HAKKI PILKE 55 PRO

FIREWOOD PROCESSOR

– Instructions for assembly, operation and maintenance
– EC Declaration of Conformity
– Safety instructions
– Guarantee terms

The operator must read and understand these instructions before operating the machine!

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1. General information

1.1. Introduction

The purpose of this manual is to ensure that the machine is used in the manner intended by the manufacturer, taking safety into consideration. Everyone operating the machine or working in close proximity to it must study this manual carefully.

Operators of the machine are expected to have basic skills in tractor handling, such as utilising the cardan shaft drive and the tractor's lifting equipment. Before commencing work, operators must also familiarise themselves with the machine's control and safety equipment and ensure their proper operation.

More information on Hakki Pilke products can be found on our website at www.hakkipilke.fi.
Keep this manual in the immediate vicinity of the machine.

1.2. Purpose of use

The Hakki Pilke 55 Pro firewood processor is designed for preparing firewood from pruned wood or logs. The firewood processor must not be used to process any treated wood, such as is found in construction waste. Sand, nails or other impurities in the wood may damage the machine.

The maximum diameter of the logs to be processed is 55 cm. This limit must not be exceeded. Machine is designed to perform the best when used +20 cm diameter trees. When estimating the diameter of the log you are about to cut, note that the shape of the log and other factors, such as branches and burrs, make the actual diameter larger, and may prevent the log from being fed into the machine. The splitting groove is designed for logs up to 60 cm in length. Never cut or split logs that exceed the maximum length.

1.3. Machine models and basic information

Model	TR	Combi	
Driving power	Tractor's cardan shaft (PTO)	PTO	Electrical
Weight	3,240 kg	3,380 kg	
PTO/Electrical drive	min 50 hp / max 500 rpm	21.3 kW (min 50 A, type C fuse)	
Height/width/length	in working position 2,900/5,970/2,740 (mm)		
In-feed/out-feed conveyor	2,740/1,800 (mm)		
Saw bar/chain	bar: 25" groove 2.0 mm. chain: 88 loops, pitch 0.404"		
Max log diameter	55 cm (Recommended minimum diameter 20 cm)		
Max/min log length	Log max 60 cm; min 25 cm		

The machine's serial number, date of manufacture, weight, operating voltage (electric-powered machine) and model are indicated on the grey type plate located on the machine frame on the right side from the operator's position.

1.4. Operating conditions

- The temperature range within which the machine can be operated is -20 to +30 °C. In the winter, the operator must ensure that there is no risk of slipping in the working area.
- The working area must be level and clear of unnecessary items. No unauthorised persons may enter the working area. The machine may only be used in sufficient lighting conditions.
- The machine may not be used indoors.

1.5.Safety instructions

- This machine is intended to be operated by only one operator. The danger zone is 10 m from the machine.
- Persons under 18 years of age may not operate the machine.
- The operator must ensure that the use of the device does not cause danger to others and that there are no unauthorised persons in the danger zone.
- The machine may not be operated while under the influence of alcohol or other drugs, or when tired.
- The machine may not be operated unless the operator has familiarised themselves with this instruction manual.
- The machine has been designed solely for making firewood.
- The machine must be placed in the transport position whenever it is moved. The machine must not be transported connected to a tractor.
- The operator is not permitted to modify the structure or operation of the machine or remove protective equipment.
- The operator must wear ear protectors, sufficiently tight-fitting work clothing and gloves, protective goggles and safety footwear.
- Before starting up the machine, the operator must ensure that the machine and its guards are intact.
- When powering the machine with a tractor, the operator must ensure that the cardan shaft is undamaged and that the rpm range is correct. The machine must be attached to the tractor's lifting equipment during operation.
- Before starting up the splitter, the operator must ensure that all the control and safety devices are functional.
- When cleaning the machine or carrying out any maintenance, it must be disconnected from its power source.
- Keep the machine's warning labels visible and in good condition. Ensure that the machine features the labels listed in Section 1.7. If necessary, obtain replacements from your retailer.

1.6.Noise and vibration

A-weighted sound pressure at the working location 89.4 dB (LpA); sound power during work cycle 106.5 dB (LWA). The vibration values do not exceed 2.5 m/s2.

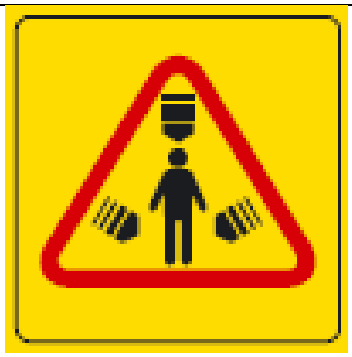
1.7.Warning symbols

 *Read the machine's manual before operating the machine.*	 *Wear eye and ear protection.*	 *Wear safety footwear and work gloves.*

Do not wear any loose items of clothing.

Always grab the piece of wood or log from the side.

Lifting point for a forklift.



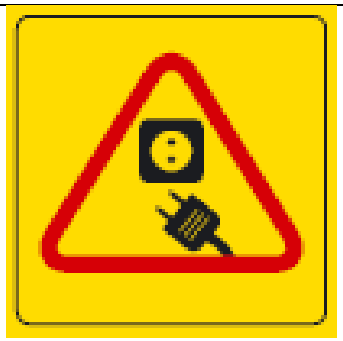
Beware of moving parts.

Beware of the cardan shaft.

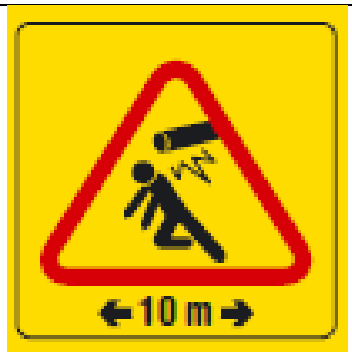
Beware of the saw chain.

Beware of the splitting knife.

Only one person may operate the machine.



Disconnect the power supply before any maintenance procedures.



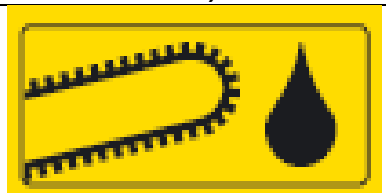
The danger zone around the machine is 10 metres.

Risk of crushing

The maximum permitted angle of the conveyor is 40°. Do not walk under the conveyor.

The maximum speed for the cardan shaft is 500 rpm.

The rotation direction is in the direction of the arrow.



Saw chain oil

 *Hydraulic oil*	 *Danger zone*	 *Lubrication point*

2. Receipt and assembly

2.1. Delivery inspection

Dispose of the machine's packaging material in an environmentally friendly manner.
Check that the machine has not sustained any damage during transit and ensure that all necessary parts are included in the package. In the event of any defects or damage, contact the retailer immediately. Remove any cable ties and strap supports installed for transport.

2.2. Lifting and moving the machine

When moving the machine, make sure that the moving and lifting capacity of your tractor or forklift is sufficient for the weight of the machine. Only lift the machine by the designated lifting points, using a tractor's lifting equipment or by the lifting points indicated in figures 2 and 3.

Figure 1. Lifting points for a forklift (2 pcs).

Figure 2. Lifting points for hooks.

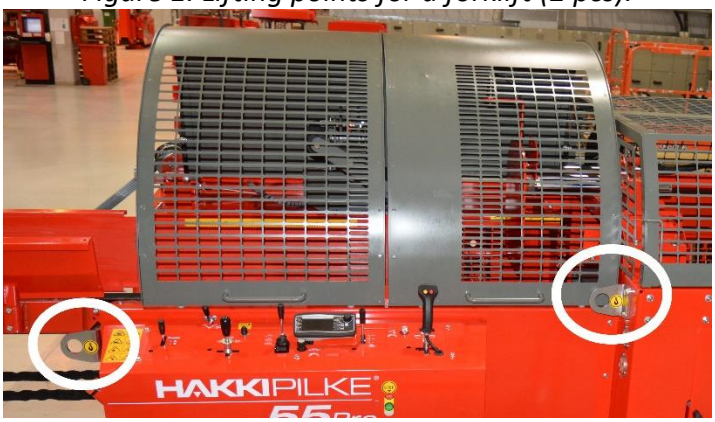


Figure 3. Lifting points for hooks.

When connecting the machine to a tractor's lifting equipment, there must be no one in the tractor cabin, so as to prevent any accidental contact with the controls. Check all the connecting devices of the tractor and the firewood processor before connecting them. Never use faulty equipment. The pins that are used

to connect the pushbars and drawbars to the machine must be of the correct size, and the appropriate locking pins must be used to secure them. Road transport with a tractor is prohibited. Only short transport is allowed if the tractor's lifting capacity is sufficient. Use a transport chassis suitable for road transport.

The machine must be placed in the transport position if it is to be moved more than 5 metres. Exercise extreme caution when moving the machine in the operating position. Always lower the machine to the ground when you stop.

Note! Incorrect lifting may cause a hazardous situation or damage the machine.
Note! Road transport of the machine with a tractor is prohibited!

2.3. Main components of the machine

The Hakki Pilke 55 Pro is a firewood processor with fully hydraulic controls. In other words, all of the machine's functions are controlled hydraulically with operating levers on the machine's control panel. The guard of the cutting and splitting section is interlocked with the machine's operation: Opening the guard stops the cutting and splitting functions.

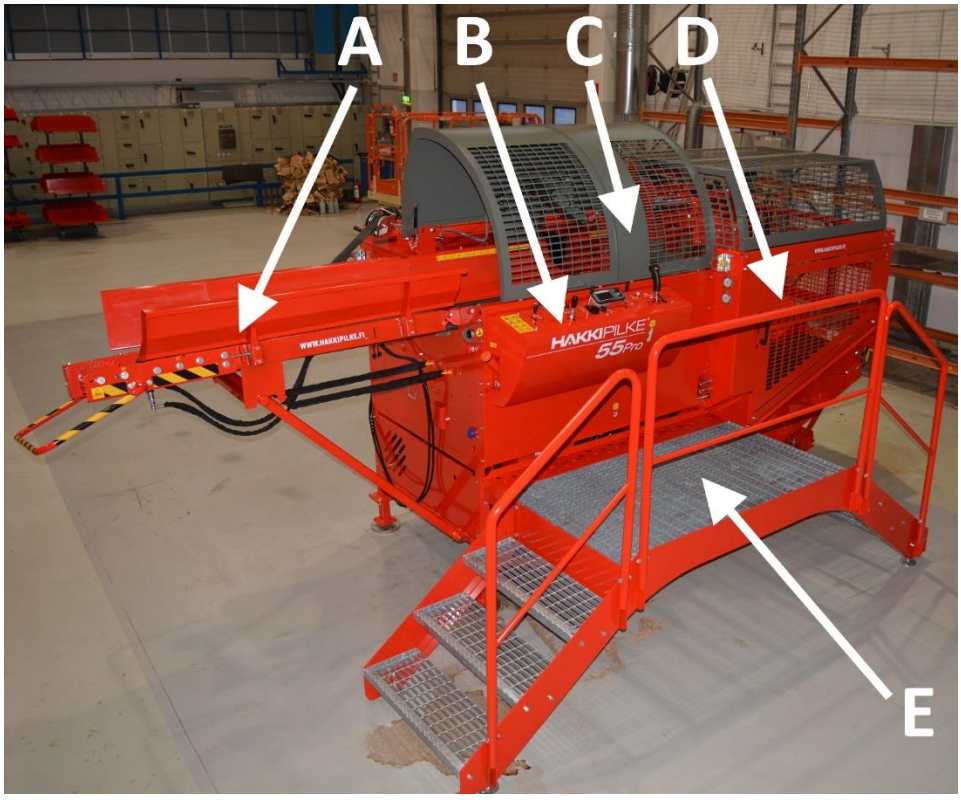


Figure 4. Main components of the machine

A. In-feed conveyor
B. Control panel
C. Cutting and splitting unit
D. Out-feed conveyor
E. Work platform

3. Control functions and setting up the machine

3.1. Preparing the machine for operation and transport

Before arranging the machine for operation and using it, ensure that the operating conditions, detailed in Section 1.4, are met and review the safety instructions in Section 1.5.

Note! Inspect and clean the machine according to Sections 4.3 and 5.8 before arranging it for transport.

3.1.1. Placing the in-feed conveyor in the operating or storage position

Place the in-feed conveyor in the operating position as follows:

1. Ensure that sufficient room is available to lower the in-feed conveyor (approx. 2.5 m).

2. Release lock A in Figure 5 and lower the in-feed conveyor's support leg to lower position B, as shown in Figure 5.

Figure 5.

3. Detach locking pin C in Figure 6, and lift lock D from its slot. At the same time, lower the in-feed conveyor to the lower position using winch E.

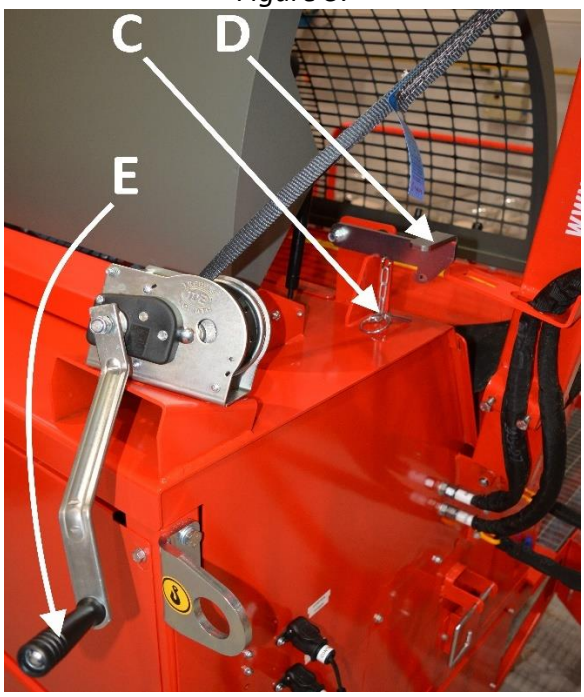


Figure 6.

4. Ensure that the in-feed conveyor's support leg settles in the appropriate slot, position the log guide plate and tighten it with the circled bolts in Figure 7.

Figure 7.

5. Also attach the other guide plate, and tighten it with the four circled bolts shown in Figure 8.

Place the in-feed conveyor in the storage position in the reverse order.

Figure 8.

3.2. Controls

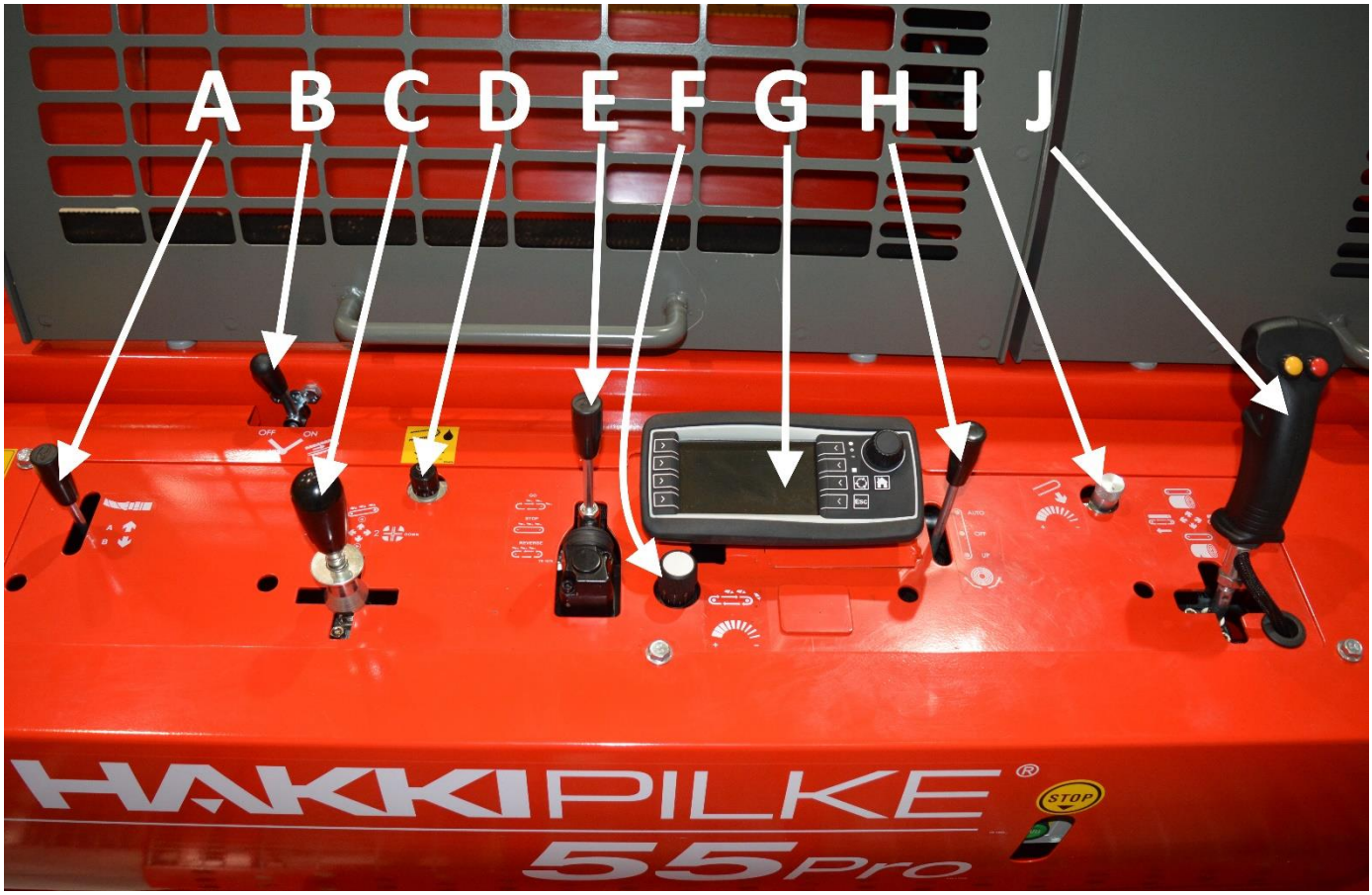


Figure 9. Controls

Names and functions of the controls in Figure 9

A. **Accessory valve.**
- Used for controlling accessories (HakkiFeed log racks)

B. **AC-10 control lever**
- The lever is used to release the operating pressure of the automatic chain tensioner (AC10) by turning the lever to the OFF position when replacing the saw chain, for example.

C. **Control valve of the out-feed conveyor (accessory) and multiplier knife**
- Lever up/down: turns the out-feed conveyor to the right/left
- Lever right: multiplier knife is lowered, Lever left: multiplier knife is raised.

D. **Adjusting the amount of saw chain oil**
- When the valve is turned anticlockwise (+), the electronic saw chain pump feeds more oil to the saw bar. When the valve is turned clockwise (-), the pump feeds less oil.

E. **Control valve of the out-feed conveyor's belt (and XL Conveyor as an accessory)**
- Upper position: - Front position causes the belt to move forward
- Middle position: The conveyor belt does not run

- Lower position: The conveyor belt runs backwards (momentary use for removing a blockage, for example).

F. **Speed adjuster for the out-feed conveyor belt**
- Turning the adjuster clockwise (-) reduces the belt's rotation speed, while turning the adjuster anticlockwise (+) increase the belt's rotation.
- Affects the out-feed conveyor and the XL Conveyor out-feed conveyor available as an accessory.

G. **Machine's information and control monitor**
- The monitor can be used to adjust the wood measuring device, for example. See Section **3.2.1**

H. **Log guide plate control valve**
- Upper position: AUTO: the guide plates are in automatic mode, i.e. the plates go up and down automatically according to the movement of the saw bar
- Middle position: OFF: the guide plates are not in use
- Lower position: UP: manual control of the guide plates to the upper position (last log, for example)

I. **Fine tuning adjuster of the saw bar lowering speed**
- Turning the adjuster clockwise (-) reduces the lowering speed while turning the adjuster anticlockwise (+) increases the speed.

J. **Joystick**
- Joystick to the left/right: the in-feed conveyor belt runs to the left/right.
- Joystick forwards/backwards: lowers/raises the manual control of the log press.
- **Button A:** Splitting knife lowered
- **Button B:** Splitting knife raised
- **Button C:** Activating/cancelling the splitting function
- **Button D:** Performing the cutting function by keeping the button pressed down:
  - The saw performs the cutting motion (the cutting chain rotates and the saw bar is lowered to the lower position)
  - In addition, the wood measuring device turns out of the way and the log press is pressed against the log
  - The log guide plates rise up, if control lever C is in the AUTO position.
  - Releasing the button stops the saw chain and raises the saw bar back up. The measuring device and the guide plates also return to their initial position.

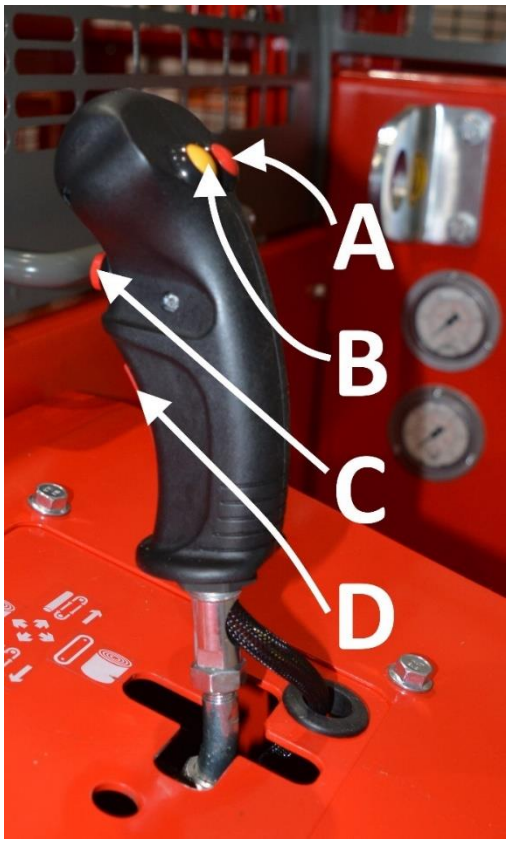


Figure 10. Joystic

3.2.1. Using the machine's monitor

The Hakki Pilke 55 Pro features a monitor that can be used to control many of the machine's functions. In addition to this, the monitor can collect a variety of information, such as the quantity of firewood produced, for example.
Figure 11 presents the monitor's control buttons A-I, which function as follows:

A= Splitting mechanism's half-stroke function

B= Activate the display's Trip indicator to see the stored operating time and yield.

C= Activate the display's Total indicator to see the total operating time and yield.

D= Manual left movement of the measuring device (reduces wood length). The measuring device value is restored to the value set on the display after the next sawing action.

E= Automatic splitting knife height adjustment / Manual adjustment (change by pressing the button)

F= Measuring device control button (press the knob to activate the measuring device adjustment) See section **3.2.4**

G= Maintenance menu, sensor statuses and other necessary maintenance-related information

H= Settings: change display language, volume measurement units, etc.

I= Manual right movement of the measuring device (increases wood length). The measuring device value is restored to the value set on the display after the next sawing action.
Note! Section J is a symbol that indicates the status of the covers. If any of the three guards is open, the symbol will be shown in red and the machine's functions will be unavailable. Esc = go back in the menu.

Note! The diameter of the wood fed into the machine is measured with a sensor from the top of the wood measuring device, and the length is determined based on the value entered in the measuring device. This results in the calculated wood volume. The logs are always assumed to be entirely round, which means that irregular shapes and knots result in measurement errors. The firewood volume calculation is intended as an indicative value and must not be used for firewood sales or determining the hourly wage of an employee.

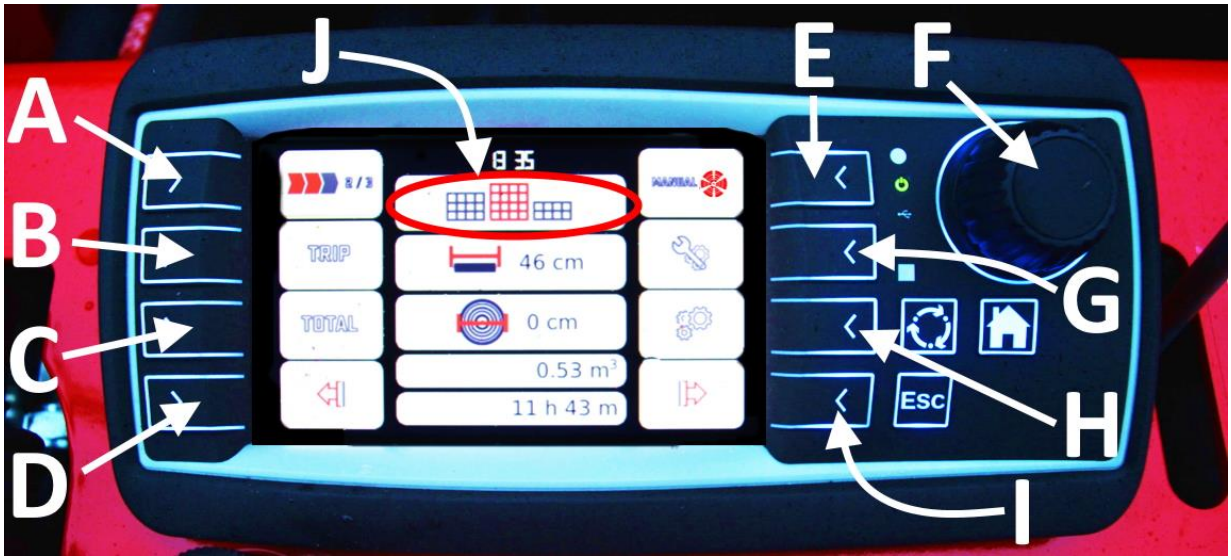


Figure 11.

3.2.2. Tractor drive

A tractor-powered firewood processor is connected to the tractor's three-point lifting devices and cardan shaft. To connect the machine to the cardan shaft, you have to move protective cover A of the socket and multiplier gear into a position where it covers the socket (in combi models).

Connecting the cardan shaft is a task for only one person. The tractor cabin must be free of people in order to prevent accidental contact with the controls while the log splitter is being connected to the tractor. Check all the connecting devices of the tractor and the firewood processor before connecting them. Never use faulty equipment.

The three-pin power cable D (figure 12b) for the electric controls is connected to socket F (figure 12a) of the 12V power source. Connect the cooler's power cable C to socket G of the 12V power source. Connect input E of the 12V power source directly to the tractor's battery using a suitable fuse. Please note! The power requirement is 300 W (25 A) and the cable must be at least 2 x 6 mm² in size.

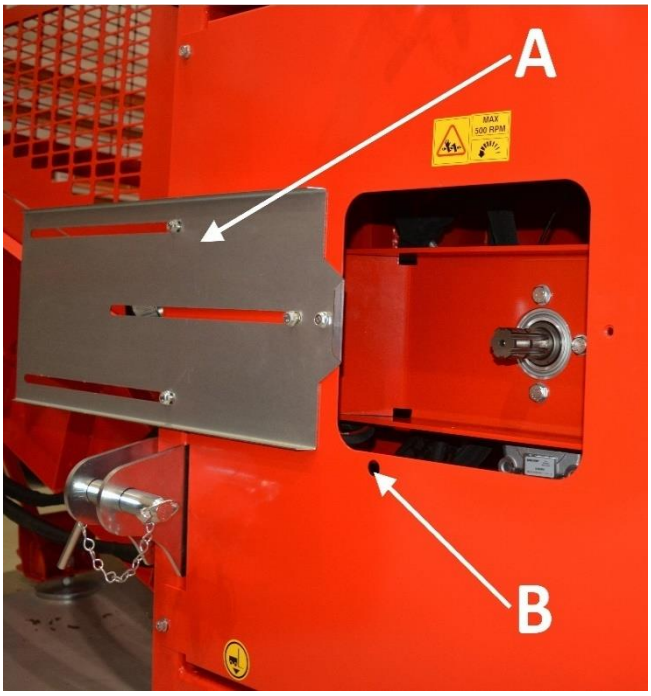


Figure 12.

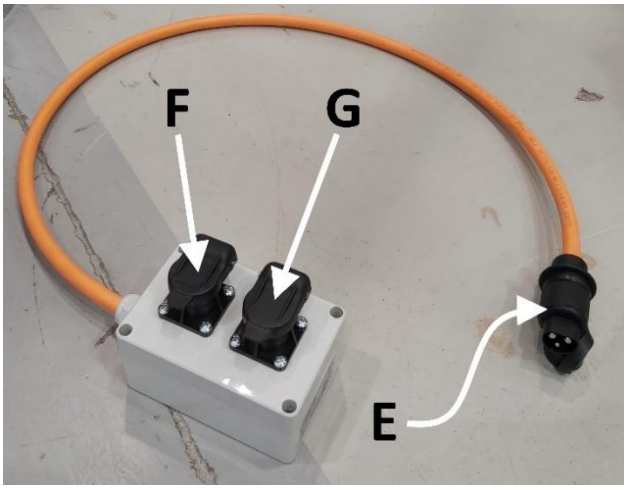


Figure 12 a.

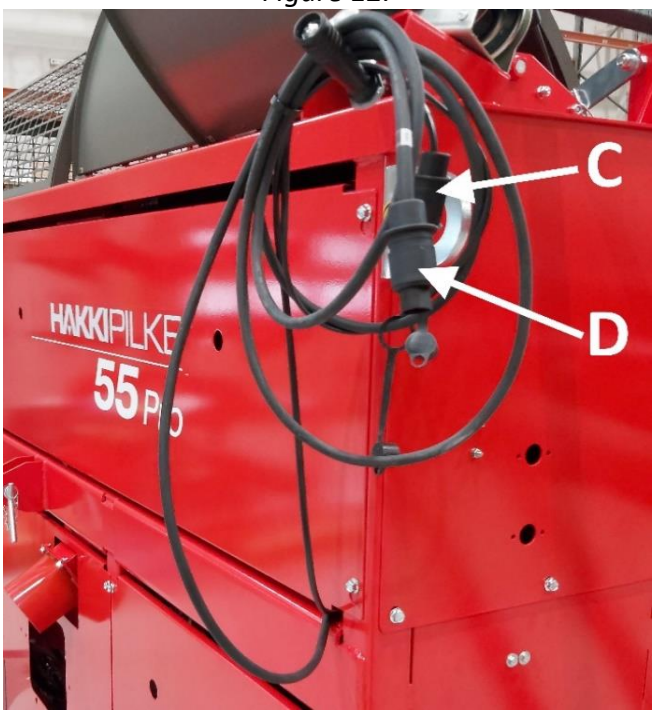


Figure 12 b.

When using the cardan shaft, observe any instructions provided by the manufacturer of the shaft. The machine requires about 22 kW of power, which must be taken into account with regard to the capacity of the cardan shaft. A suitable cardan shaft is B03 (22 kW/30 hp) Make sure that the connected shaft is locked to the splined shaft of the multiplier gear. Connect the chain that prevents the turning motion of the protective cover to slot B. Finally, ensure that all connections are safe and secure. Never use a damaged or unprotected cardan shaft.

Note! Tractor-powered machines must be attached to the lifting equipment of the tractor.
Note! The starter (Figure 14) only functions when the machine is powered by electricity.

3.2.3. Electrical drive

An electrically powered machine operates with a 21.3 kW motor. The fuse must be at least a 50 A type C fuse. The electrical cable must be at least 5 x 10 mm², and the recommended maximum length is 25 metres. In order to connect the cable, move protective cover B of socket A (63 A power socket) and the multiplier gear and secure it into a position where it covers the multiplier gear.

In an electrically powered machine, the "control" power cable for the electric controls is connected to the three-pin socket on the side of the machine (Figure 14a, upper). The cooler's 12 V cable is connected to the lower three-pin socket (Figure 14a, lower).

The electrically powered machine is turned on with the green button of the remote starter, located in the control panel in the front of the machine (Figure 14). The starter itself is located behind a protective sheet metal cover below the remote starter. The starter features an automatic fuse and a thermal relay for the electric motor. The thermal relay can be reset by pressing the red stop button on the starter, below the remote starter.

If the electric motor rotates in the wrong direction (i.e. the machine makes an abnormal noise and the hydraulic functions are inoperable), the current phase is incorrect. The phase may only be changed by an authorised electrician.

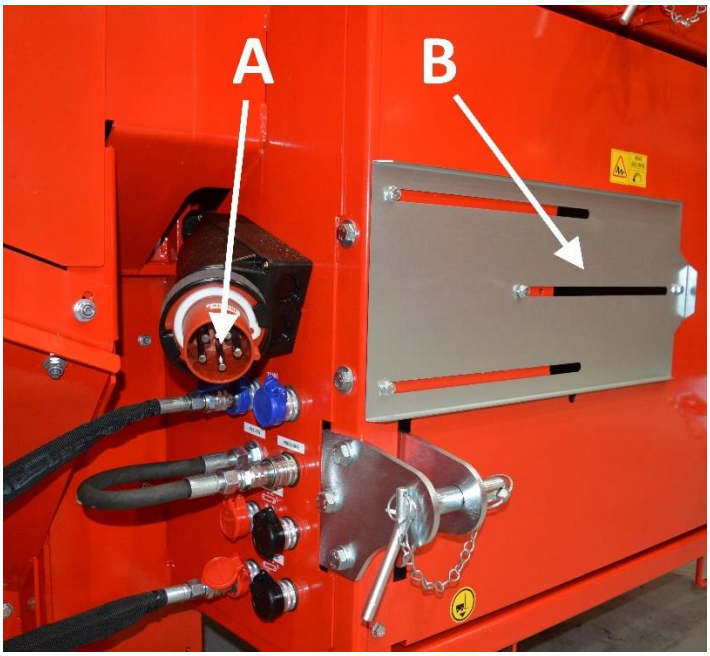


Figure 13. The machine's electrical drive

Figure 14. Electrical machine's remote starter.

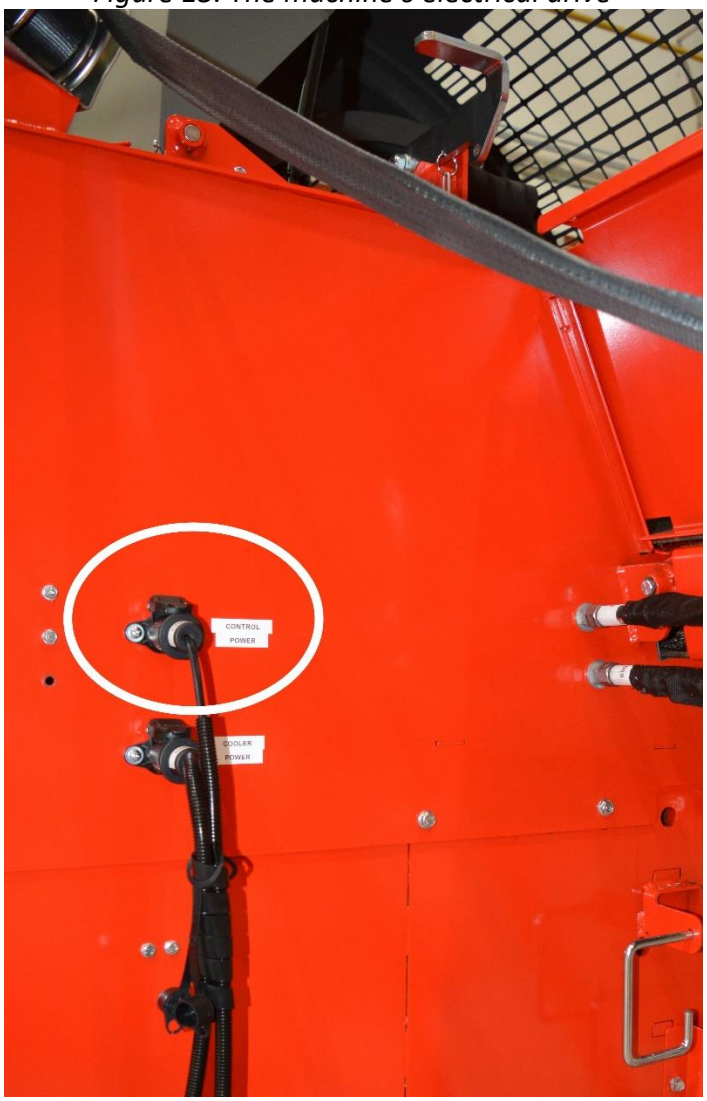


Figure 14a. Electrical connector of the electric control device

3.2.4. **Adjusting the log length**

The Hakki Pilke 55 Pro features a hydraulic automatic measuring device for cutting firewood, with an adjustment value of approx. 25 to 60 cm. When sawing, the log limiter plate (B in Figure 16) always moves approx. 5 cm backwards with the help of a hydraulic cylinder to ensure that the log does not get stuck and falls freely into the splitting groove. Before splitting, the operator must always ensure that the log is not oversized and does not connect with limiter plate B (Figure 16), guide plates or other machine components.

1. Press display knob A once to activate the measurement change (Figure 15).
2. Turn the knob until the display shows the correct wood measurement, and press the knob again to activate the selection and move plate B of the wood measuring device to the correct position.
3. If necessary, you can adjust the measuring device manually to the left or right using the buttons at the bottom edge of display G. After the manual adjustment, the measuring device returns to the value entered in the display (after sawing or splitting).

Figure 15. Log length adjustment

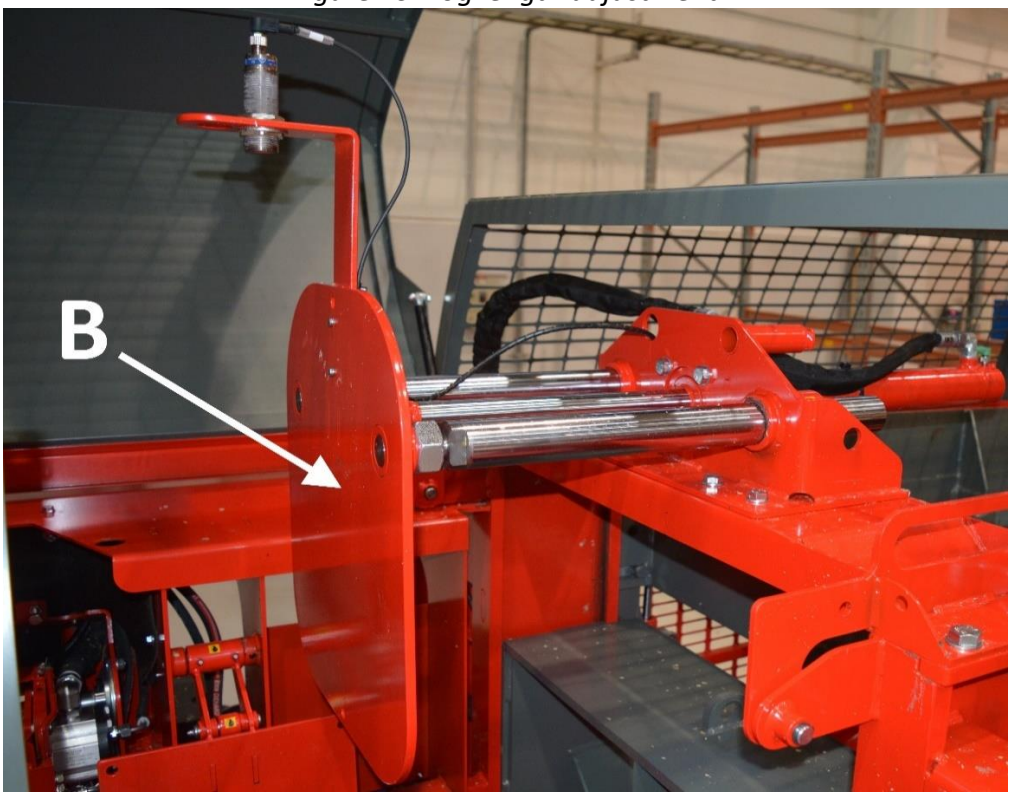
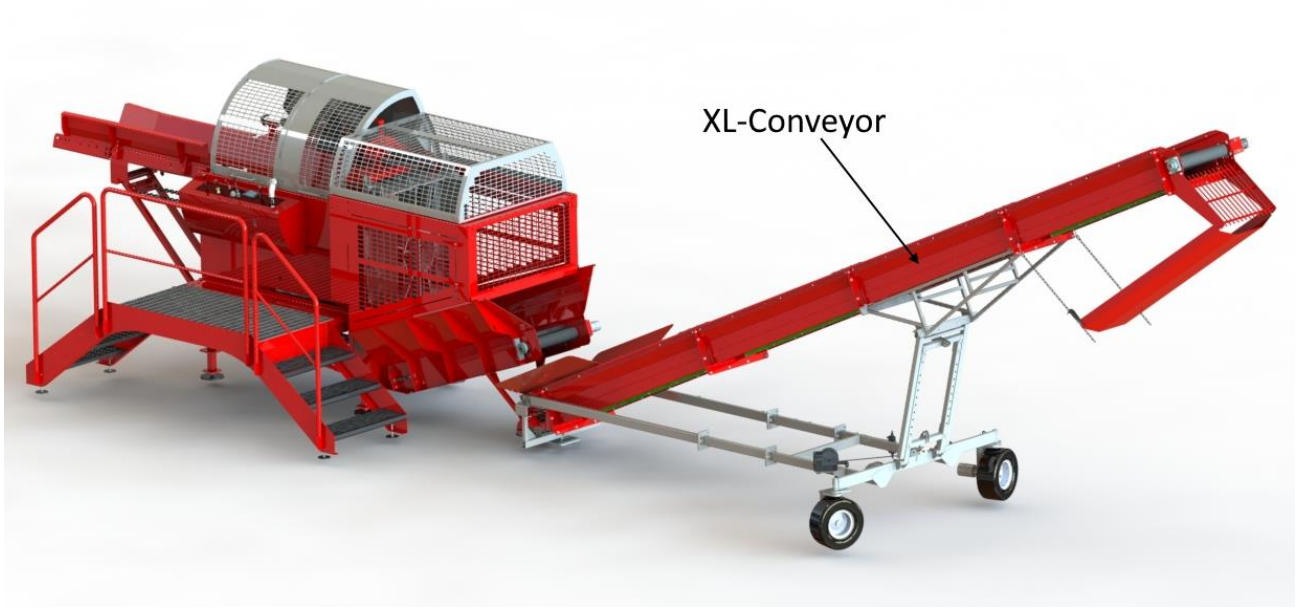


Figure 16. Log measuring device plate

3.2.5. Using the XL Conveyor out-feed conveyor (accessory)



The Hakki Pilke 50 Pro firewood processor's out-feed conveyor belt is driven by a hydraulic motor. To change the speed of the belt, use adjuster C in Figure 17. Changing the conveyor angle in the lateral direction is done hydraulically using lever A in Figure 17:

- Lever forwards: the conveyor turns to the left.
- Lever backwards: the conveyor turns to the right.

Note! Always ensure that there is nothing in the way of the out-feed conveyor before turning it!

The angle of the out-feed conveyor is adjusted mechanically with the conveyor winch. **Read more about the use of XL Conveyor in its separate operating manual.**

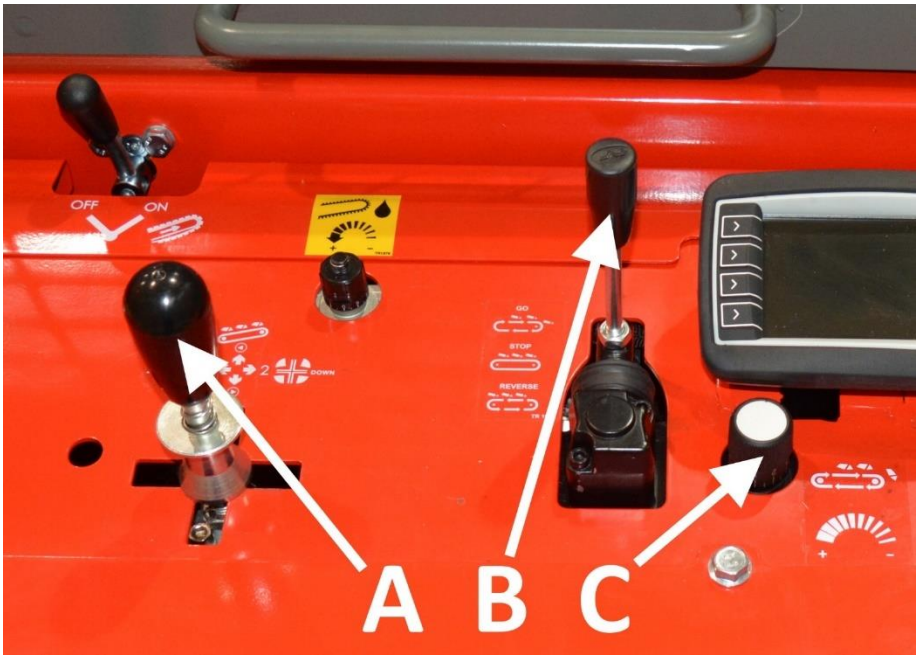


Figure 17.

By using lever B (Figure 17), you can stop the conveyor (middle position) and, if necessary, reverse the conveyor belt for a short distance (approx. 1 m) by pulling the lever back if a piece of wood is stuck between the conveyor cleaning grille and the upper roller, for example.

NOTE! The out-feed conveyor's largest operating angle is the topmost position to which the conveyor can be locked. Do not exceed the maximum operating angle!

3.2.6. Adjusting and using the splitting knife

In the Hakki Pilke 55 Pro machine, the splitting knife is adjusted automatically based on the log diameter. Sensor A in Figure 18 measures the diameter of the log, the machine's software calculates the correct height for splitting knife B and the cylinder lifts/lowers the knife to the correct height during sawing.

The splitting knife can be manually adjusted with the top buttons on the control handle (Figure 10, A and B). The splitting knife moves to the desired position and returns to automatic mode upon the next sawing of a log. Fully manual control is only recommended to be used by those who are experienced in the machine's operation. The manual adjustment can be activated through the display (Figure 11, E).

Note! An incorrect splitting knife position on manual control may damage the splitting knife!

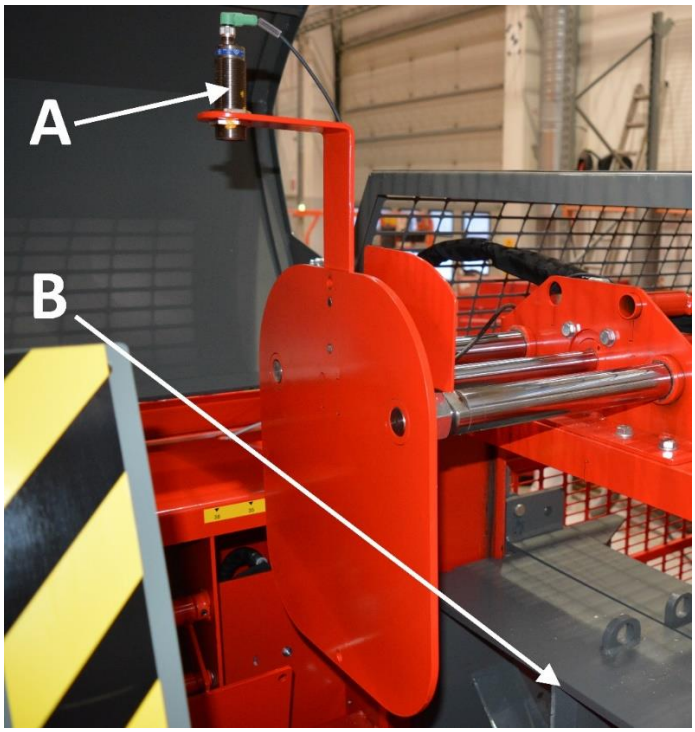


Figure 18.

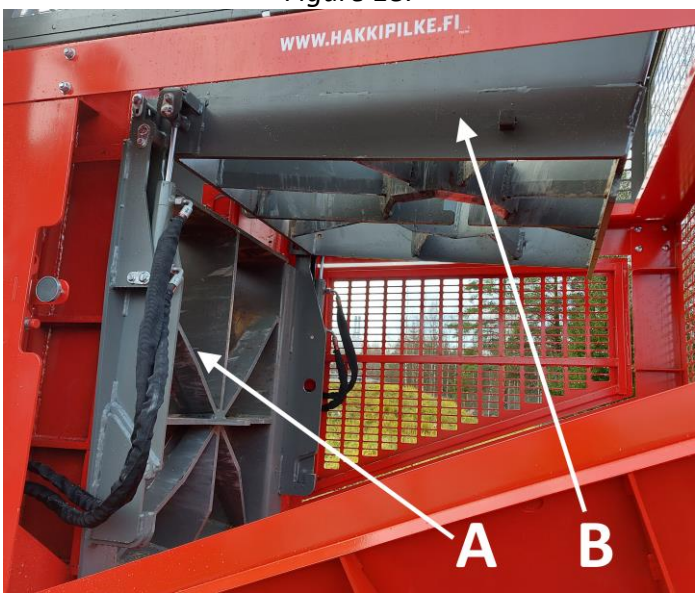


Figure 19.

The machine features a MultiBlade™ splitting knife, which consists of the basic knife (A in Figure 19) and what is called a “multiplier knife” (B in Figure 19), which can be lifted to a raised position if the log diameter is smaller and it is sufficient to split it into eight parts, for example (instead of 16 or 24). The multiplier knife is raised as follows:

1. Make sure that there is nothing in the out-feed conveyor to prevent the lifting. The doors at the sides of the out-feed conveyor must be closed.
2. Split the last piece of wood to the halfway point of the knives, at which point the piece of wood has pushed the previous piece through the rearmost knife. (Stop the splitting by pressing the splitting button again.)
3. Lift multiplier knife B to the top position (as shown in Figure 19) by turning control lever A to the left, as shown in Figure 17.
4. When lowering the blade back to the lower position, pull cord C in figure 20 to unlock the multiplier knife and raise the stopper D to the upper position, allowing the multiplier knife to lower into the lower position.

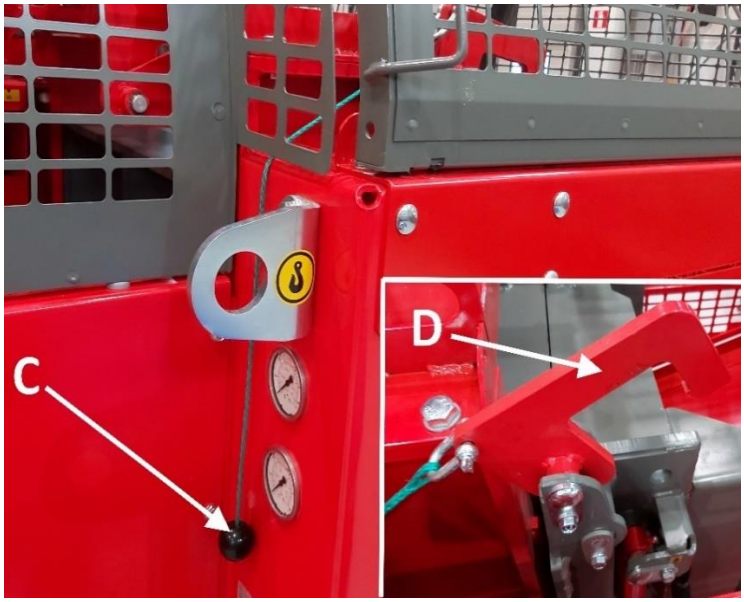


Figure 20.

Lower the multiplier knife by completing the steps in reverse order. In other words, the multiplier knife can be lowered by turning lever A to the right (Figure 17) when locking pin D and the guards have been detached.

Note! When switching the multiplier knife to the lower position, make sure that the locking lugs in Figure 21 are clean so that the locking pins of the multiplier knife settle properly into place. Before continuing operation, ensure that the knives are at the same level and fully locked.

When the splitting knife is being lowered, make sure that there are no long pieces of wood attached to it, preventing the multiplier knife from lowering. If necessary, clear the knife of any pieces of wood that may hamper the lifting/lowering.

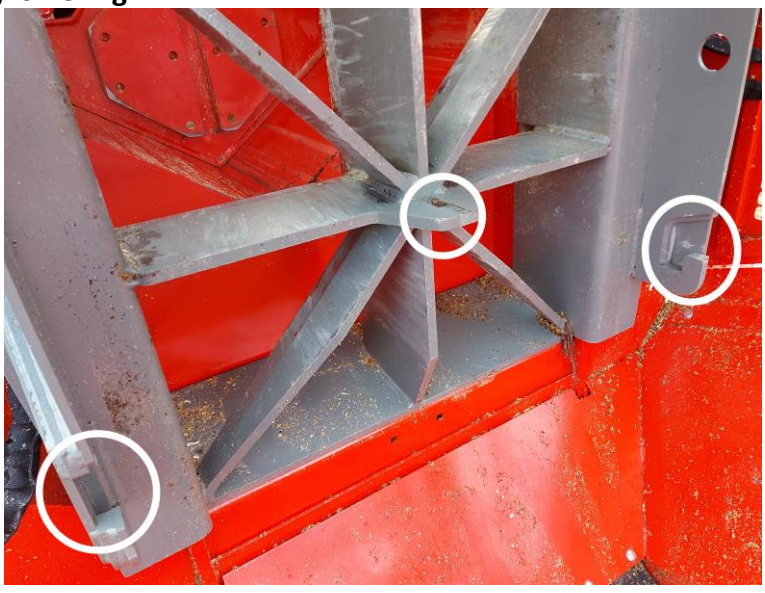


Figure 21.

3.2.7. Using the sawdust blower (accessory)

An electric or hydraulic sawdust removal device is available for the machine as an accessory. The sawdust blower allows you to keep the base of the machine clean and collect sawdust for other purposes.

Note! The machine is not intended to be used without the sawdust blower!

The electric external sawdust blower operates with standard 1-phase mains current. 230 V 50 Hz.

The sawdust blower is provided with its own operating manual. Please read the manual before using the device.

Connect the sawdust blower to the machine, as follows:

1. Attach the sawdust blower's hose to connector F in Figure 22.
2. Then, observe the instructions in the sawdust blower's operating manual.

Figure 22.

The hydraulic sawdust blower operates using the machine's own hydraulics. Connect the sawdust blower hoses as follows:

1. Disconnect the other end of the short hose from quick coupling A.
2. Connect the sawdust blower's pressure hose to the female connector of the detached hose end.
3. Connect the sawdust collector's return hose to the free quick coupling, i.e. B
4. Connect the sawdust collector's overflow hose to quick coupling C.

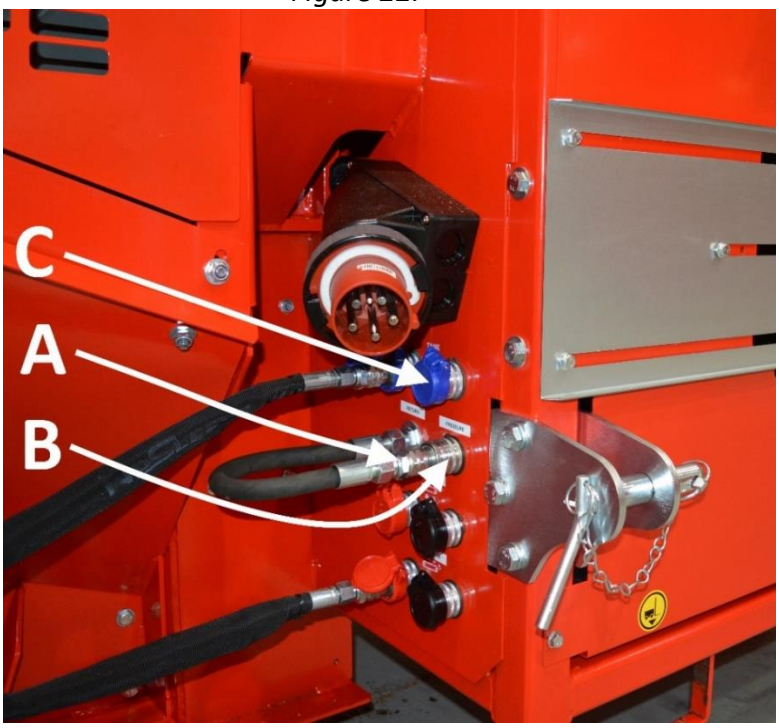


Figure 23.

4. Operating the machine

4.1. Performing a test run on the machine

The machine may not be used before a test run has been performed and all the functions of the machine have been tested. Both the test run and testing can only be performed by a person who has studied the machine's manual.

Note! When turning on the machine in cold weather (-5°C or colder), it is recommended that you use a separate heater for oil (accessory). In addition to this, the machine needs to be idled without work motions until the oil temperature has increases to at least +10°C.

Before the test run, all the components of the firewood processor must be checked. If any faults or wear and tear that may affect the safe use of the machine are discovered, the processor must not be used until the faulty or worn component is replaced and safe use can be ensured.

1. During start-up, always test the machine's guards until the guard icons on the display turn green (Figure 15).
2. Ensure that all of the machine's guards are closed.
3. Ensure that the in-feed conveyor is in the working position.
4. Make sure that the splitting groove is empty.
5. Make sure that you are familiar with the functions of the machine's controls. If necessary, see Section 3.2.
6. Activation.

   a. Tractor drive: Insert the connector for the electric control device into the tractor's electrical socket. Start the tractor and connect the output, starting with a slow speed and increasing the speed from a minimum of 450 rpm to a maximum of 500 rpm.

   b. Electrical drive: Connect the cable to the socket of the firewood processor, start the machine by pressing the start button and wait until the electric motor operates at full speed.
7. Start the splitting motion by pressing button C on joystick J shown in Figure 9. The splitting motion must be normal.
8. Make sure that the saw and the lubrication on the cutting chain work as follows: (If necessary, see Section 7.0)
   a. Perform a few sawing cycles without wood by pressing down button D (Figure 10).
   b. Make sure that the saw bar is lowered all the way down during the sawing cycle, then automatically raised back up when button D is released, and that the saw chain rotates for the entire time that button D is pressed down.
   c. Turn off the machine and disconnect it from the power source.
   d. Open the guard and see if the saw chain has been supplied with oil.
9. Start the splitting cycle and stop it by opening the guard mesh. Ensure that the display shows the icon indicating that the guard mesh has been opened. Make sure that the splitting beam returns to its initial position when the guard mesh is closed.
10. Test run the input conveyor's feed and return motion with joystick J in Figure 9.
11. Start the out-feed conveyor by pushing lever E in Figure 9 to the front position. Make sure that the conveyor belt stops when lever E is placed in the middle position and that the feed is reversed when lever E is in the back position. Set the conveyor belt to a suitable speed with controller F (Figure 9).

If a fault, failure or leak occurs during the test run, determine the cause and take remedial action as necessary. The machine must be shut down and disconnected from the power source for the duration of both the diagnostics and repairs.

4.2. Placing logs on the in-feed conveyor

We recommend the use of auxiliary devices, such as the HakkiFeed 472 log table. If a log table is not attached to the machine, the maximum allowed log length is 4.5 m. Always lift and place wood on the input table in a safe manner that does not endanger the operator.
Note! The placing of logs directly onto the in-feed conveyor with a loader is strictly prohibited.
Note! Ensure that the log's centre of gravity stays on the conveyor.

4.3. Feeding and sawing wood

The in-feed conveyor feeds the wood into the firewood processor. Move timber into the machine by turning joystick J shown in Figure 9. The feed can be cancelled by turning the joystick to the left. The machine has been designed to be used with the log table model Hakki Pilke HakkiFeed 471 or 472. Do not use the machine without a suitable log table due to the weight of the logs.

When feeding wood into the machine, make sure that it does not present a risk of your clothes, hands or other parts getting caught in the machine, such as due to the shape of the log. Do not use your hand to guide the log into the cutting section. Adjust the wood measuring device to the desired length and make sure that the speed of the out-feed conveyor belt is suitable by adjusting it.

1. Choose the log to process. Note that the maximum log diameter is 55 cm. The knottiness and shape of the log can increase the diameter.
2. Use joystick J to feed the log into the machine with the in-feed conveyor. Check that the log is not oversized and that no part of it collides with the log press or saw bar during feeding.
3. When the log stops in the hydraulic measuring device for cutting, cut the log by pressing button D (Figure 10) on the joystick. This will activate the saw chain and sawing cycle automatically.
4. Return the saw bar to the upper position by releasing button D (Figure 10).
5. Do not start the next cutting motion before the splitting process has turned to reverse back.

Note! Do not operate the feed during sawing or when the saw bar is not fully in the upper position.
Note! Use the machine with HakkiFeed log tables only. Do not lift logs into the machine with a loader!
Note! When using the machine, always make sure that no one else is within the danger zone (10 m) of the machine or the log table connected to it. See Section 1.5.

4.3.1. Hydraulic log press

The Hakki Pilke 55 Pro firewood processor is equipped with a hydraulic log press, which always **automatically** presses the log against the in-feed conveyor during the cutting motion. If necessary, the operator can raise/lower the log press with joystick J (Figure 9) by moving the controller forwards/backwards. The operator must ensure that the log being fed into the machine does not collide with the log press due to variations in log size, for example.

Note! When feeding in a new log, always raise the log press to the upper position!

4.3.2. Jamming of the cutting blade

If the cutting blade becomes jammed in the log, stop sawing and try again on another section of the log. If the cut is misaligned because the bar drags to one side, the sharpness of the saw chain and the bar must be checked. A chain that is not evenly sharp will always drag towards the blunter side, which will make cutting a thick log impossible. On the other hand, sawing with an evenly dull chain is inefficient, and the saw chain must be sharpened or replaced (see Section 5.1.1).

4.3.3. Guide plates for falling wood pieces

The 55 Pro is equipped with guide plates to ensure that the cut pieces of wood are always lowered to the bottom of the splitting groove in the right position. First, the cut piece of wood is lowered on top of the plates, as shown in Figure 24, which then lowers the piece to the bottom of the splitting groove (Figure 25) in a controlled manner.

Figure 24.

The need for the guide plates depends on the thickness and length of the piece of wood that is being split. A longer and thinner piece of wood is easier to lower to the splitting groove in the right position than a shorter and thicker piece.

The operator can choose whether to use the guide plates or not. They can also be used manually for controlling the fall of the final log, for example.

When the guide plates are in automatic mode (controller H in Figure 9 is in the front position), they immediately rise up when the saw bar starts to cut wood. Once the log has been cut and the piece has fallen on the plates, release the sawing button, which raises the bar and lowers the guide plates automatically to the lower position.

Figure 25.

When the plates are not in use (controller H in Figure 9 is in the middle position), they remain in the lower position, as shown in Figure 25.

In manual mode, the operator can manually raise/lower the plates with controller H (Figure 9).

4.3.4. Sawing the last log

When sawing logs, the second to last piece should be sawn in such a way that the remaining piece is of a sufficient length. This ensures that the log stays firmly under the hydraulic log press and that the sawing is steady and safe. The last log can be fed on top of the manually lifted guide plates (Figure 24) and then be lowered down to splitting in the correct position.

4.3.5. Using the quick couplings of the additional hydraulics

1. Connect the additional hydraulics (e.g. when using the lateral transfer mechanism of the HakkiFeed 472 log table) by pushing the auxiliary device's hydraulic hoses into the quick couplings in Figure 26:

- The one marked in red to quick coupling B.
- The one marked in black to quick coupling A.
- The one marked in blue to quick coupling "Tank".

2. Use the additional hydraulics with controller A in Figure 9.

Note! The HakkiFeed 472 log table's hydraulic motor features an overflow hose which must be connected to quick coupling C, i.e. the direct line to the hydraulic tank.

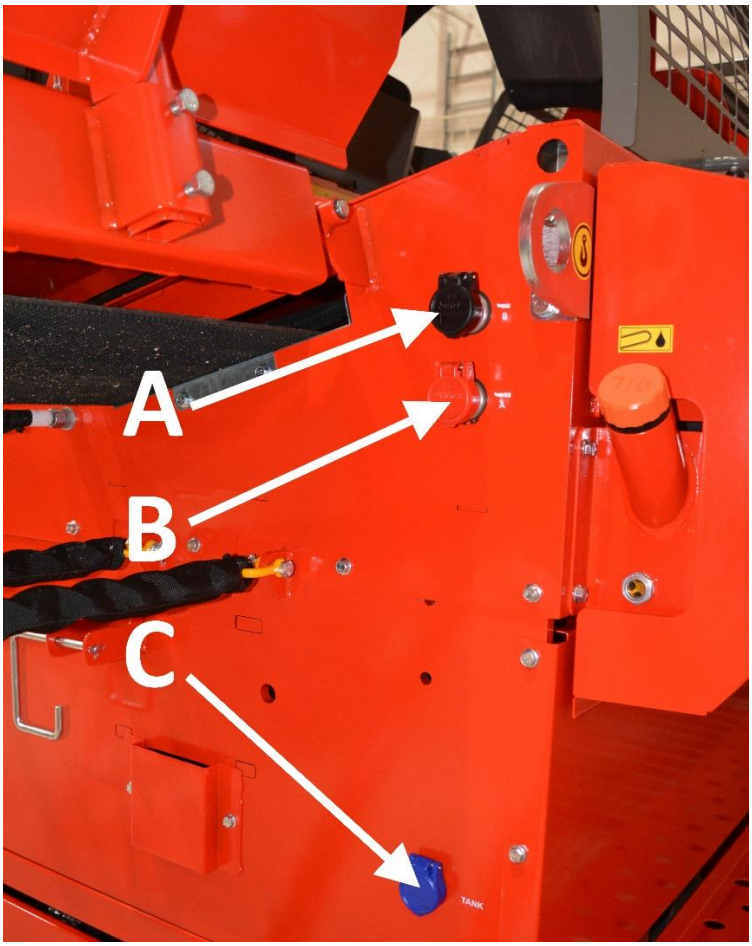


Figure 26.

4.3.6. Connecting a log table's in-feed rollers to the in-feed conveyor

A log table's (e.g. HakkiFeed 472) in-feed rollers can be connected in series with the in-feed conveyor. This way, the rollers are automatically synchronised to operate with the in-feed conveyor when feeding logs using joystick J (Figure 9). Connect the hoses of the log table to the machine's in-feed conveyor as follows:

1. Turn off the machine and disconnect it from the power source.

2. Remove hose B from quick coupling A (Figure 27).

3. Connect the pressure hose of the log table rollers (marked in red) to quick coupling A.

4. Connect the return hose of the log table rollers to hose B (with a female coupling).

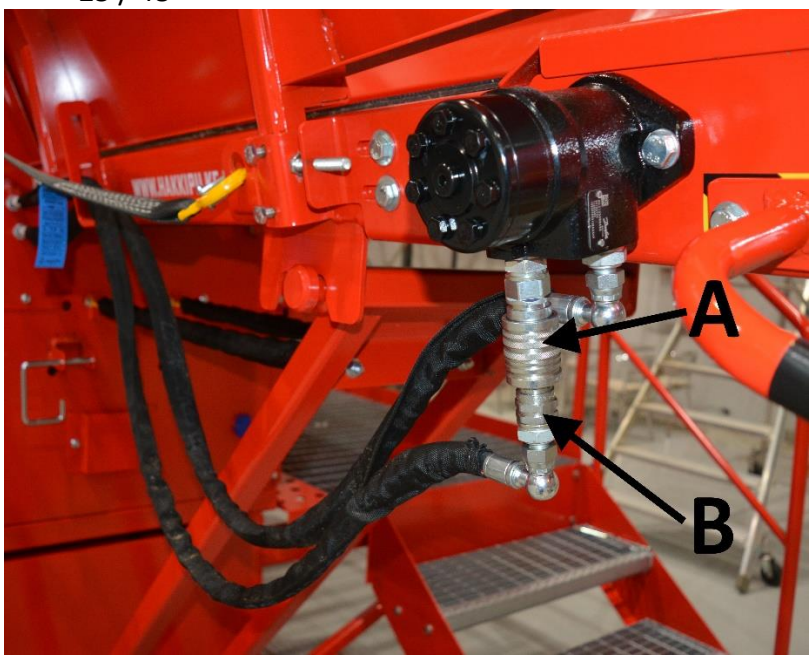


Figure 27.

4.4. Log splitting

4.4.1. Jamming of wood on the splitting knife

If a piece of wood gets jammed on the splitting knife in a situation where the splitting force is insufficient to push the piece past the knife, carry out the following:

1. Return the splitting beam fully to the starting position by opening and closing the splitting guard.
2. Restart the splitting by pressing button **C** (**Figure 10**). This recharges the machine's pressure booster to provide full power.
3. If the log is still not split completely, raise the splitting knife slightly (approx. 5 cm) and repeat step 2.

4.4.2. Resplitting or splitting without cutting

1. Raise the protective cover of the cutting and splitting groove.
2. Place the log you want to split in the splitting groove.
3. Close the protective cover of the cutting and splitting groove.
4. Activate the splitting cycle with button C (Figure 10).

The above procedure can be used to split wood without cutting it as necessary.

4.4.1. Adjusting the stroke length of the splitting motion

In the Hakki Pilke 55 Pro firewood processor, the splitting cylinder is controlled electrically with sensors A and B in Figure 28. The stroke length of the splitting cylinder can be adjusted as follows:

1. Shut down the machine and disconnect it from its power sources.

2. Remove the machine's cover plate (from the rear of the machine), as shown in Figure 28.

3. Sensor A (Figure 28) determines the spot in which the splitting beam stops during the return motion. If necessary, change the position of the sensor. Loosen the sensor's fastening bolt, move the sensor and tighten the bolt to secure it in place.

4. Sensor B (Figure 28) is used to determine the point at which the splitting cylinder changes direction during the splitting cycle, i.e. how close to the splitting beam the splitting knife goes. If necessary, change the position of the sensor, as instructed in section 3 above.

Note! The covers and guards must be reattached after maintenance.

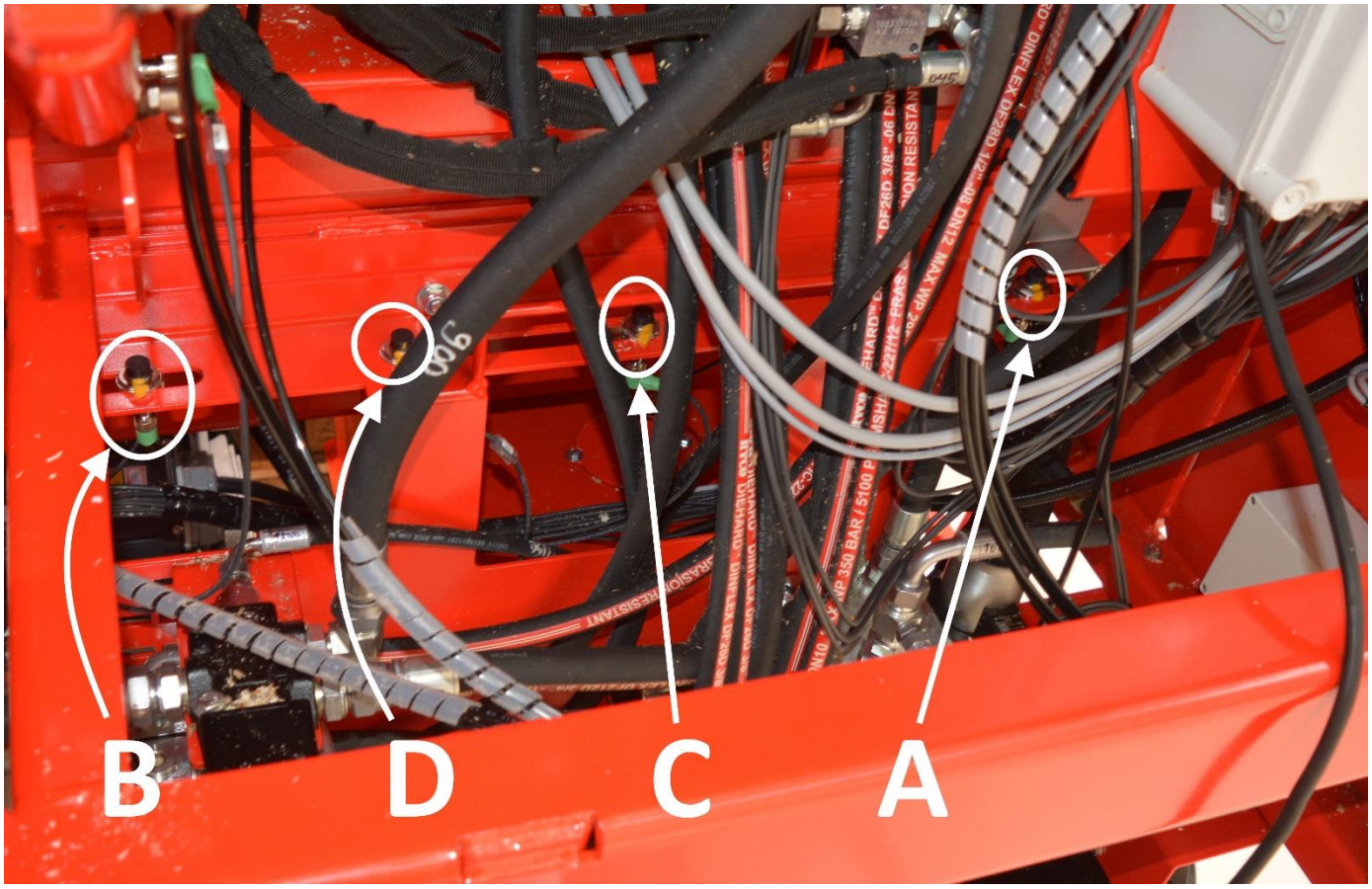


Figure 28.

4.4.2. Halving the stroke length of the splitting motion

When splitting logs with a diameter of over 30 cm but a length of under 24–40 cm with the Hakki Pilke 55 Pro firewood processor, the efficiency of the machine can be enhanced by limiting the movement of the splitting cylinder. You can activate the half stroke with monitor button A (Figure 11) and select either 1/2 stroke or 1/3 stroke. The stroke lengths can be adjusted by moving sensors C and D (Figure 28). It is preferable to set the adjustment so that the log remains slightly jammed in the splitting knife and only the next log will split it completely.

Activating a single splitting pushes the log up until the preset splitting setting. Note! You can also carry out a single full splitting motion by keeping the splitting button pressed down as long as the splitting motion has finished.

4.5. Using the out-feed conveyor

The running speed of the out-feed conveyor can be freely adjusted with adjustment screw A (Figure 29). If the conveyor is jammed for any reason, the conveyor must be stopped with lever E (Figure 9) and the machine shut down before the cause is removed. If the issue is at the end of the conveyor (a piece of wood is stuck between the conveyor and possible extension conveyor), the conveyor belt can be reversed for a short distance with lever E (Figure 9).

The tightness of the intermediate conveyor's belt (and the belt's alignment) can be adjusted as follows:

1. Loosen fastening nut B (Figure 29).
2. Tighten/loosen the belt with nut C in Figure 29 (the same amount on both sides of the belt). If the belt is crooked, loosen nut C (in relation to the spring) on the side towards which you wish to align the belt better.
3. When the conveyor belt is at the correct tension and properly aligned, tighten fastening nuts B on both sides tightly against nut C.

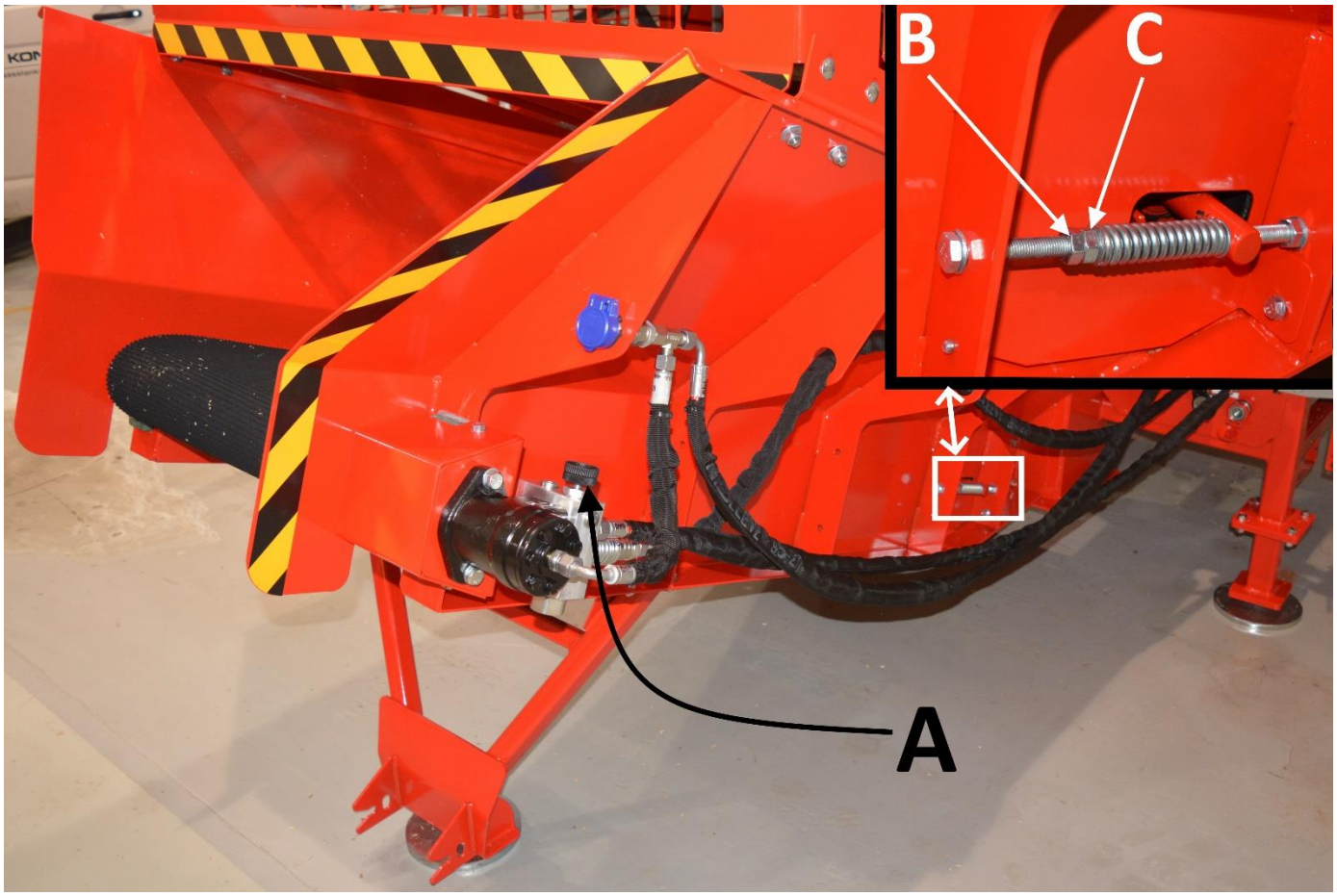


Figure 29.

The out-feed conveyor's belt can be replaced as follows:

1. Loosen the belt in accordance with the instructions provided above.
2. Rotate the connection point roughly to the halfway point of the conveyor.
3. Pull the connection wire out and remove the old belt.
4. Install the new belt in place in the reverse order.

4.6. After use

1. After you have finished making firewood, stop the out-feed conveyor, shut down the machine and remove the firewood from the splitting groove and conveyor.
2. Ensure that the machine has not been damaged.
3. Ensure that the machine can be moved safely off the processed firewood.
4. Clean the machine.

If you will not be using the firewood processor for a while, do the following:

5. Store the machine according to the instructions in Section 10.

5. Machine maintenance

The machine must be disconnected from its power source before any maintenance, adjustment, replacement or cleaning measures. Only use spare parts that are supplied by the manufacturer or your retailer. If the guards of the machine have to be removed for maintenance, they must always be reattached before the machine is activated. After maintenance and adjustment measures, the machine must be test run according to the instructions in Section 4.1.

5.1. Cutting blade and drive end

If the cutting blade of the machine does not penetrate the wood properly or the cut is skewed, the cutting chain is most likely blunt or the saw bar is bent. **The most common cause for problems with cutting logs is an unevenly dulled saw chain which veers 5–10 cm to either side and causes the saw bar to stop.** It is a good idea to keep a replacement chain on hand, so that you do not need to interrupt your work to sharpen the chain.

5.1.1. Replacing and tensioning the saw chain

The Hakki Pilke 55 Pro firewood processor comes standard with a patented AC10™ automatic and hydraulically powered saw chain tensioner. When the machine is running, the hydraulic cylinder pushes the saw motor backwards with a constant force, keeping the saw chain's tension optimal. The operator does not need to worry about the saw chain's tension.

Replace the saw chain, as follows:

1. Turn off the machine, disconnect it from its power source and open the left and right guard.
2. Turn lever B (Figure 9) to the OFF position to release the pressure in the automatic cutting chain tensioner.
3. Pull the cutting chain downwards at the middle of the beam. This will loosen the chain and allow you to remove it. **Note! Always wear cut protection gloves when handling the saw chain.**
4. Install the new saw chain and ensure that the cutting teeth come first in relation to the rotating direction.
5. Turn lever B in Figure 9 to the ON position.
6. Close the machine guards and turn on the machine. This will automatically tension the cutting chain to the right tension and raise the saw bar.

To check the tension of the cutting chain, wear protective gloves and pull the lower edge of the chain at the middle of the beam. The tension is correct when you cannot pull a drive tooth to a fully visible position with moderate force, but the chain moves on the bar when pulled with a tool.

5.1.2. Replacing the saw bar

Replace the saw bar, as follows:

1. Remove the cutting chain according to steps 1–3 of Section 5.1.1.
2. Remove the beam's fastening bolts A (Figure 30).
3. Remove fastening plate C (Figure 31) and remove the saw bar from the groove.

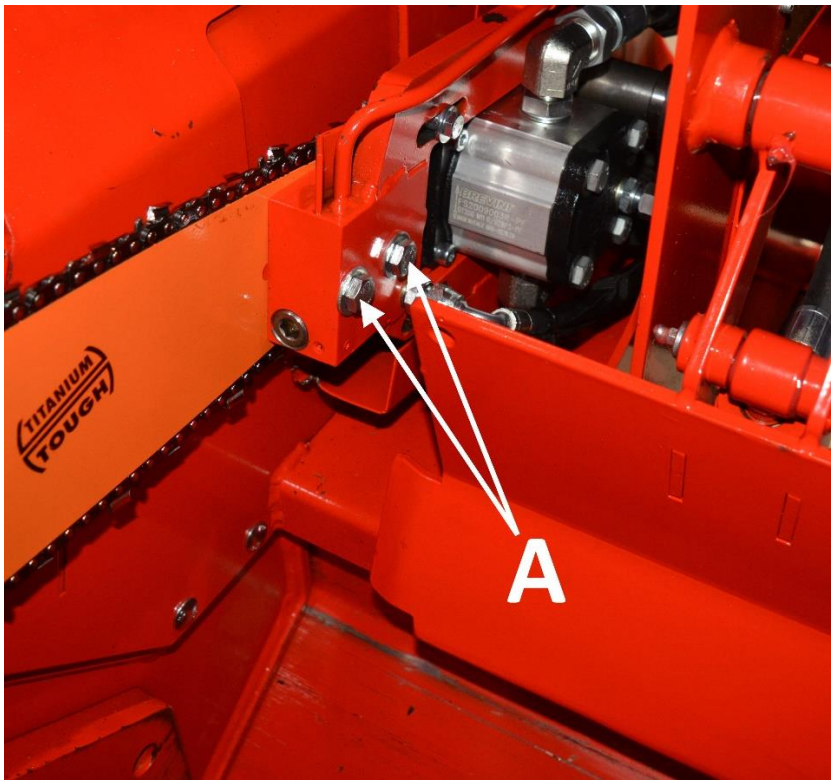


Figure 30.

4. Place the new bar against gear wheel B, twist it into the groove and tighten saw bar bolts A.
5. Install the saw chain in place according to steps 4–6 of Section 5.1.1.

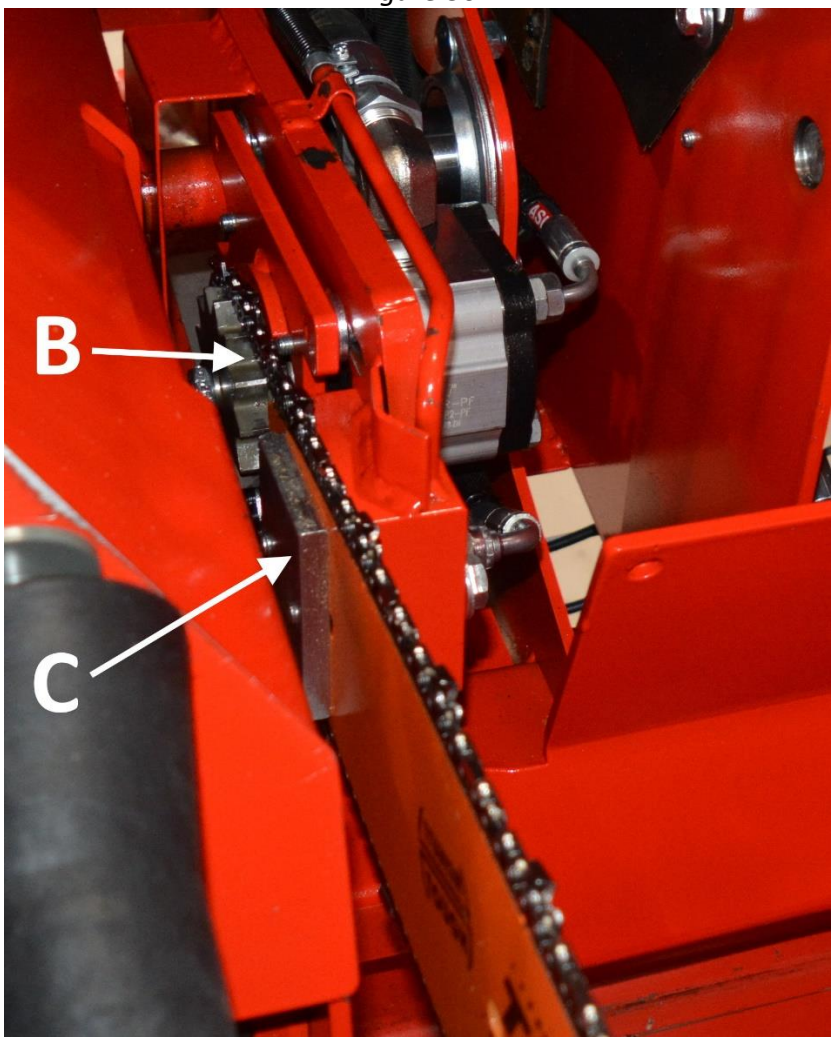


Figure 31.

5.2. Changing the oil of the multiplier gear

1. Remove drain plug C (Figure 32) and drain the oil into a suitable container.

   Note! The multiplier gear's oil volume is 0.34 litres.

2. Close plug C and open filler cap A (Figure 32).

3. Feed the new oil to the multiplier gear and close filler cap A. The required amount is 0.34 litres.

4. You can check the oil level through oil level gauge B (Figure 32).

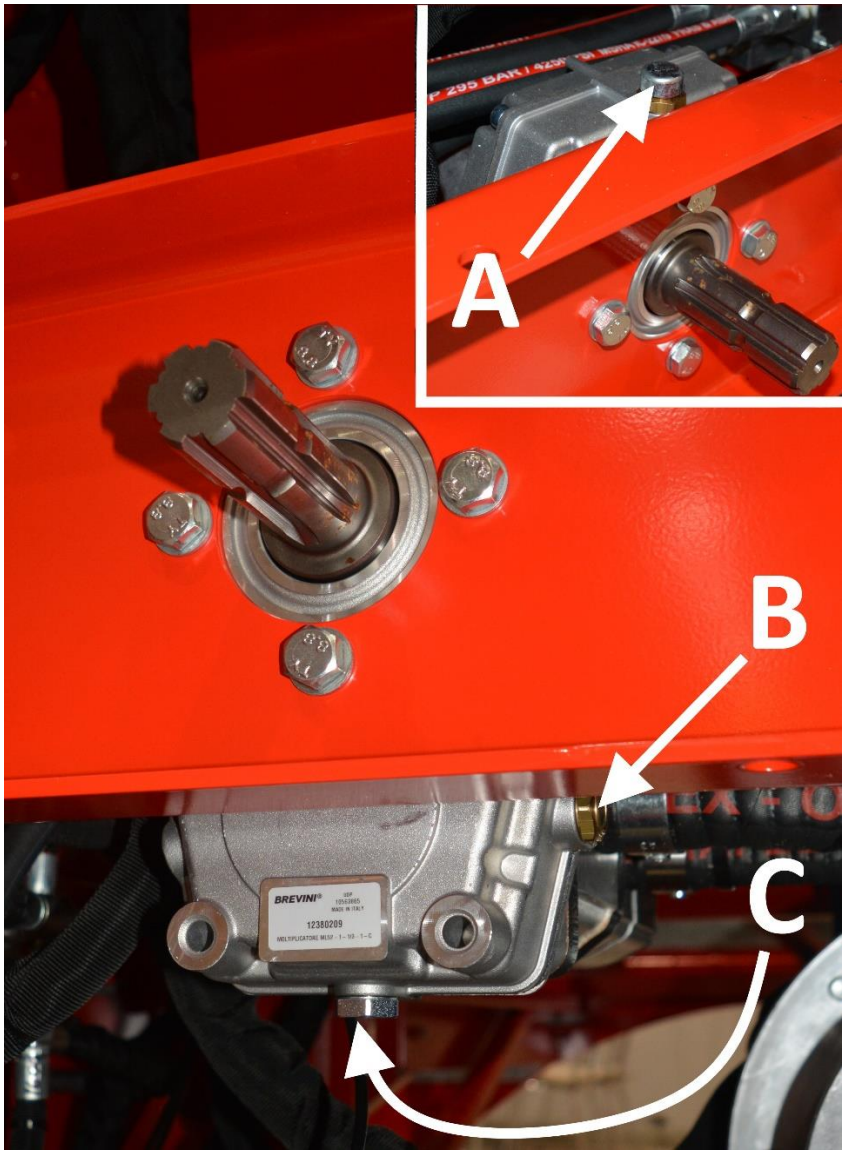


Figure 32.

5.3. Changing the hydraulic oil and filters

1. Turn off the machine and disconnect it from its power source.

2. Open the oil tank's filler cap A.

   The tank is located in front of the work platform on the operator's side. **The oil level guard and thermostat D measure oil level and temperature in the tank and warn about insufficient levels or excessive oil temperature on the machine's monitor.**

3. Remove plug C in Figure 34 and drain the old oil.

4. Remove the bolts circled in Figure 33, and remove the covers of the filter housing (2 pcs). Remove the old filter cartridges and install new ones. Reattach the covers with the circled bolts.

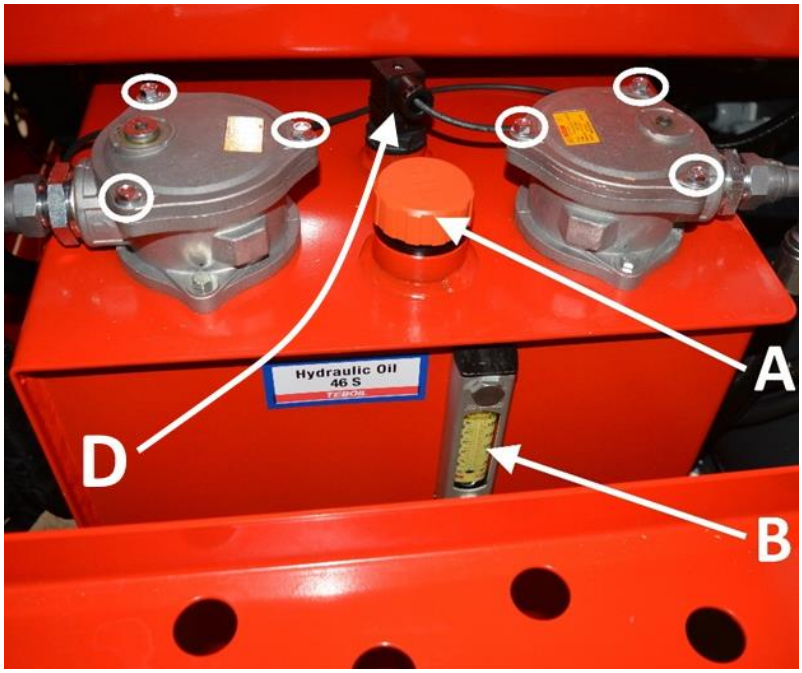


Figure 33.

Figure 34.

Note! The oil volume is approx. 125 litres, so be prepared to replace the container more than once as necessary.

Note! Choose the correct type of oil according to the operating conditions! If the electric motor is turned on in cold conditions (below -10°C), the use of an oil with a viscosity of ISO VG 32 and an oil heater accessory is recommended.

The recommended oil under normal conditions is ISO VG 46 (with the oil temperature no more than 60°C).

5. Put plug C back in place and feed the new oil to the tank through the opening of filler cap A (approx. 125 litres).

6. Use gauge B (Figure 33) to make sure that the oil level is near maximum.

5.4. Conveyor maintenance

5.4.1. Replacing and tightening the in-feed conveyor belt

Replace the in-feed conveyor belt as follows:

1. Shut the machine down and disconnect it from its power sources.
2. Raise and lock the in-feed conveyor into the transport position. (See Section 3.1.1.)
3. Move the belt joint to a suitable height.
4. Disconnect the joint by using pliers, for example, to pull out wire A (Figure 31) that holds the joint together.
5. Remove the old belt.
6. Slide the new belt under the table through opening B at the side of the in-feed conveyor's drive roller until you can pull the belt out from the other end C.
7. Lead the rest of the belt under the log press, around the rear roller and, finally, behind the conveyor.
8. Connect the joint by inserting wire A into the joint.
9. Turn the conveyor back to the operating position and tension the belt.

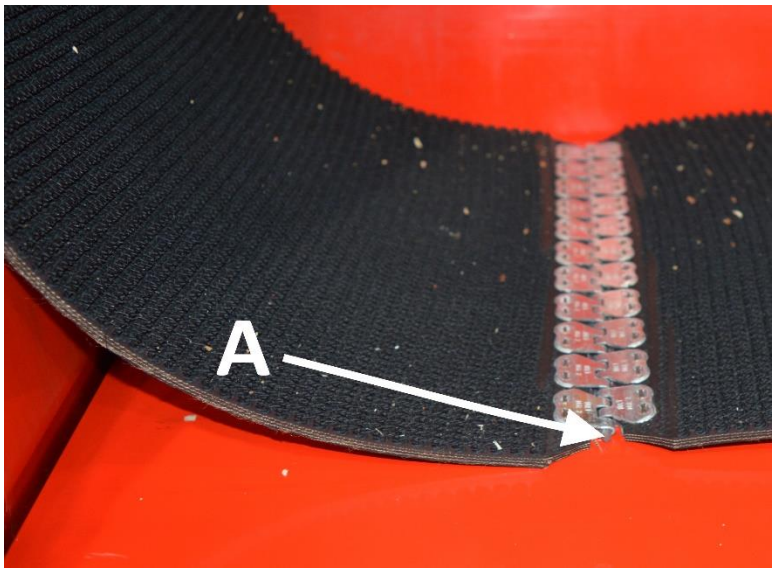


Figure 35.

Figure 36.

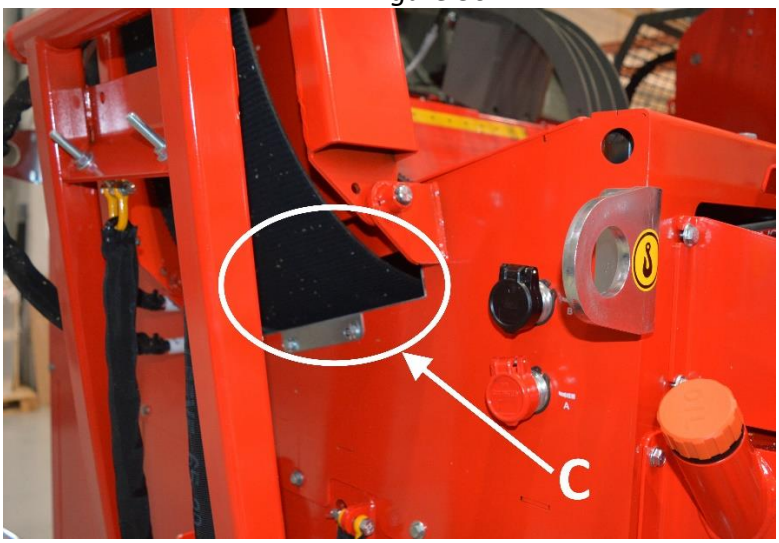


Figure 37.

10. Finally, adjust the belt to the correct tension and to run straight with the help of adjustment nuts D (on both sides). First loosen the circled bolts (total 6 pcs) so that the rear roller can move. Retighten after adjustment.

    The belt is at the correct tension when its middle section is raised approx. 5 cm when the conveyor is in the operating position. An excessively tight belt may be damaged more easily, and it places unnecessary strain on the bearings of the conveyor.

Figure 38.

5.5. Lubrication

The Hakki Pilke 55 Pro features an automatic central lubrication pump SKF TLMR201, which feeds Vaseline at regular intervals to the nipples that require the most lubrication. The pump in Figure 35 is located at the rear of the machine behind a sheet metal cover. The lubricator operates on 12 V voltage and the fill level of the cartridge can be monitored through the transparent scale on the side of the cartridge.

The SKF MR380 (380 ml) cartridge must be replaced with a new one immediately once the lubricator's red light A is lit (Figure 39).

The grease volume can be changed. The standard setting is 1 month/cartridge. Grease is only pumped when the machine is connected to 12 V voltage.

Note! Read the central lubrication pump's separate operating manual and observe its instructions!

Figure 39.

The outputs of the lubricator's distributor are numbered from one to ten (Figure 40). Their lubrication targets are as follows:

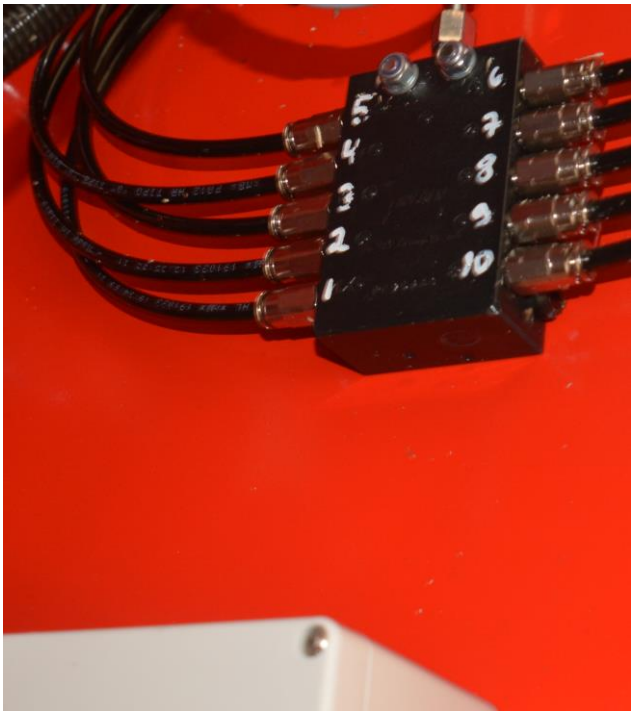


Figure 40.

1. Splitting mechanism slide, operator's side
2. Splitting mechanism slide, opposite side
3. Log guide plate, operator's side
4. Log guide plate, opposite side
5. Log press cylinder
6. Log press, stabiliser
7. Log press, stabiliser
8. Log press, arm
9. Saw drive end cylinder, arm
10. Saw drive end cylinder, base

All other lubrication points of the machine are marked with a  label presented in the figures below.

1. Grease nipples of the splitting knife height adjustment cylinder (2 pcs, Figure 41).

2. Right-side nipples of the multiplier knife (2 pcs, Figure 42).

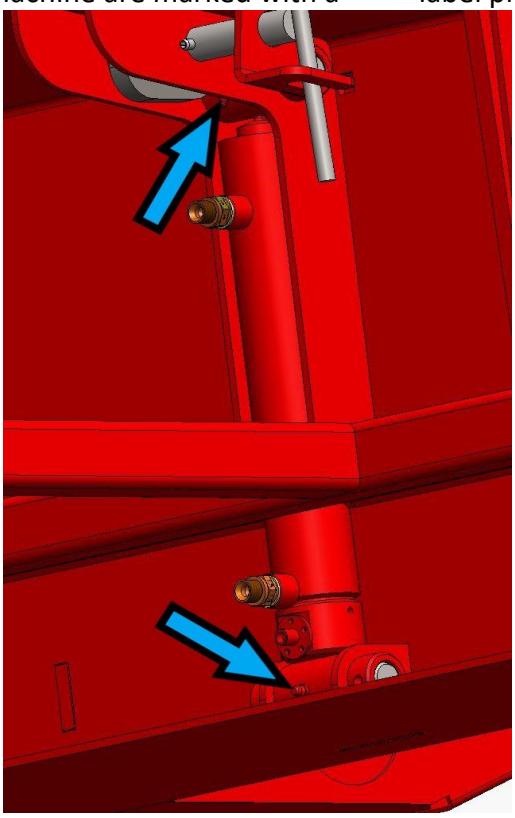


Figure 41.

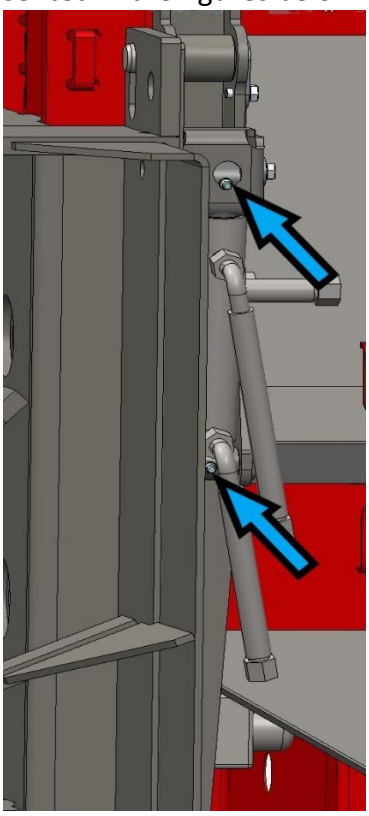


Figure 42.

3. Left-side nipples of the multiplier knife (2 pcs, Figure 43).

4. Grease nipples of the guide plate (3 pcs, Figure 44).

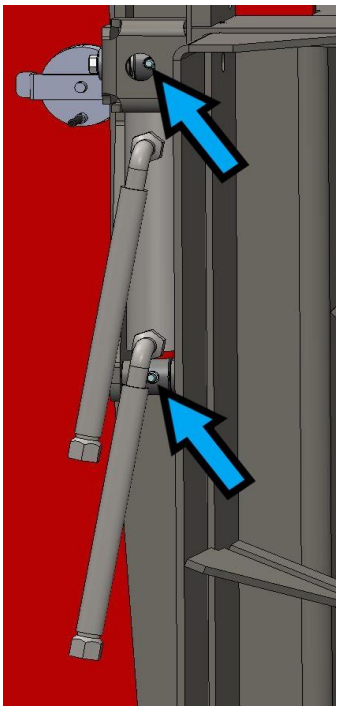


Figure 43.

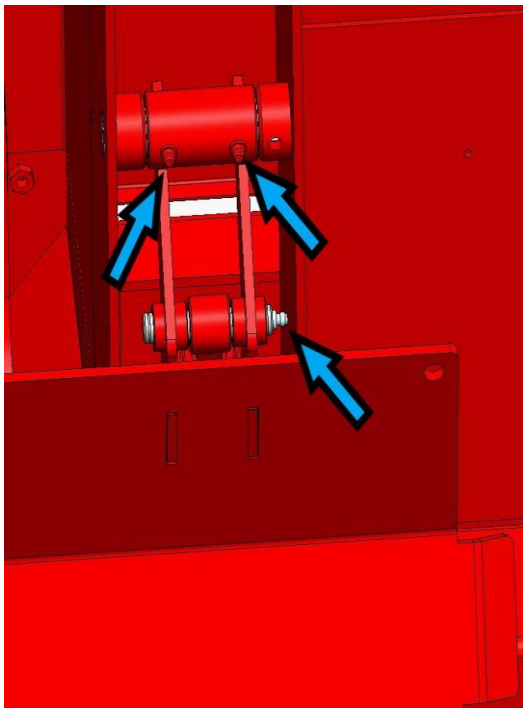


Figure 44.

5. Grease nipples of guide plate 2 (4 pcs, Figure 45).

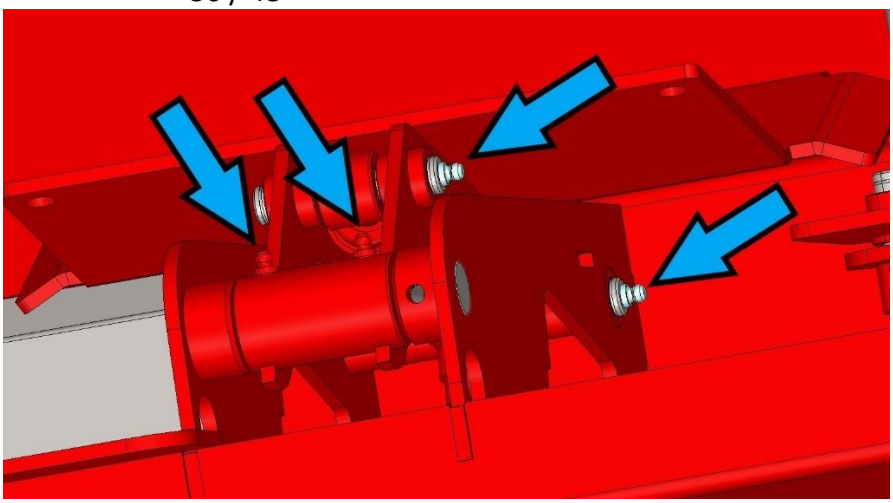


Figure 45.

6. Grease nipples of the out-feed conveyor bearings (2 pcs, Figure 46).

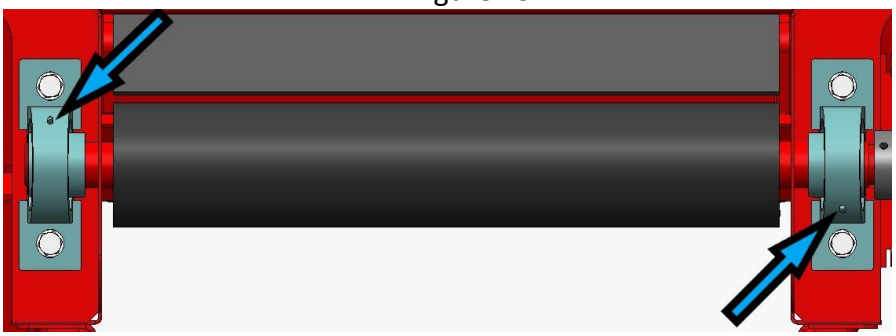


Figure 46.

7. Grease nipples of the log press (3 pcs, Figure 47).

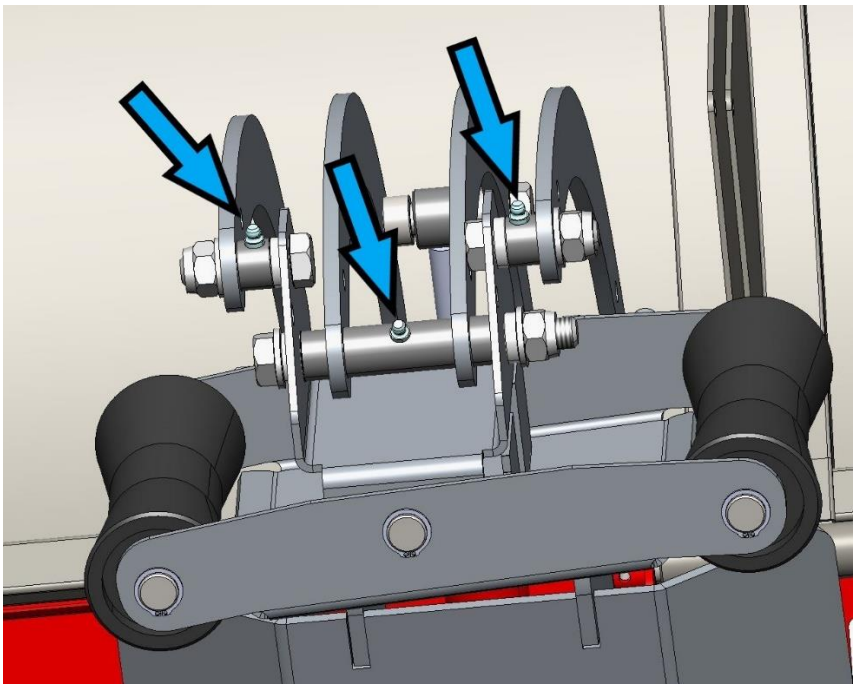


Figure 47.

8. Grease nipples of the wood measuring device (2 pcs, Figure 48).

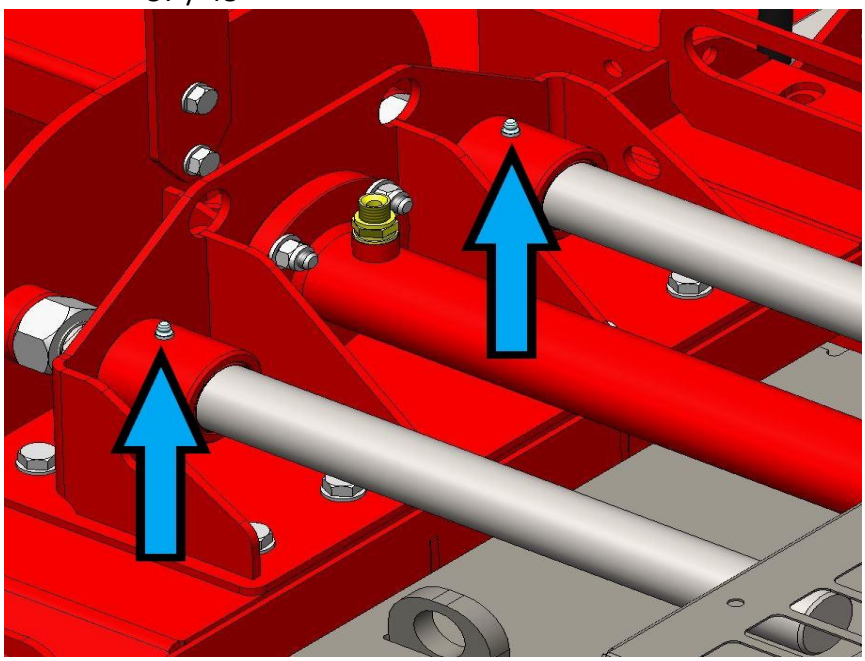


Figure 48.

9. Grease nipples of the log table support legs (2 pcs, Figure 49).

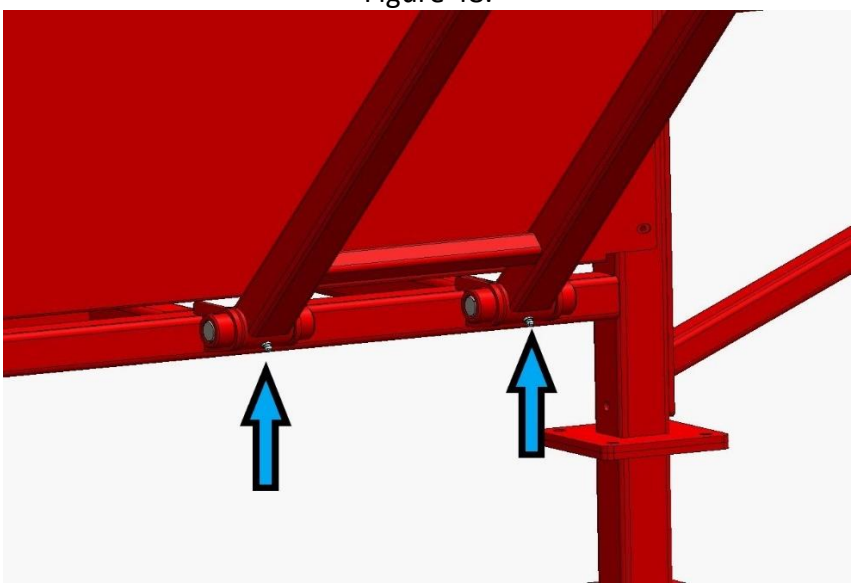


Figure 49.

10. Grease nipples of in-feed roller bearings (3 pcs, Figure 50).

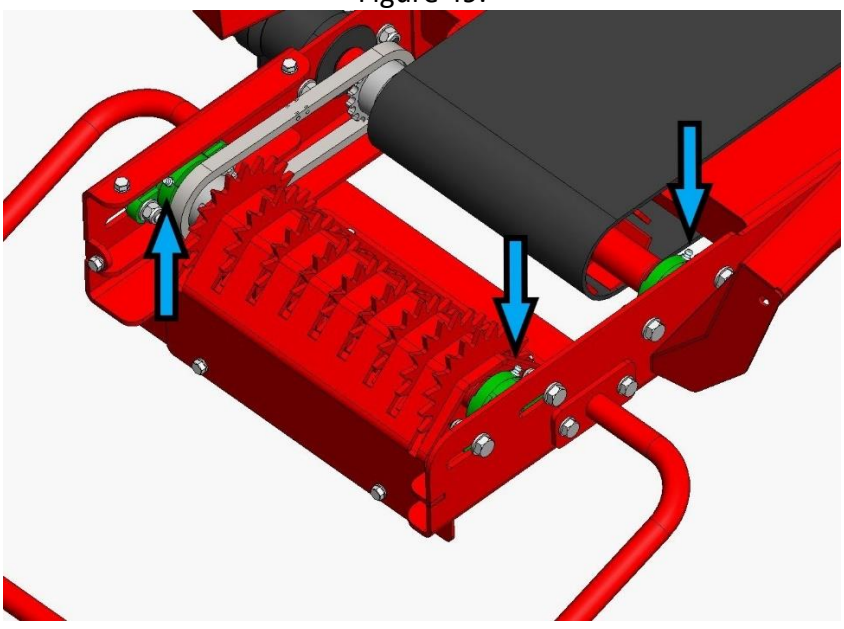


Figure 50.

11. Drive roller nipple (1 pc, Figure 51).

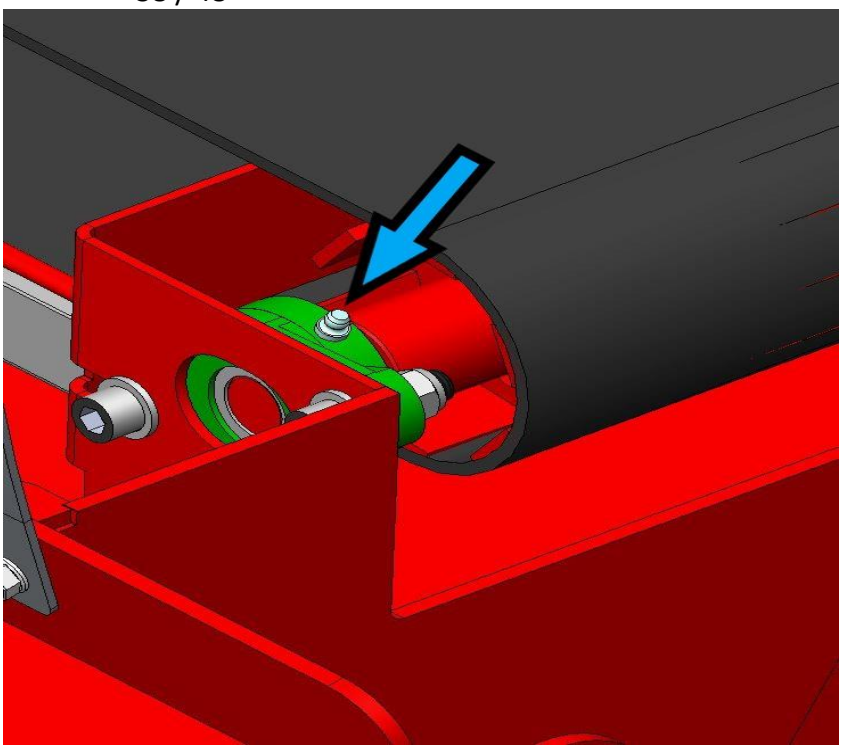


Figure 51.

12. Guard nipples (4 pcs, Figure 52).

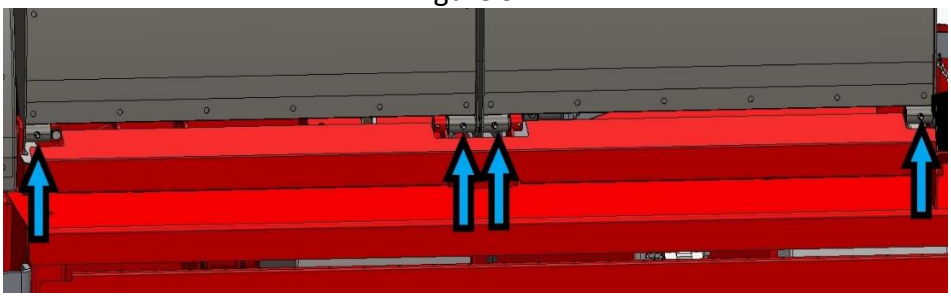


Figure 52.

5.6. Saw chain lubrication

The saw chain is automatically lubricated whenever it rotates. The chain oil is fed to the chain from the tank with the help of an electric pump, i.e. the pump always pushes oil to the chain when the chain rotates. You can adjust the amount of saw chain oil fed to the chain with the help of adjuster A (Figure 53), i.e. the amount of oil decreases when the adjuster is tightened and vice versa.

Note! The adjustment screw lock must first be removed by lifting the cap, which releases the screw for free rotation.

The factory setting for adjuster A (Figure 53) is 2 turns towards the open position from the closed position. Increase or decrease the amount as necessary according to the size and type of wood, air temperature and type of oil.

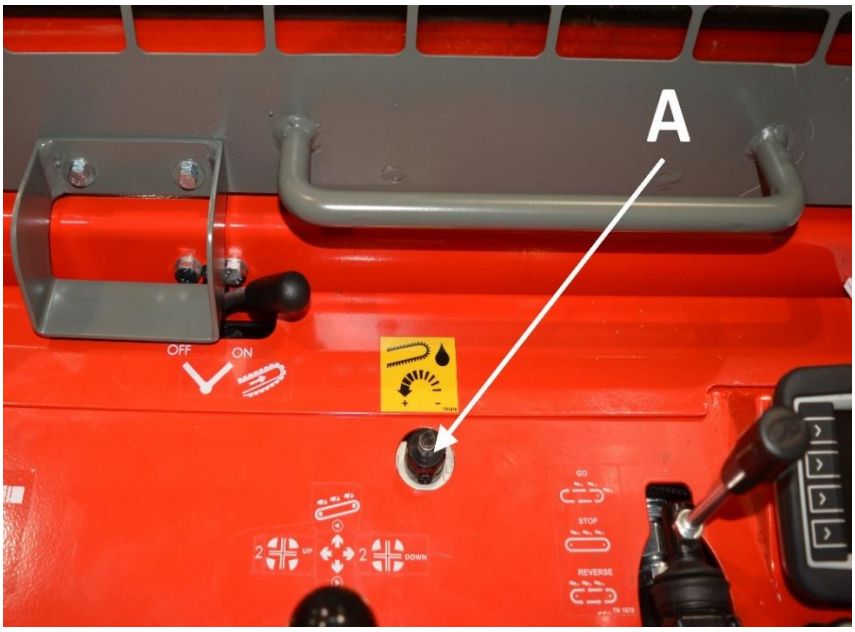


Figure 53.

Always check before you start working that the chain receives oil when the machine is turned off and the cage is closed (with the 12 volt electricity connected).

You can monitor the oil level of the saw chain through sight glass C (Figure 54). When the oil level is below the sight glass C level (the glass is clear instead of the colour of oil), the saw chain oil must be immediately added through filler cap B (fill approx. 5 litres). Tank capacity is about 6 litres.

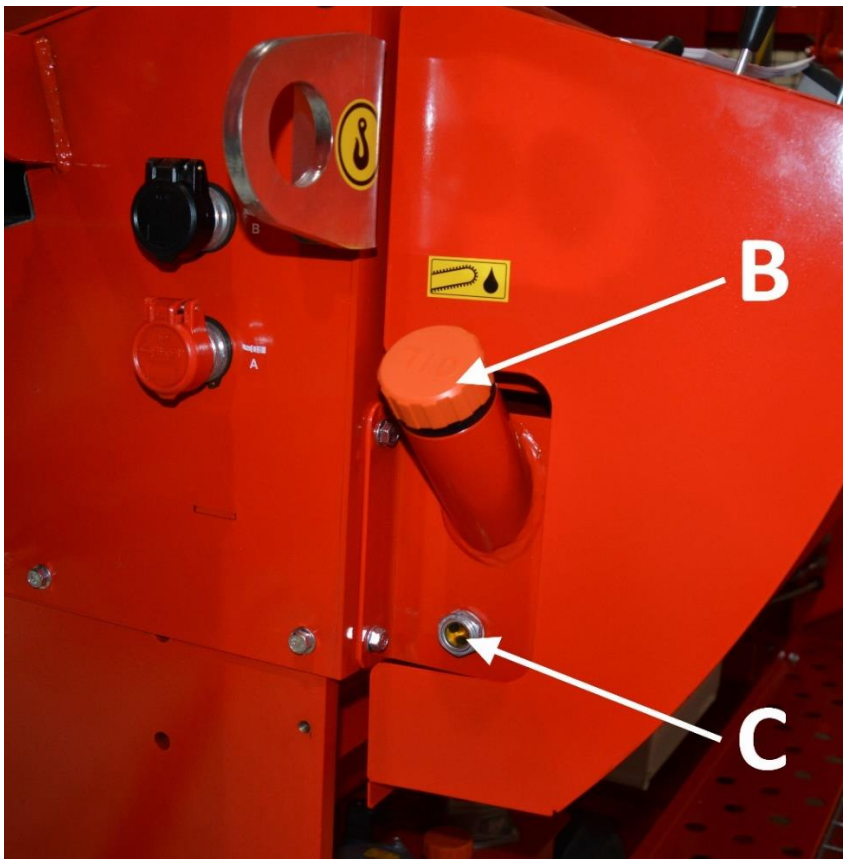


Figure 54.

5.7. Solenoid and pressure regulating valves

The machine's pressure control cartridges have been adjusted to the correct settings at the factory. The splitter's guarantee becomes void if the factory adjustments are changed. If you need to change the adjustments, first contact the manufacturer or retailer and follow their instructions carefully. Changing the cartridge settings incorrectly may damage the machine or render it hazardous to operate. The relief valve values can be measured and checked in accordance with the following instructions.

The valves of the Hakki Pilke 55 Pro are presented in the figures below.

Figure 55:

A is the control valve of the measuring device cylinder.

B is the control valve of the splitting knife's height adjustment cylinder.

The valves are located at the rear of the machine behind the topmost sheet metal cover (left side).

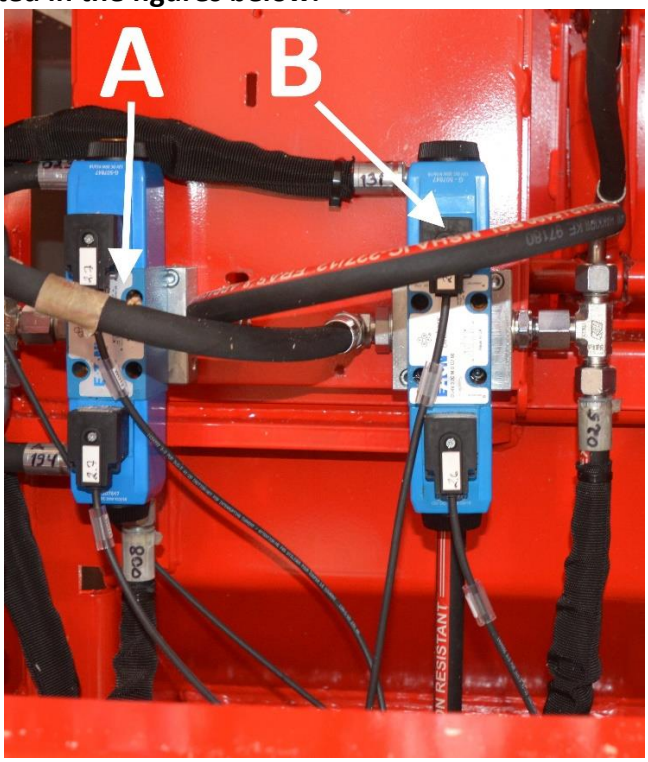


Figure 55.

Figure 56:

Splitting valve block:

- Pressure-increasing valve (**KL1**): adjustment value about 16 mm from base to screw end
- High-speed valve (**KL2**): adjustment value about 12 mm from base to screw end
- Tank valves 2 pcs (**V1 and V2**)
- **C** is the directional valve for splitting.

Note! Do not change the factory settings of the valve block!

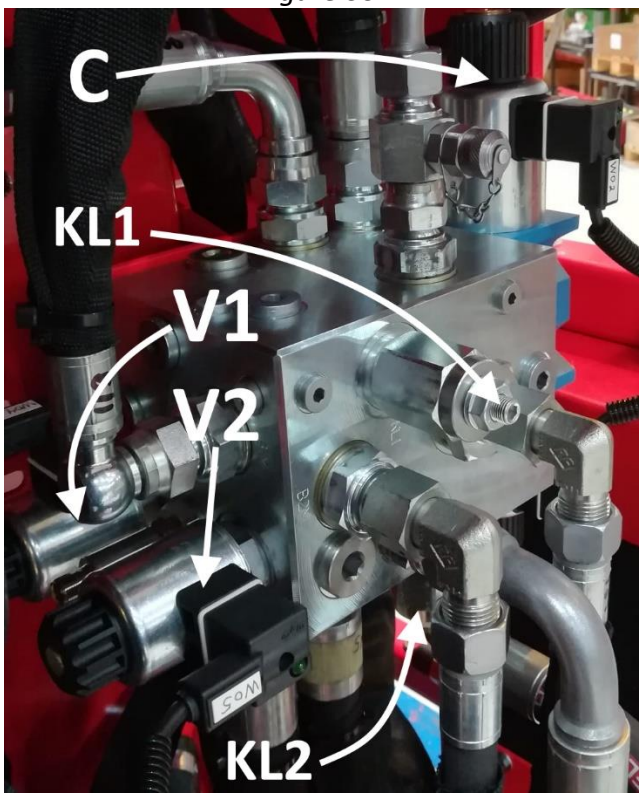


Figure 56.

Figure 57:

E is the saw valve (activates chain rotation)
F is the pumps' sectional valve with the following pressure values:

- **Measuring point F1:** Max 220 bar for the larger hydraulic pump
- **Measuring point F2:** Max 250 bar for the middle pump
- **Measuring point F3:** Max 250 bar for the smallest pump

Note! The values cannot be adjusted. The size of the measuring points is 1/4".

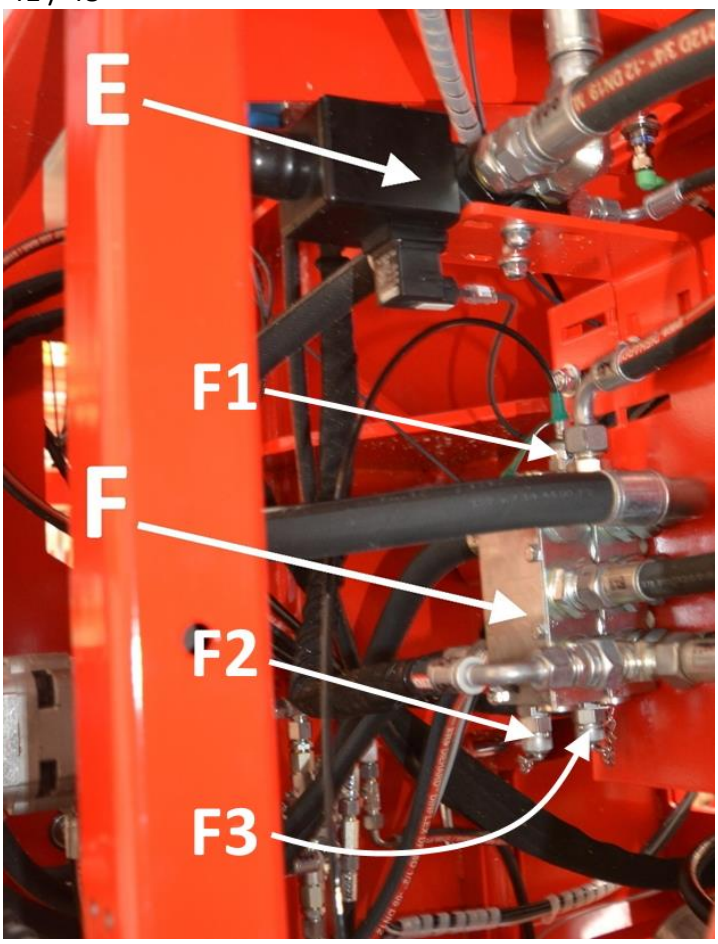


Figure 57.

Figure 58:
G is the log press valve.

H is the feed stop valve (if the bar is not up, the timber feed is stopped)

I is a relief valve

J is the return oil manifold

K is the base plate for pressure relief valves:

- pressure relief valve chain tensioner: 18 bar (inner)
- pressure relief valve: saw bar lowering 20–25 bar (outer)
  L is the control valve for pressure reducers

N (behind the hose) is a pressure relief valve for lowering the saw bar. The adjustment value is 20–25 bar.

M (behind the hose) is a pressure relief valve for the chain tensioner. The adjustment value is approx. 18 bar.

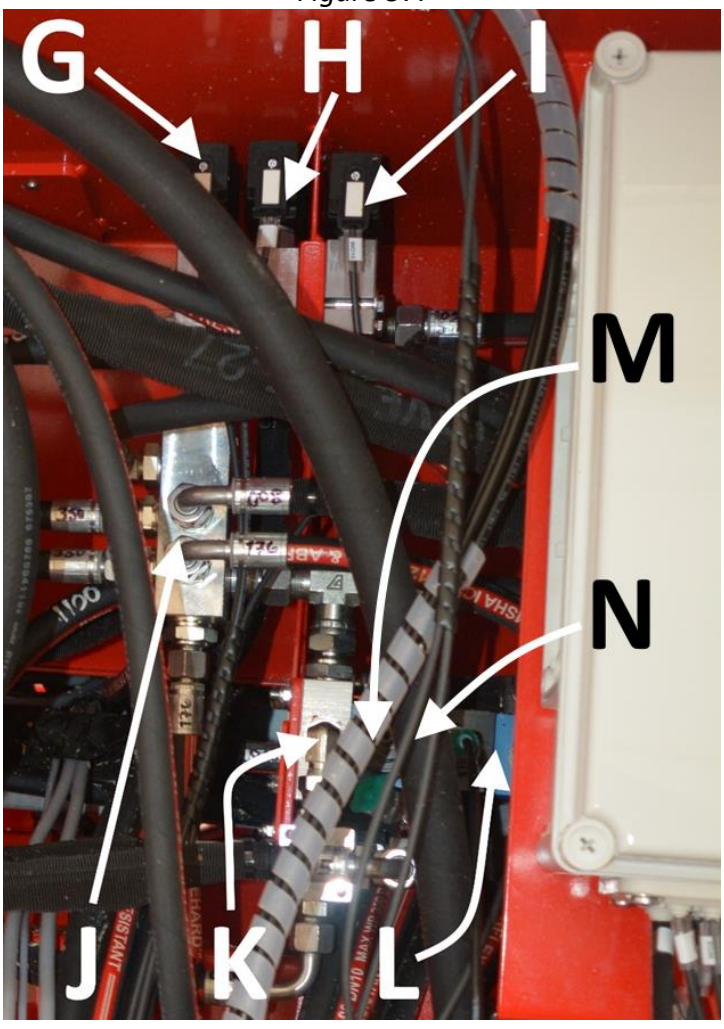


Figure 58.

Figure 59:

A is relief valve 2.

B is tank valve 3.

Figure 59.

5.8. Washing and cleaning

Any loose dirt and sawdust can be removed from the machine with pressurised air, for example. The machine can also be washed with a high-pressure washer, as long as the water jet is not aimed directly at the bearings or electrical equipment.

Always ensure that the machine and the working area are sufficiently clean during operation. The machine must always be cleaned after use. Clean the machine at suitable intervals and always before storing the machine for a prolonged time. After washing, the firewood processor must be lubricated according to the instructions in Section 6.

5.9. Storage

Although the machine is intended for outdoor use, it should be covered and stored in a sheltered location or indoors. Before prolonged storage, the machine must first be cleaned, then washed according to the instructions in Section 9 and lubricated according to Section 6.

5.10. **Maintenance table**

Target	**Task**	**Daily**	**Interval 100 h**	**Interval 500 h**	**Substance/accessory item**
Multiplier gear oil	Check 1st change Subsequent		X X	 X	SAE 80/90. 0.34 l
Hydraulic oil Normal conditions (replacement interval or 2 years)	Check 1st change Subsequent	X	 X	 X	Amount approx. 125 l For example ISO VG 46
Oil filter	Always when changing oil				Number: 97348 (2 pcs) 13921107005357
Grease nipples	Lubrication	According to Section 5			Lubrication oil
SKF lubricator (cartridge)	Check Replace as necessary	X			Cartridge: 50050229 LGWM 2/ MR 380
Saw bar	Check	X			25” 2 mm .404” 95750
Cutting blade	Sharpen as necessary				0.404” 88 vl 2 mm 95762
Saw chain oil	Check	X			Recommendation: Biodegradable saw chain oil
Machine	Clean Wash as necessary	X			
Electric motor	Clean	X			
Electrical equipment	Clean	X			
Winch and strap	Check	X			
Splitting beam (inside the machine)	Clean		X		
Splitting knife	Check Sharpen as necessary	X			

5.11. Failures and remedial measures

Failure	Cause	Remedial measure
Failure due to low hydraulic oil level (display)	1. Leak: tank level indicator alarm.	1. Eliminate the leak and add oil to the maximum level of the sight glass.
Failure due to excessively high hydraulic oil temperature (display)	1. Tank level indicator's thermostat alarm, oil temperature above 70°C.	1. Shut down the machine immediately and check the oil temperature and cause of the overheating.
The splitting force is insufficient to split the log.	1. The log/splitting knife is in an incorrect position. 2. Insufficient pressure increase. 3. The splitting force is not great enough.	1. Fix the position of the log/splitting knife. 2. Return the splitting to the starting position and restart. 3. Contact the retailer.
The in-feed conveyor belt does not move.	1. The belt is too loose.	1. Tension the belt according to the instructions in Section 5.4.1.
The out-feed conveyor belt does not move.	1. The out-feed conveyor's belt is too loose (drive roller is spinning). 2. The lower drive roller is jammed and does not move.	1. Tighten the belt according to the instructions in Section 4.4. 2. Disconnect the machine from the power source and remove the obstruction.
The saw chain does not properly sink into the wood.	1. The saw chain is dull or cuts to the side. 2. The saw bar is crooked. 3. The saw chain is not supplied with sufficient oil.	1. Sharpen or replace the saw chain. 2. File the bar to make it straight. 3. Increase oil feed.
The machine starts, but none of the functions work. The machine makes an abnormal noise.	The electric motor runs in the wrong direction.	See Section 3.2.2.
The electric motor does not start.	1. The machine makes a loud noise, but does not start. 2. The thermal relay has tripped. 3. Starter fuse triggered. 4. The input cable is faulty.	1. The gear fuse has blown. Replace it. 2. Reset the thermal relay with the starter's stop button. 3. Disconnect from the power source and check the starter fuse. 4. Replace the cable.
The electric motor tends to stop, and the thermal relay is easily triggered.	1. The thermal relay is broken or incorrectly adjusted. Some other problem?	1. Contact the retailer.
The cutting or splitting function does not work.	1. The machine guard is open.	1. Close the guard completely.
The sawdust blower is jammed.	1. There is a chip or obstruction in the sawdust blower.	1. Clean the blower's motor.
The machine's electrical control does not work or works unreliably (sawing button, splitting button)	1. In a PTO machine, the 12 V plug is not connected to the tractor (in an electrical model, the 12 V plug is not connected to the machine) 2. Guard open or sensor fault 3. Connection or grounding fault in the tractor.	1. Connect plug. See Section 3.2.1 or 3.2.2 2. Fully lower the guard and check sensor operation (Figure 56). 3. Check the connections 4. Determine the cause of the burnt fuse, and replace the fuse after repairs.

	4. Burnt fuse in 12 V control box	
The saw bar is not lowered fully when the cutting button is pressed.	1. Saw dust or debris under the saw drive end	1. Clean

6. Guarantee terms

“Guarantee terms come into force when you register your customership in the extranet service.”

The guarantee is valid for the original buyer for 12 months, starting from the date of purchase, but for no more than 1,000 operating hours.
Always contact the machine’s seller before undertaking any procedures in matters concerning the guarantee.

A guarantee claim must be issued to the seller in writing **immediately** upon the discovery of a defect. If the defect concerns a damaged part or component, please send a photograph of the damaged part or component to the seller, if possible, so the fault can be identified. When submitting a guarantee claim, the buyer must always include the type and serial number of the machine in the claim and present a receipt that includes the date of purchase. Guarantee claims must be submitted to an authorised retailer.

The guarantee covers

- Parts damaged in normal use due to faults in the material or manufacturing.
- Reasonable repair expenses in accordance with the agreement between the seller or buyer and the manufacturer. Faulty parts will be replaced with new ones. A faulty part or parts replaced due to a material fault must be returned to the manufacturer via the retailer.

The guarantee does not cover

- Damage caused by normal wear and tear (such as saw blades and belts), improper use or failure to observe the instruction manual.
- Damage caused by negligence of maintenance or storage procedures detailed in the instruction manual.
- Damage occurred in transport.
- Cutting blades, V-belts and oil, as well as normal adjustment, care, maintenance or cleaning procedures.

- Defects in a machine to which the buyer has performed or commissioned structural or functional changes, to the degree that the machine can no longer be considered equivalent to the original machine.
- Other potential costs or financial obligations resulting from the procedures mentioned above.
- Indirect costs.
- Travel costs resulting from guarantee repairs.
- The guarantee for parts replaced during the guarantee period of the machine expires at the same time as the machine’s guarantee.
- The guarantee is void if the ownership of the machine is transferred to a third party during the guarantee period.
- The guarantee is void if any of the machine’s seals have been broken.

If a fault or defect reported by the customer is found not to be covered by the guarantee, the manufacturer has the right to charge the customer for the identification and possible repair of the fault or defect in accordance with the manufacturer's current price list.

This guarantee certificate indicates our responsibilities and obligations in full and excludes all other responsibilities.

7. EC Declaration of Conformity for the machine

(Machinery Directive 2006/42/EC, Appendix II A)

Manufacturer: TP Silva Oy
Address: Valimotie 1, FI-85800 Haapajärvi, Finland

Name and address of the person who is authorised to compile the technical file:

Name: Timo Jussila Address: Valimotie 1, FI-85800 Haapajärvi, Finland

The aforementioned person assures that

Hakki Pilke 55 Pro firewood processor Serial number: ……

- is compliant with the applicable regulations of the Machinery Directive (2006/42/EC).

Location and date: Haapajärvi, 22 December 2020

Signature: 

Seppo Koiranen
Managing Director

HAKKI PILKE-MANUALS:

GIVE US FEEDBACK!: