d)** De-tension the band blade after each day of cutting.
- e)** Never operate the mill without the guards in place.

Care and Maintenance

Hud-Son sawmills require a certain amount of care and maintenance, so that it may continue to perform at its best.

Cleaning your Sawmill

- Using an air hose, blow off all loose debris that builds around the unit.
- Use extreme caution when cleaning the mechanism.
- Never use flammable or combustible materials to clean the mill.
- Be in a well ventilated area. Always wear protective equipment to prevent injury.
- Use proper procedure to dispose of waste materials.
- Wipe down the idler and pulley wheels using an air hose, brush or rag.
- Clean and inspect blade guides.

Preventative Maintenance

- Check for correct blade tension guaranteeing that 30-35 pounds of torque is on tensioning bolt/nut.
- Check blade tracking, a 1 - 1/4" blade should be centered on band wheels.
- Check bearing, idler and pulley wheels for wear.
- Signs of wear are:
 - Excessive heat
 - Squeaking sounds
 - Looseness
 - Grease pillow block bearings
 - Grease blade tensioner shaft.
 - Grease the lift tubes.
- Check all belts for wear and to make sure the belt tension is "taut".
- Belt should have no more than 1/2" deflection.

MAINTENANCE SCHEDULE CHART ***Service Recommendations for Hud-Son Sawmills***

Service Item	<i>Daily</i>	<i>40 Hours</i>	<i>See Manual</i>
Check Engine Oil Level	✓		
Check/Clean Engine Air Filter			✓
Clean Unit of Bark, Saw Dust, and other Debris	✓		
Lubricate Grease Fittings and Oil Points (see Diagram for locations)		✓	
Check Blade Sharpness	✓		
Fuel - fill as needed	✓		
Blade Lubricant - fill as needed <i>Refer to 2A on page 6</i>	✓		

**** Change engine oil after 8 hours of operation on a new engine (break-in period)****

A routine inspection of the entire machine is encouraged. Check to see if all fittings are tight and secure. Make sure all nuts are tightened. Check to see if there is any damage that may need to be repaired before further damage occurs. Routinely checking the equipment and proper maintenance will help keep the Hud-Son Saw Mill running to the best of its ability.

Parts and Warranty

Warranty:

Warranty registration cards must be completed and returned to Hud-Son Forest Equipment within 30 days of purchase. Failure to do so will void the warranty. Also altering the mill in any way will void the warranty.

Warranty claims must be registered with the Dealer/Distributor, and defective parts must be returned to the Dealer/Distributor at the owner's expense. The Dealer/Distributor will assume cost of the shipping one way in regards to any warranty claim. Freight is standard UPS ground. Any expedited services are at an additional charge and will be paid in full before shipping at the owner's expense. The shipping cost of warranty/parts out of the continental USA, will not be covered under warranty. The labor charge out of the continental USA is also not covered under warranty.

Fuel system problems caused by the failure to use fresh fuel (less than 30 days old)) - Gummy deposits, varnish and/or corrosion due to gas are not covered by warranty. Since we have no control over the quality of gasoline and we know it deteriorates with age, the warranty defines "fresh" fuel as less than 30 days old.

Warranty Claim Procedure

All warranty claims that are done in the field must be handled as follows:

1. Customer must call the Dealer/Distributor and acknowledge the problem.
2. If the problem can be solved in the field, new parts will be shipped, invoiced and paid for. A credit will be given once the old parts are returned, if covered by warranty.
3. Parts to be replaced must be returned at the owner's expense within 30-days to receive credit.
4. If the problem is deemed too severe to be fixed in the field by the customer, then the customer must bring the saw mill at the owner's expense to the closest Hud-Son Dealer/Distributor for repair. If the Dealer/Distributor is not qualified to make the repairs, then the equipment must be returned to Hud-Son Forest Equipment at the customer's expense.
5. If the problem is not a warranty problem, the customer will be charged for the parts replaced and the labor time spent repairing mill.
6. Any modification to the band mill that is performed by any personnel other than Hud-Son Forest Equipment direct staff voids the warranty.
7. Any parts that are replaced without the discretion of the Dealer/Distributor voids the warranty on the part the customer is replacing and no reimbursement will be made.
8. Parts purchased by the customer from an outside source, without prior approval from Hud-Son Forest Equipment, Inc will **NOT** be reimbursed.

ALWAYS CALL YOUR SERVICING DEALER FIRST!

Dealers/Distributors carry parts and are very knowledgeable with the inner workings of your sawmill. Remember that modifying your mill or using parts that are not Hud-Son Forest Equipment approved, can void your warranty. No warranty on labor or shipping.

Warranty/Service Information:

Please contact our warranty department with any issues or to reorder parts.
Phone: 1-800-765-SAWS Hours of Operation: M-F 8:00-4:30; Saturday 8- NOON est

HUD-SON FOREST EQUIPMENT WARRANTY



3 YEAR CONSUMER HOME OWNER
1 YEAR COMMERCIAL USE

Hud-Son Manufactured Products are warranted to be free of manufacture defects in materials and workmanship under normal use and service for a period of time from the purchase date of invoice. Warranty is limited to the repair of the product and/or parts needed or replaced.

HUD-SON FOREST EQUIPMENT WARRANTY DOES NOT COVER THE FOLLOWING CONDITIONS:

A - Down time or loss of funds, money, and income during repair time.

B - Machines or parts lost or damaged during shipments or handling/shipping companies. Warranty does not cover shipping costs or next day air costs.

C - Normal service wear items such as, but not limited to: V-belts, air filters, fuel filter, oil filters, blades, cutting item, any item that requires servicing.

D - Modifications, alterations, tampering repairs done elsewhere other than by an authorized Hud-Son Forest Equipment Dealership.

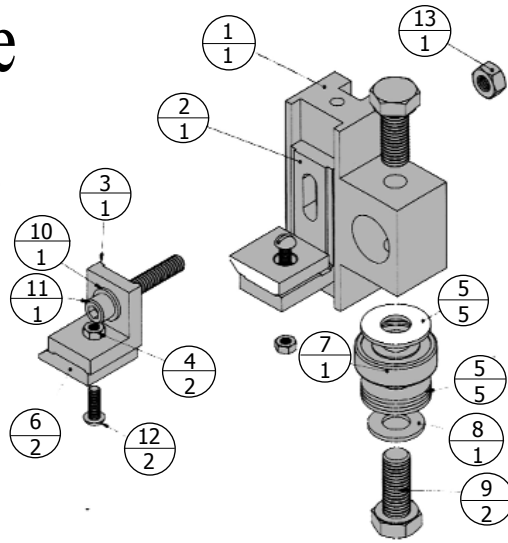
E - Products manufactured by other manufacturing companies, such as, but not limited to: Engine and Hydraulic Components.

F - Customer is responsible to return defected parts to the Dealer or HFE at their expense. (If requested)

G - Warranty registration is required to process claims. If warranty registration is not on file a copy of the original invoice may be required before processing claims.

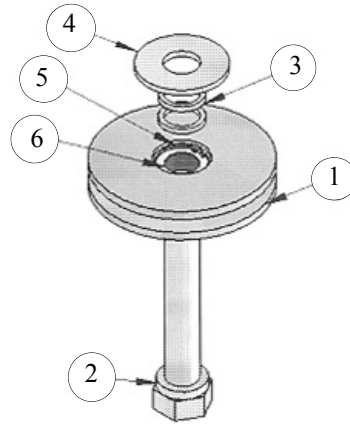
Components used on Hud-Son Forest Equipment products that are manufactured from another company such as, but not limited to engines, pumps, valves, hydraulic components, applies to that Manufacturer's Warranty Policy.

Blade Guide



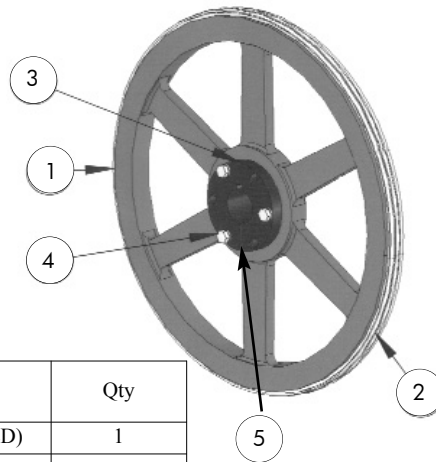
Item No	Part No	Description	Qty.
1	976-001-01	S Guide Body	1
2	976-072-1	Long Shoe Holder	1
3	976-072-2	Short Shoe Holder	1
4	F-59351	M4 x .7 Metric Hex Nut	2
5	F-93392	3/8 flat washer USS larger, zink finish	5
6	CP20-10A	Guide Shoe (sold as pairs)	2
7	6200-2RS	6200-2RS Bearing	1
8	F93370	3/8" flat washer, SAE small	1
9	F-42033	Hex cap screw, M10 x 1.5 x 25 -- 25S	2
10	33074	Flat Washer Selected Narrow 0.25	1
11	F-73168	SHCS 0.25-20x1.5x1.5-S	1
12	F-65622	Slotted RDHD Screw #8-32x 1/2"	2
13	F-59756	1/4" Course Thread Zinc Finish Hex Nut	1

Track Wheel Assembly Parts List



Item No.	Part No.	Description	Qty.
1	WHE-04-12-53	TRACK WHEEL	1
2	HAR-12-12-64	SHOULDER BOLT	1
3	HAR-55-12-1000-125	3/4"X1"X1/8" ZNFW	2
4	HAR-50-12-1166-76	3/4" ZFW	1
5	PIN-08-25	C-CLIP	1
6	BEA-03-12-24T	3/4" BEARING	1

Sheave Assembly Parts List w/Belting for Sawmill



Item No	Part No	Description	Qty
1	WHE-02-44-288	18" SHEAVE (RED)	1
2	BEL-04-58-056.5	Belting Crown Top	1
3	BUS-01-24-256	Q-BUSHING	1
4	HAR-01-05-32	Bolt	3

DISPUTES

All disputes, claims and causes of action arising out of the delivery, use, or warranty claims for personal injury and or property damage must:

1. Claimant must provide a written notice of the claim or dispute to the company (at the address below) at least 30 days after the claim arose prior to commencement of any action;
2. Company has 60 days to make a decision on the claim and will provide a written response to claimant;
3. No action may be commenced until after the company has provided its decision on the claim;
4. All claims against the company for any cause related to delivery, design defects, repairs, use

of the equipment or warranty shall be filed in Supreme Court, Oneida County, State of New York. The parties may file for Arbitration in Oneida County New York after consent by both parties.

5. Construction and interpretation of this agreement and any and all claims shall be subject to the Laws of the State of New York.
6. The address for submission of claims is:

Hud-Son Forest Equipment
PO Box 345
8201 State Route 12
Barneveld, NY 13304
7. Notices under this agreement must be in writing and sent by certified or registered mail.

MAINTENANCE NOTES

Thank you for choosing



Hud-Son Forest Equipment, Inc.

8201 State Rt. 12, PO Box 345 Barneveld, NY 13304

info@hud-son.com

We have an onsite technician available to answer any questions

Monday - Friday 8 to 4:30 and Saturday from 8 to noon. 315-896-7297.

WWW.HUD-SON.COM • 800.765.SAWS