WILLIAMS HUSSEY 206 MOLDER Variable Feed Molder User Manual

Contents

WILLIAMS & HUSSEY

WILLIAMS HUSSEY 206 MOLDER Variable Feed Molder

WARNING: FOR YOUR SAFETY READ AND UNDERSTAND THIS MANUAL PRIOR TO USING THE SAW. REVIEW ALL SAFETY RULES AND OPERATING INSTRUCTIONS FREQUENTLY.

This manual is provided for your convenience in the use and care of your machine. These instructions include operation, precautions, preventative maintenance and other pertinent data to assist you in assuring long life and dependable service from your machine.

Molder Model: 206.208/230.1 v2.0 206.208/230.3 v2.0 For Serial numbers 20210492060001 forward April 2021

www.williamsnhussey.com 1 (800) 258-1380 (641) 843-3240 fax (641) 843-3869 Customer Service is available Monday -Friday, 8:00 AM- 4:30 PM CST

SPECIFICATIONS

- **MOTOR**
  - 2HP
- **RPM**
  - 6900
- **FEED RATE**
  - 0-19FPM
- **MAX PROFILE DEPTH**
  - ¾”
- **MAX PROFILE WIDTH**
  - 6 ¾”
- **PLANING WIDTH**
  - 7”
- **MIN STOCK LENGTH**

    - 9”
- **MIN STOCK THICKNESS**
    - ¼”
- **MAX STOCK THICKNESS**
    - 8”
- **WORKING HEIGHT**
    - 35”
- **OVERALL HEIGHT**
    - 50”
- **OVERALL WIDTH**
    - 22”
- **OVERALL LENGTH**
    - 28”
- **SHIPPING WEIGHT**
    - 260#

ACCESSORIES

- **ELLIPTICAL JIG**
    - EJ-92
- **CRANK EXTENSION**
    - 54-306

SAFETY RULES

Your W&H Molder has been designed for maximum safety, however, as with all power tools; there is a possibility of incident or injury to the operator. Therefore, it is imperative that this manual is completely read and understood before using. Use your W&H Molder with respect and caution. Following stated and inherent safety precautions will considerably lessen the possibility of personal injury. If normal safety measures are not taken or are overlooked, the possibility of incident rises tremen-dously. These safety measures are simple to follow, and the injuries that could happen are not worth the few minutes saved by ignoring safety. The W&H Molder was designed for specific applications. Do not modify or use the machine for any purpose other than what this manual describes as its capabilities. Substituting a motor with a horsepower rating over 2HP consytitutes a modification. Any modifications or improper use to the Molder-Planer may result in personal injury, and will void the warranty. Please contact us if you are unsure about safety protocol before using the machine.

SAFETY CHECK LIST

DON’T TAKE UNNECESSARY RISKS!

- Failure to read and apply manual instructions will cause poor performance, unnecessary repairs and injury.
- Wear safety glasses, hearing protection and respiratory protection.
- Disconnect the power before servicing or changing knives.
- Wear footwear that does not slip. This will help you keep proper footing and balance. Always stand beside the machine, never in the way of the in-feed and out-feed areas.
- Keep knives sharp and clean.
- Make sure the machine has proper grounding.

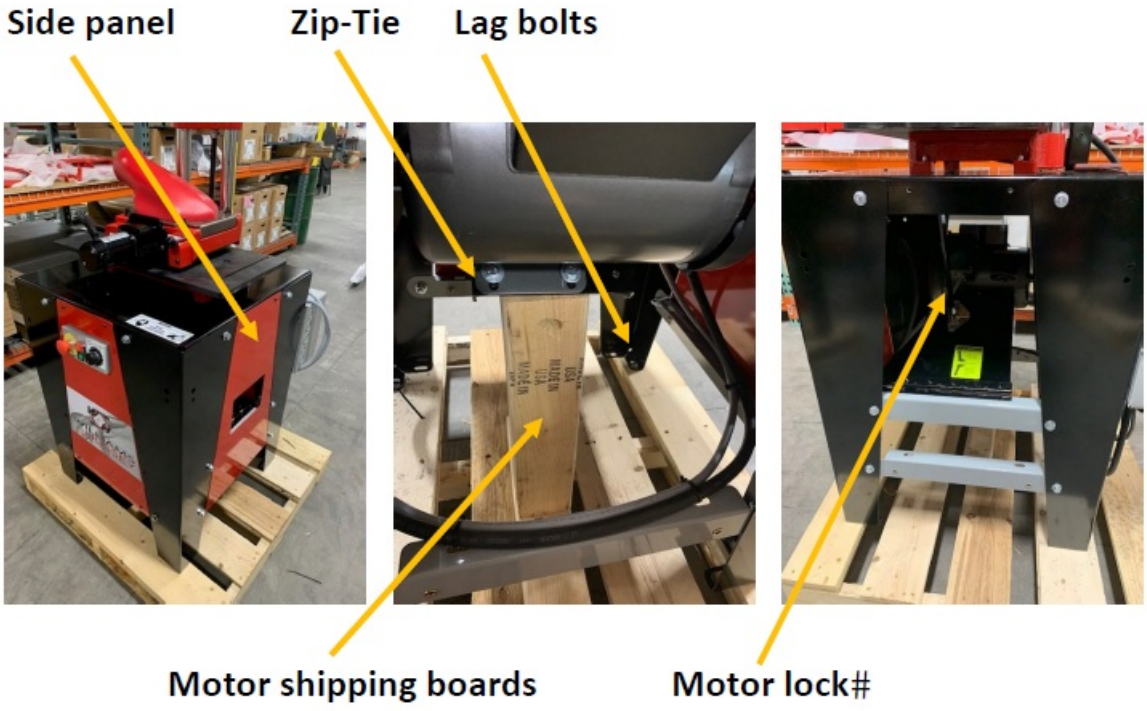
- Make sure all guards are secured and in working order.
- Remove all adjusting keys and wrenches before starting.
- Check the stock for loose knots, nails, and foreign matter.
- Keep the machine in a dry, clean, and well-lit area.

PREPARING TO USE THE MACHINE

1. 1. Disconnect the power source while going through these procedures.
   2. Check knives to ensure that the bolts are tight. If molding, set your guides for the stock path through the knife area. If plaining, you may or may not wish to set your guides. Many times, they are not needed in plaining.
2. When molding, the head scale seting must be set to within 3/16” of the height of your stock. The “0” on your scale is set to the top of your GS-2 guide system sub-plate. This means you would set the machine head reference to the scale at ¾” in order to take a full profile pass on a ¾” piece of stock. You could set the machine head in reference to the scale at 15/16” for a maximum height first pass (3/4” + 3/16”). This seting will provide the proper roller tension. Any other seting higher from the thickness of the stock entering the machine is unacceptable and dangerous. See the molding section for more information.
   The chip extractor loads first under the out-feed end of the head with a lip under the cast head. You then finish by
   atiaching the chip extractor with its pin. Make sure the pin is inserted all the way in until you feel it “catch” on the spring-loaded catch.
3. Check rotational clearance of the knife with the chip extractor in place. Rotate the knife by hand at the 5” pulley cut out on the inner belt guard to ensure the knife area is clear.
4. Do not stand or let others stand in the out-feed area or directly in line with the in-feed of the machine.
5. With the head set in the proper position, tighten the head locking bolt firmly. This is essential for safety and to ensure the machine head will stay where you have set it.
6. Test a piece of stock, with the machine off, to see if it will make contact with the in-feed roller.

UNPACKING INSTRUCTIONS

- Remove clear packaging.
- Inspect the machine for any shipping damage. Remove the side covers.
- Cut the zip-tie around the motor.
- Remove the motor shipping boards.
- Remove the lag bolts holding the machine to the pallet. Lift the machine off of the pallet.
- Re-install the sides.
- Before elevating the molder, loosen the motor lock.



Please note that the Grey #12-4 wire that is used on the singly phase machines are preprinted with lead numbers on them below is the wiring instructions for wiring in your plug or directly into your power box. Please call with any questions.

Wiring your 154/ 206 220Volt Molder

- Wire # 1 is a hot wire
- Wire # 2 is the neutral
- Wire # 3 is a hot wire
- Green/ yellow stripe is ground

Caution:
If you have 3 phase do not split the wild leg off for 1 phase Wiring for your 220V molder.

Wiring your 154/ 206 3phase molder
Connect power to the Black, Red, and orange colored wires.

Note: Orange is for a wild leg if you have one. Failure to do so will damage the control panel. If you facility does not have a wild leg connect as per diagram If your machine is rotating the incorrect way switch only the black and red wires

green is ground white is neutral

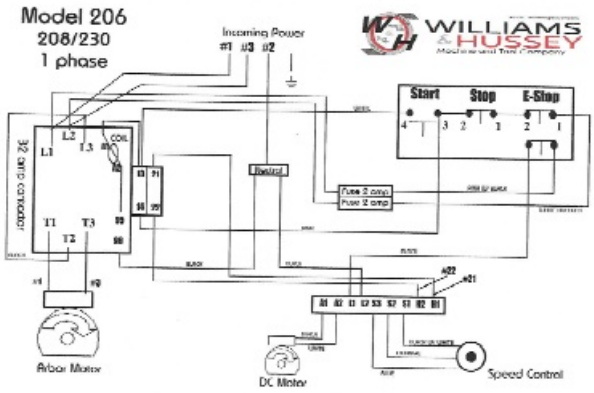
Wiring your 209 molder

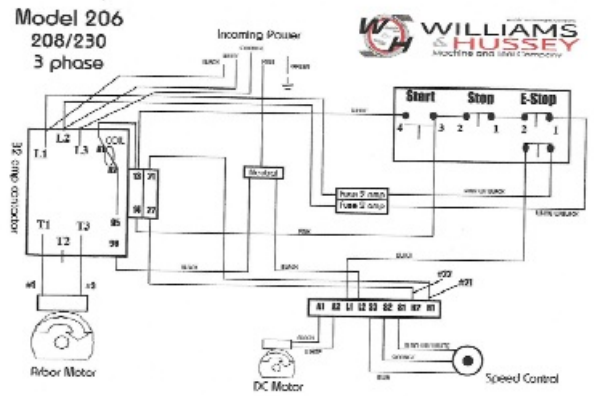
- wire # 1 is Hot
- wire #2 is neutral
- wire #3 is not used
- Green/ Yellow stripe is ground

Electrical controls
Photo at right shows the standard electrical control box that houses the contactor to control the cutter head motor and the DC drive board to con- trol the feed wheels. The image below shows the start/station controls from the front of the machine and their purpose. E-Stop-will shut down both cutter head and feed rollers. Start/stop station will start and stop the cutter head Speed Dial-will control the speed of the feed rollers 0 is stop 10 is fastest

Drive Motor: the drive motor is plugged into the electoral box through the special plug that is wired into the control box and the motor. As shown below.

Adding plug to cord: simply add the plug from your local hardware store that matches your facility. We do not ship with the plug in due to the fact that there are so many different versions.





VARI-FEED OPERATIONAL TIPS

The main control start button starts the knife motor and the Vari Feed motor. The speed control knob controls the speed of the feed rollers. The stock feed rate is approximately from 0 to 19 fpm (feet per minute), depending on where the knob is set. Higher rates of feed are only recommended for lighter depths of cuts. Turn the knob clockwise to increase the feed rate. When the dial is in the 9 o'clock position the feed speed is approximately 4 fpm.

- At the 12 o'clock position= approximately 6 fpm
- At the 3 o'clock position = approximately 14 fpm
- At the full to the right position = approximately 19 fpm

Always remember to set your stock rate prior to entering the stock into the machine. The feed rate may be changed during the cut. The vari-feed option allows for high feed rates on relief cuts on the backside of casings. The vari-feed multi-pass combination pro- vides the versatility of slow feed rates on deep hardwood profiles making possible two or three passes to finish. On deep and wide profiles you can now raise the knife for a partial profile cut and enter the stock very slowly, while engaging the butt into the knife gentiy, letting stock move under the out-feed roller before engaging a higher feed rate. This reduces the inci- dence of a large chip out, a chatter mark or snipe on the first few inches of your stock. You have the same advantages exiting the cut. As the grain structure changes throughout the cut you can vary the stock feed rate to reduce the possibility of chip outs and spoil age or your piece of stock. Before starting the machine first familiarize yourself with the rest of this "Owners Manual". It s very important to safely operate the machine as outlined in this "Owners Manual. operate the machine only within the described design intent.

MOTOR LOCK

Your newly designed machine base has a motor lock. This new devise allows you to lock your motor in place to keep it from bouncing on the belt during interrupted cuts etc. It also allows you to modify the belt tension which can aid you in achieving the finish quality you are looking tor. To reduce tension you can crank the head down to within 1/4″ of the actual setting you will use and lock your motor. Then reset your head to the 1/4″ lower running position and your tension will be reduced. You can vary the 1/4 factor to achieve the tension you desire.

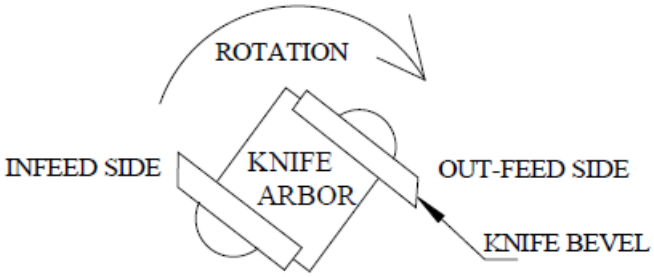
Always unlock the motor before resetting the machine head height.

DISCONNECT POWER BEFORE CHANGING KNIVES!

PLANER KNIVES

CAUTION; when planing always back off all four pressure screws to a position %" higher than the fully seated position. You will create too much roller pressure and feeder problems if you don't. Remove the chip extractor by pulling out the pin and lifting the infeed end up first and pulling it back to clear the lips hold. Clean off knives and machine arbor. Set one knife at a time in place against the lip of the arbor. Place the "bevel" of the knife as shown in the illustration below. Tighten the eight bolts securely using a 7/32″ allen wrench. After tightening, double check to see that the knives are snug against the lip.

MOLDING KNIVES



VIEW FROM PULLEY SIDE OF MACHINE

KNIFE SHARPENING

For fast and professional results with minimum edge loss, return your knives to the factory for re-sharpening. Have your knives resharpened when you first notice some dullness. This gives optimal performance and maximum life span out of the knives. Molding knives should be surface ground on the face in pairs or the profiles should be reground. Sometimes it is better to regrind the profile. If you send them to us for regrinding, we will use the best method that will prolong the use of your knives. Planing knives may be ground on the surface or on the bevel. Both molding and planing knives have an edge angle of 57 degrees measured off the back of the knife. The use of dull knives will put a strain on the feed mechanism and will result in your need of a repair. Any problems created due to the use or dull knives are not covered under the warranty.

HOW TO MOLD

You will normally use the guide sub-plate. When using the optional jig you willtake it off. Always use your sub-plate on any job where the knife is designed to cut below the bottom of the stock. This type of knife will hit the base of the machine if a sub-plate is not used. An example of this situation would be the molding of half or quarter rounds.Ihe 0 on your head setnng scale rererences the top or the sub-plate supplied with your machine. For example, iT you were milling a piece of stock you would set the machine head at the * setting. Adjusting your machine head to this scale setting will give you a full pass cut and a completely finished profile. This is a multi-pass machine and with multi-pass, you can add 3/16′, in this example, to the 3/4″ dimension for a first pass setting of 15/16″. In this example you may set the machine head to any scale setting between 3/4″ and 15/16 for a first pass.

These settings allow you to achieve proper roller tension for holding the stock and provid- ing d sare operauon. Be sure to check for sufficient feed roller contact before proceeding to use this setup and be sure to rotate your molding knives to check for knife rotation clearance with the chip extractor installed and the power off before starting the machine. Turn the knife arbor by turning the motor pulley at the inner guard opening Other molding tips Stock height should be within 3/16″ of finished molding size. If making one pass only it should be within 1/32″. Stock width should be uniform and to finish molding size. Saw ripping to width will not make the stock uniform enough for smooth flow through the guides, and thus, will not result in satisfactory molding. We recommend that all stock be planed in both width and height to finished molding size betore setting up to do the profile. When

tightening the knives, push them firmly aga inst the lip and sideways against the bolts in the direction of the tube side of the machine for an exact profile match up.

Hold secure while tightening bolts. Set the head height to within 3/16″ of your stock height. This will give you proper roller tension on your molding stock. This is the correct way to mold. it is acceptabie to leave 3/16″ of the Cut tor muitple passes. But ror sarety reasons leave no more than s/16 On some extremely deep or wide cuts, some prior stock removal will be required before molding. You may remove this stock using one of the rabbet/dado knives found in our catalog. You may also use a dado blade on a table saw. Failure to set your head height within 3/16″ of the stockk height will create an extreme satfety hazard in that possibly not enough roller pressure will be applied, or that no roller pressure at all will be applied. Do not cut a wider stock area than the knife was designed to cut. This will cause excessive heat in the knife, burn your stock and puts a harmful load on the feed system.The roll pressure screws are set at maximum molding pressure from the factory. They are screwed into the head as far as possible and the check nut is tightened. When you use the machine for planing you will need to reduce the roller pressure. Loosen the pressure screw lock nut and screw out each pressure to a setting ” higher than the fully seated position and retighten the lock nut. To change the molding knives, remove the chip extractor. set one knife at a time in place with the bevel edge toward the in-feed end of the machine. Firmly push the knife down against the arbor lip and sideways against the bolts in the direction of the tube side of the machine. Hold secure while tightening bolts with a 7/32″ allen wrench or drive.

GUIDES

Guiding your stock

Your machine comes with the GS-2 guide system, which includes a flex guide and a solid guide to guide, your stock. To set these guides, first attach your knives to the knife arbor in the position you have chosen, often a place where you can get the most out of your roller surfaces. Panel knives would go to the far right. Smaller knives to the post side half of the mounting area and larger knives to the central posiions. Roll one knife down pointing to the machine bed and place a sample piece of stock you are going to mold on the bed. Align the stock to the knife profile and carefully lower the machine head until the roller puts pressure on your stock to hold it securely. Attach your flex guide to the side of the profile that will cut the least deep into your stock. This will give the longest pOssible life to your flex guide. The beveled portion of the guide should be facing the stock. Put about a 1/32″ amount of pressure on the flex part of the guide. This will keep you stock from wandering within the glidepath. Pull the handles up and away from the stock path. Attach your solid guide on the other side of the stock. Push it up firmly against the stock and tighten the handles angling them away from the stock path. Remove your set up piece of stock by raising the machine head, and pulling the stock out from the bed.

|Your knives will usually cut into one or both guides. This is normal and expected. The guides are effective and last a long time after being cut into many times. As you become more familiar with the machine and its use, you will want to make wooden guides to suit specific jobs. Always make a complete sample (top and bottom) of crowns and keep sample to set up on. Make your bottom cut first when milling bed and crown moldings. You may want to add a key cut as a guiding mechanism for your top profile.

When planing the edge of stock, a high, square, relieved guide is needed in order to have the edge reasonably quare and to provide stability. The center reliefs are to reduce friction. Some profiles are too deep to make on the w&H. In some cases you can rotate the profile into a flatter position to effectively re- duce the depth of cut. A “V block” guide would be made to guide your stock. The profile knives would have to be custom made to use in this V block position. When making tongue and groove stock, a serious and detailed approach is needed in order to achieve a uniform fit. Carefully pre- inspect your stock for cupping and warping. You need to plane all your stock to one uniform size. The guide thickness should be 3/8″ thinner than your stock or your roller will scuff on the guides when the stock has left the ma- chine and the rollers are in their rest positions. When running thin stock, you will need to fasten a sub-plate between the guides to maintain a thick enough guide to control your stock.Always check your knife clearance to the guide. Clear away any interfering portion of the guide by gently lowering your knife down
into the guides to just below your running position.

MOLDING PICTURE FRAMES

Decide whether the rabbet or profile cut should be done first. If you are going to make the rabbet on the w&H Molder, do the rabbet first. In order to utilize the W&H Molder for rabbets, a rabbet knife with a depth of cut equivalent to the depth you need should be ordered. If we do not have a standard knife with the depth you seek, we can make a special knife to suit your needs.

ROUND TOP CASINGS cONSTANT RADIUS SIZE ARCS

We manufacture knives with the profile cutting the deepest portion of the cut on the open side of the machine. Notify us when you order a knife if you want the deep side of the cut on the vertical tube side of the machine. The set up and operation of the W&H machine for a round top molding job is very similar to the straight molding set up. One main difference is the molding stock will ride piggybacked on a template to enable the knife to clear the jig guiding hardware. Our E92 Eliptical Jig is not needed for a fixed, constant radius. Stock preparation can be done in many ways. The following is one example. First determine the angle needed to cut the wood sections in order to stay within the selected radius. Lay out the wood sections by marking the angles while being careful to select cuts for grain structure and color. Cut the sections and biscuit join them together with glue. We made a fixture to

band saw the inside and outside radii consisting of a pivot bar and bracket. We mounted the pivot bar to the stock on the scrap portion of the inside radius. The pivot bar is drilled with numerous holes to accommodate any radius sizes. You may also want to design a fine adjuster to allow you to make any radius in between your adjusting holes. Make sure the outside radius is cut first. The guides should be 20″ long, which is the length of the GS2 guide system, or 14″ long if you are just using the bed of the machine. The guides may be made using the band saw set up. We make one guide for the in- side radius and one for the outside radius. We use MDF board.

ROUND TOP SETUP

1. Make sure power supply is disconnected
2. Raise the machine head and set the stock on the bed.
3. Align the stock with molding profile.
4. Lower the head to pinch the stock.
5. Set the guides and clamp them in place.

Raise the machine head, remove the stock, and reset the head to within 3/16” of stock size. Check to see that the rotating knife will not hit anything you don’t want it to on start up. NEVER attempt closed loop molding. It is an unsafe procedure; you will not have enough roller pressure initially.

RAISED PANELS

All of our panel knives are designed to produce a ” tongue. Be sure to select a panel knife based on the fin- ished panel thickness. A panel must be 9″ or more in the direction you are molding in order to not have the panel come off of one roller before it engages the second roller. When you use multiple passes you must have at least 9″ of panel remaining in the direction of the cut in order to have a least one roller on the panel at all times. If you desire a different tongue size or have a panel thickness other than ” or 5/8, a special knife can be ordered and shipped quickly by w&H.

THE RAISED PANEL SET UP

1. Disconnect the power suppiy.
2. Install your knives over toward the tube side of the machine allowing enough room to install your guide.
3. Index the knife arbor so the profile will be seen against the bed. Raise the head to allow the panel to be laid on the bed and to be lined up with the profile visually.
4. Once you have found the proper position for the panel, lower the head so the rollers will put pressure on the panel while Dutting the guide against the panel. lignten your guide.
5. Raise the head, pul the panel out of the machine, and lower the head to within 3/16″ of the panel height. Rotate the blade arbor by hand to insure nothing is interfering with its rotational path. Mould the panel cross grain ends first. Stand somewhere between the open side and in-feed side.

RAISED PANEL ISSUES

It takes some practice to make a good panel. It is helpful to keep a slight upward pressure on the panel as it is being molded with a steady pressure against the guide. Because panels are normally larger than the 7″ cutting capacity of the machine, the panel must pass beneath the open side of the head. There is approximately 1/32″ clearance between the top of the panel and the head of the machine, provided the head is at stock size setting, and not below. Many users try to create a slightly deeper cut to modify the tongue size or change the profile appearance and end up dragging and pivoting the panel away from the guide path. The head must be set at the panel thick ness and not below it in order to have clearance to pass the panel through the machine in a satisfactory way.

HOW TO PLANE

CAUTION! When you use the machine as a planer you will need to back off all four pressure screws so that you will not have too much roller tension, or you will risk shearing a pin in the large bronze worm gear. Measure the thickness of your stock. .The amount of stock that is removable in one pass is dependent on the density of the wood (relative hardness), how wide the cut is, and the moisture content of the stock.

See the table of contents section tor knife changing and installation. Loosen the planing head locking knob (54-21). To initially begin planning, set the head position to a height 1/32″ less than the dimension of the stock entering the machine. One-third of a turn on the elevating handle will equal 1/32″. Tighten the head locking knob. Make sure the chip extractor is in place, the front lip engaged into the head and the pin is firmly seated. Utilize a high, square, relieved guide when planning the edge of stock to ensure the edge will be reasonably square. A relief in the vertical wall of the guide reduces friction. see the guide section for a picture of the edge guides.

THREAD LOCKING INFORMATION

A medium-strength thread-locking compound used on some parts prone to loosen with vibration. Use two drops on the thread area of the parts listed below.

- P-122 post-side axle.
- 54-16 Rest pins.
- 54-15 Pivot screws.

A small tube of thread locker is available for purchase. Part number P-242 Do not use on P-124 in-feed axle, or on P-224, out-feed axle.

CHATTER

Snipe

FEEDING PROBLEMS

Make sure that power is disconnected before inspecϴng machine.

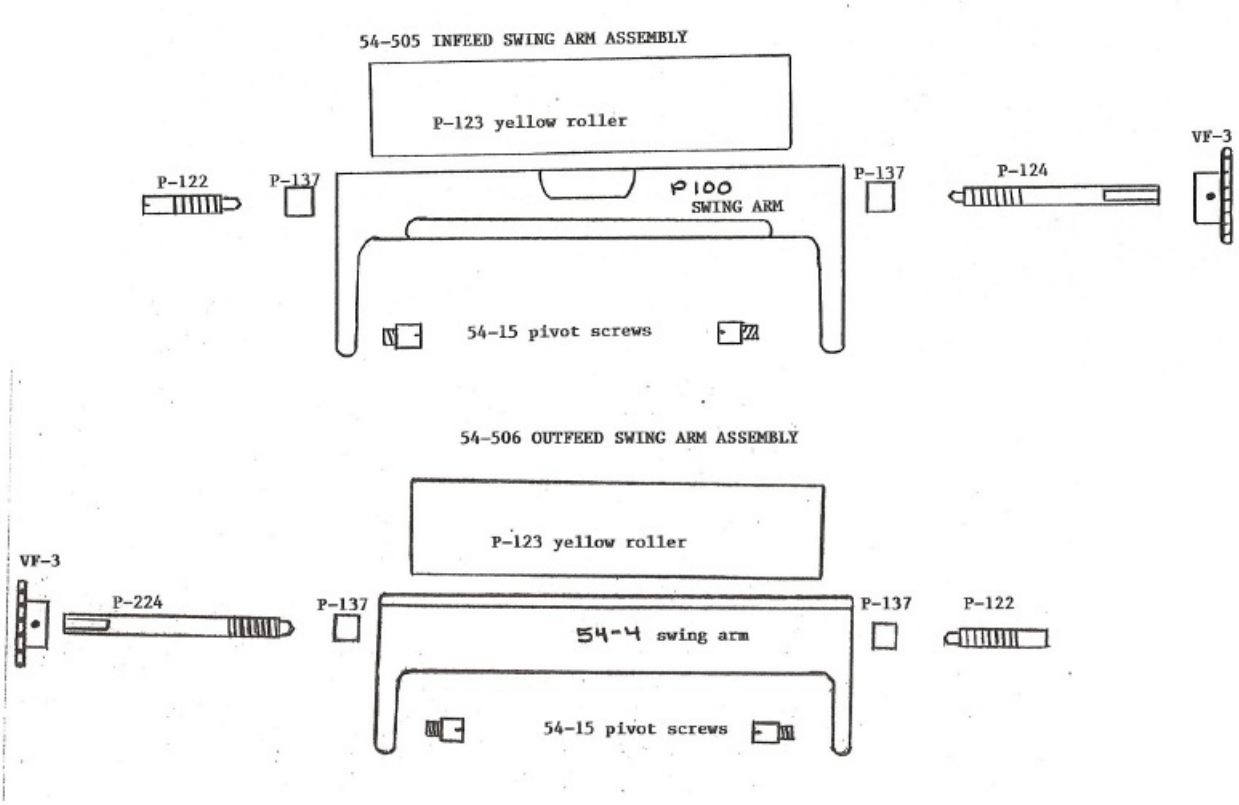
INSTRUCTIONS FOR REMOVAL OF FEED ROLLER

- Unplug machine, take off chip deflector, raise head, and remove presSure screws over swing arm.
- Remove two 54-15 pivot screws and remove swing arm, leaving chain connected to mating sprocket. Reinstall each pivot screw with a drop of medium strength thread locker.
- Take the sprocket off the swing arm axle by putting the feed roller in a vise. Use a couple of small adjustable wrenches attached to the Tlat on the long axle to loosen it.
- Put a good square shank flat bladed screwdriver into the slot on the short axle. Push in as hard as you can while using a wrench on the square shank r the screwdriver to lo0sen the short axle. somenmes this axie will not come out. Hack saw it off if it won’t. If you need to save the roller, pull the roller out of the swing arm by lifting it up and pulling it out with the short axle still in the roller. Keset the roller in a vise and use a small pipe wrench to remove it from the roller.

REASSEMBLY The rollers are constructed with a shallow hole in one end anda deeper hole in the other. The P-

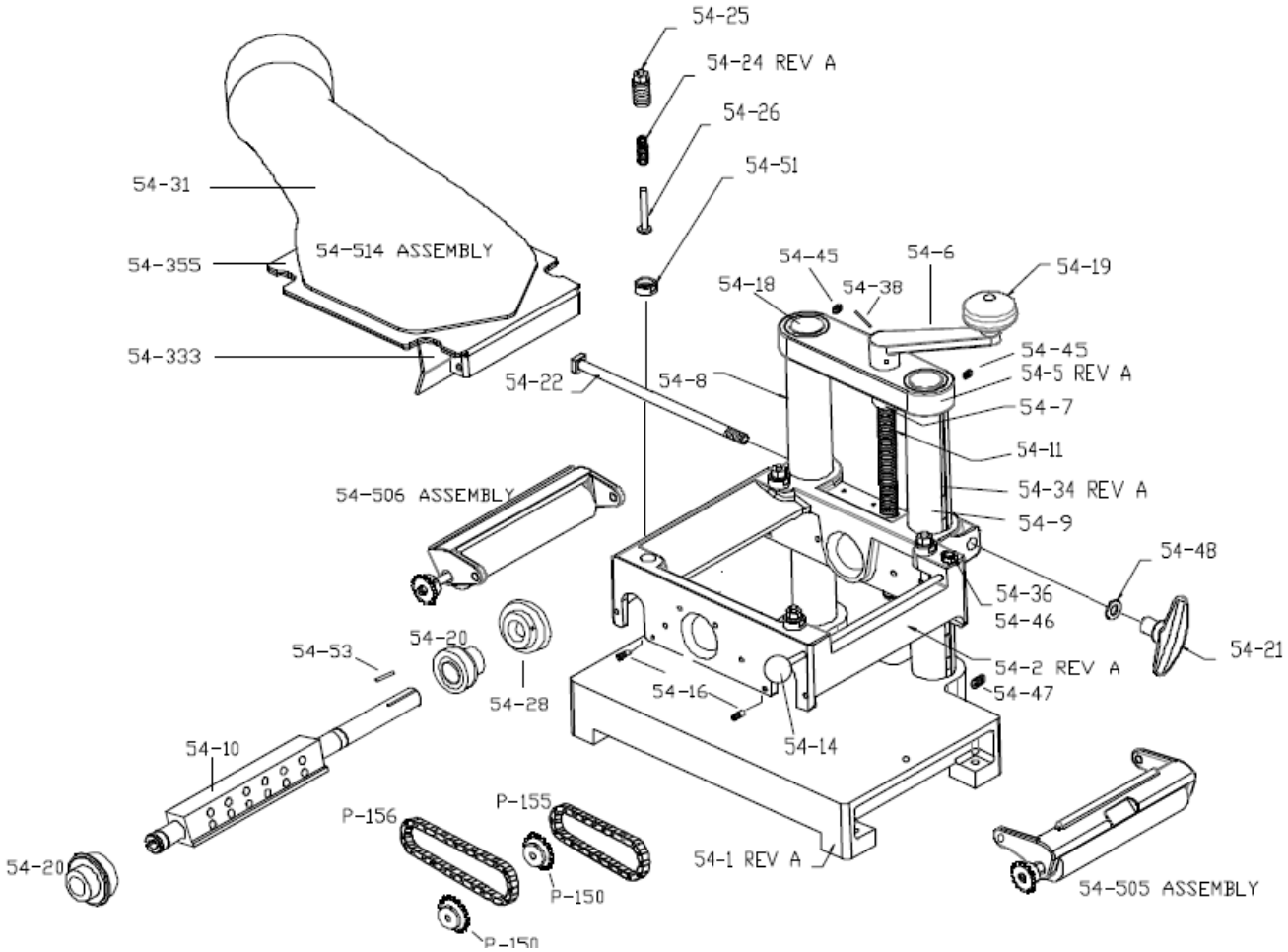
122 post side axle always goes in the short end. Reinstall the P-122 axles with two drops of medium strength thread locker on the thread portion. Do not use thread lock on P-124 or P-224. The longer axle goes in the deeper end. See drawing for swing arm assembly with roller.

POSITION OF SPROCKETS First position feed motor shaft sprockets with hubs facing in toward chain guard. The first sprocket slides up to the end of the flat on the motor shaft and the second right up against the first. Chains should (under load) run in a straight line from these sprockets to the roller sprockets. Adjust the roller sprockets to achieve this alignment. Feed roller sprockets should be positioned based on the feed motor sprockets already positioned. The chains should run in a straight line from the feed motor sprockets to the roller sprockets when the machine is under load.



MACHINE EXPLODED VIEW

When reinstalling the vari-feed unit after a repair check thee chains for proper tension. The short in feed chain should have a small amount of slack in it and the long out feed chain should have plenty of slack. This is the correct setting. To obtain the correct setting, in most cases, you would push the unit toward the in-feed end of the machine as you tighten it using up the attaching boit hole clearance for adjustment. This should give you the optimum chain tension and slack.



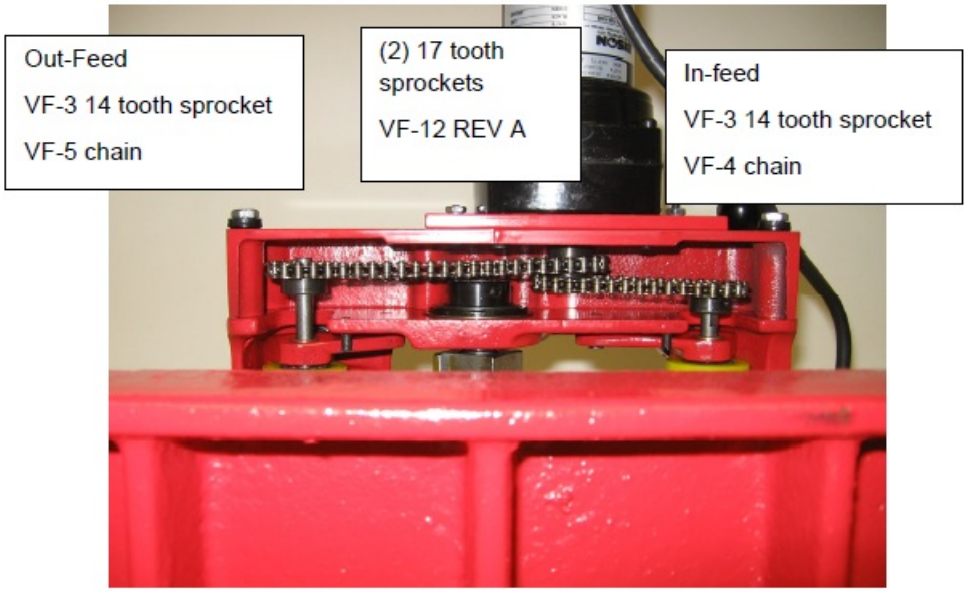
VARI-FEED VIEW

VF-100 assembly
Does not include roller sprockets and chains

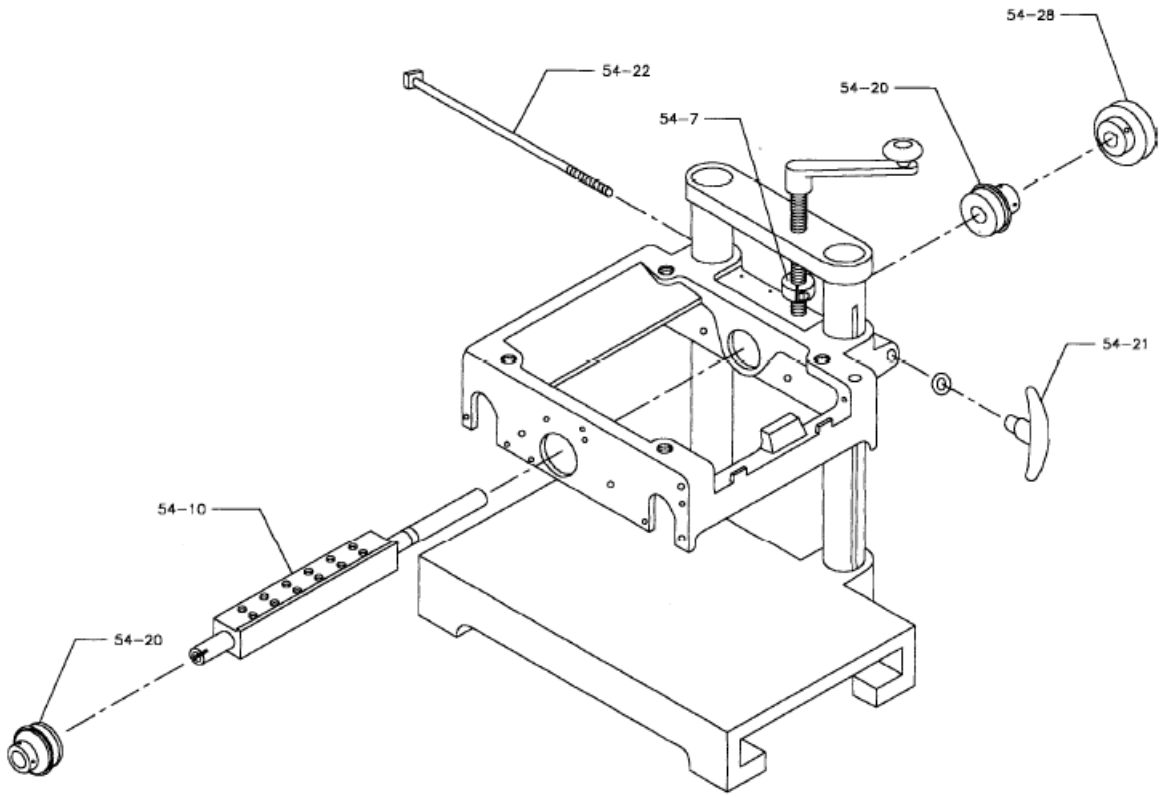
- **VF-1** Vari-Feed motor
- **VF-2 REVA** Aluminum motor mount
- **VF-3** Roller sprockets, 14 tooth
- **VF-4** Short chain, 36 pitch
- **VF-5** Long chain, 54 pitch
- **VF-9** REV A Chain guard
- **VF-12** REVA Motor sprockets, 17 tooth

Vari-Feed Removal
Loosen the set screw on the in-feed roller chain sprocket. Loosen and remove the (2) hex head bolts, and (1) socket head bolt holding the chain guard to the machine head. As you pull the unit free, pull off the in-feed chain sprocket you loosened. To remove the motor from the motor mount and chain guard, remove the two motor shaft chain sprockets and loosen and remove (4) socket head cap screws that are in a rectangular pattern surrounding the motor gear housing. To disassemble the motor mount from the chain guard, remove the two remaining socket head cap screws with nuts.

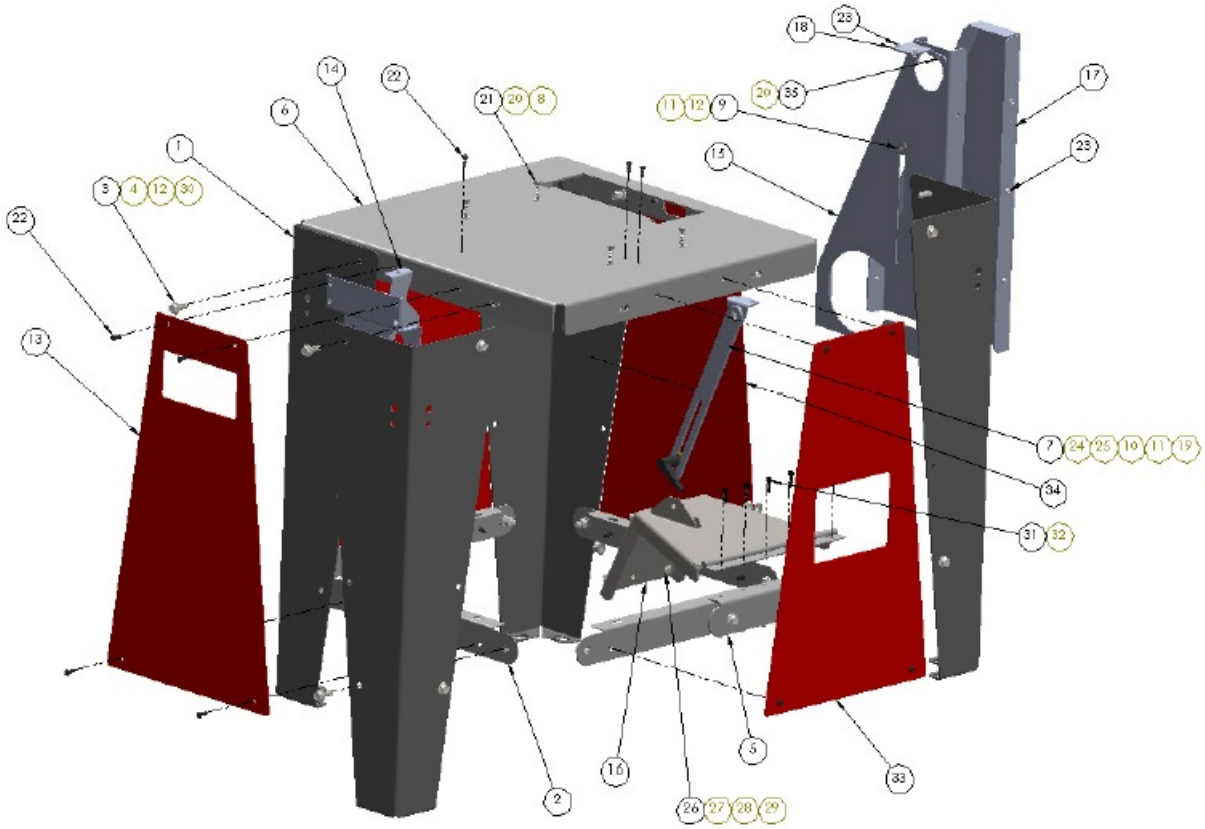
UNDERSIDE VIEW OF SPROCKETS AND CHAINS



ARBOR REMOVAL VIEW



Stand exploded diagram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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	088181-09	LEG, HD/CD EXTENDED	4
2	084177-06	CROSS BRACE, SHORT	4
3	082102	HEX FLANGE BOLT, 3/8-13 X .75	18
4	084180-00	3/8-16 Hex Nut	18
5	084177.07	CROSS BRACE, MOTOR PIVOT	1
6	084177.05	Top, Molder Stand	1
7	084177.11	Rod, Lock Bar	1
8	082023-04	1/4-20 x 1 1/4	4
9	54-402-20	BHSC 5/16-18 x 3/4	1
10	54-402-23	SCREW SHOULDER, 3/8 (5/16-18)	1
11	082024-02	Nut, 5/16-18 Elastic Stop ZP	2
12	080674	3/8" Flat Washer	20
13	084177.30	Front Cover, Molder Stand	1
14	084177.21	Control Bracket Assembly	1
15	084177.17	Belt Guard, Inner	1
16	084177.09	Motor Mount, w/ Hinge	1
17	084177.19	Belt Guard, Outer	1
18	084177.15	Mount, Belt Guard	1
19	084177.13	Anchor, Lock Bar	1
20	084173	Wshr. 1/4 Lock ZP	6
21	038738	NUT HEX 1/4-20	4
22	052511	1/4-20 X 5/8" SOC BIND HEAD CAP SCREW	19
23	697162	Scr 10-24 x 3/8 SHCS	8
24	900528-00	CLAMPING HANDLE	1
25	900529-00	5/16 T-Nut	1
26	082097	HHCS, 5/16-18 X 3/4	4
27	099361-16	5/16" FLAT WASHER	4
28	099384-07	5/16" LOCK WASHER	4
29	099370-04	5/16-18 Hex Nut ZP	4
30	000415	LOCK WASHER, 3/8	18
31	080589	SHCS, 1/4-20 X .75	6
32	082024-00	1/4"-20 LOCK NUT	7
33	084177.32	Side Cover, Molder Stand	1
34	084177.34	Side-Rear Cover, Molder Stand	2
35	080588-00	1/4"-20 x 1/2" SHCS	2

CONTACT INFORMATION

Williams & Hussey Machine and Tool Co. 465 3rd Ave SE.

- Bri, IA 50423
- 641-843-3240 (local)
- 800-258-1380 (toll free)
- 641-843-3869 (fax)
- **customerservice@williamsnhussey.com** (e-mail)
- **williamsnhussey.com** (website)
- Business Hours: Monday – Friday 8:30 am – 4:30 pm

WARRANTY INFORMATION

Molder- 1 Year Limited
Williams & Hussey Machine Co., Inc. warrants its molders for a period of one year from the original date of purchase.

WHAT IS COVERED?
The warranty covers any defects in workmanship or materials.

WHAT IS NOT COVERED?
The warranty does not cover damage due to; modifications, misuse, improper maintenance, normal wear, wood jams or using a knife motor with a horsepower rating over 2HP.

WHO IS COVERED?
The warranty covers the initial purchaser only.

LIMITATIONS ON WARRANTY

Williams & Hussey shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special, or con sequential damages arising from the use of our products. Motors, Controls & Elliptical Jig Warranty covers any defects in workmanship or materials on original parts. Warranty does not cover defects due directly or indiectiy to misuse, abuSe, negligence or accidents, normal wear-and-tear, lack or maintenance, or improper repair or alteration.

VF-104 and VE-106
Refer to applicable motor and control warranties.

Notes & Maintenance Records

IMPORTANT
To assure product reliability, repairs, maintenance and adjustments should be performed by Authorized Service Centers, always using genuine replacement parts. For parts please call customer service or log onto our website. 465 Third Ave SE Britt, IA 50423 PH 800/258-1380 641-843-3240

- **E-mail customerservice@williamsnhussey.com**
- **www.williamsnhussey.com**

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Documents / Resources

	WILLIAMS HUSSEY 206 MOLDER Variable Feed Molder [pdf] User Manual 206 MOLDER Variable Feed Molder, 206 MOLDER, Variable Feed Molder, Feed Molder, Molder

References

- Williams & Hussey Machine and Tool Co.
- Williams & Hussey Machine and Tool Co.