

RESULTS

This year's Shootout featured some major changes, including: no points scores, no price divisions, and participants were allowed to use portable edgers and material-handling equipment. In addition, participants could saw either 1- or 2-inch-thick boards, and they were allowed to use more than (or less than) the traditional two team members. The idea was to put the emphasis on each mill's individual performance, showcasing what each mill could do. Of course, we tracked lumber production and lumber overrun/underrun as well as sawing time for each mill, as we've done in the past. We provide those numbers here, and you'll find some of the same information in each of the individual mill profiles, which begin on page 30.



SHOOTOUT 2003 FINAL RESULTS	TOTAL TIME	TIME OUT	LOG SCALE (BF)	SAWING TIME	LUMBER SCALE(BF)	BF/HR	LRF	MISCUTS (BF)	EDGER USED
Baker 18H	67:34	5:22	517	62:12	539	520	1.04	19	*
Baker 18M	54:35	4:32	523	50:03	579	694	1.11	0	*
Baker 3638D	31:52	0:00	428	31:52	454	855	1.06	77	*
D&L Doublecut TS30	70:13	0:00	545	70:13	446	381	0.82	85	
Granberg Mark III	134:02	15:00	465	119:02	190	96	0:41	11	
Logosol M7	111:57	6:10	535	105:47	480	272	0.90	0	
Logosol Timber Jigg	89:55	11:35	506	78:20	291	223	0.58	16	
Lucas 827	35:05	0:00	508	35:05	539	922	1.06	0	
Mobile Dimension 12XLS	44:43	0:00	429	44:43	360	483	0.84	24	
Morewood 20HP	50:01	0:00	476	50:01	474	569	1.00	33	
Peterson WPF	29:51	0:00	475	29:51	450	905	0.95	11	
Wood-Mizer LT27	86:49	11:52	461	74:57	498	399	1.08	36	
Wood-Mizer LT40HD	38:47	0:00	545	38:47	576	891	1.06	9	

Note: Miscuts – Any board in a team's lumber pile that didn't meet the thickness or wane requirements was recorded as a miscut and did not count in the team's lumber tally. Even though they didn't meet the commercial production standards used for the Shootout, these boards would still be usable lumber for many sawyers. The miscuts category reflects this additional production. Slabs and edgings weren't recorded as miscuts.

RULES & SCORING

- The Shootout was open to any kind of sawmill that can be moved by no larger than a one-ton truck.
- All participants were part of an open field; no point scores were given. Lumber production (in BF/HR) and lumber overrun/underrun (lumber scale ÷ log scale) were tracked and reported.
- Participating manufacturers could use freestanding or attached portable edgers.
- Participating manufacturers could set up log racks, ramps and related log-loading and lumber off-bearing equipment.
- Participants could use chainsaws and chainsaw-powered debarkers to trim and clean their logs prior to the event.
- Mills, edgers, log racks and other equipment used in the event must include only standard equipment and OEM options.
- Each mill was supplied with 4 softwood logs that scaled to a total of approximately 450 board feet. The logs were to be as uniform as possible for all participants. Logs were scaled to the nearest 1/2-inch in diameter using the formula for the International 1/4-inch Log Rule.
- Sawyers had to saw 4-edge lumber of either 1-inch or 2-inch board thickness. Unedged boards were not counted in the official lumber tally. Board widths allowed were: 4 inch, 5 inch, 6 inch, 8 inch, 10 inch and 12 inch. Boards had to meet modified Northeastern Lumber Manufacturers Association (NeLMA) standards.
- There was a two-hour time limit on sawing. A timekeeper was assigned to each team.
- Each team was allowed to use up to 15 minutes of "timeout" time.
- A designated Shootout safety official monitored competitors to make sure the safety rules were followed during the competition, and competitors were requested to comply if unsafe practices or lack of required protective gear were observed.

SPECIAL THANKS

The 2003 edition of the Great Portable Sawmill Shootout would not have been possible without the help and support of many people, including:

- Shawn Bugbee, Daren Cole, Matt Galambos, Ben Nottermann, Joshua Roy and Molly Simonson of the Maine Woodsmen Team of the University of Maine at Orono.
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many 2 x 10-inch boards as possible, to reduce the number of cuts, and take advantage of their largest blade. Still, communication cost the Peterson team several boards when four heavy slabs that could have yielded a board each went to the slab pile and were not re-cut. In addition, two more 1 x 10-inch boards were missed because the log was not solidly clamped down and shifted on them. Add to that 11 board feet of miscut lumber (too much wane), and it's easy to see how critical the decisions of the sawyer and tail man are in getting the maximum yield. These mistakes worked to drop the lumber recovery factor down to 0.95, though they were one of only two teams to exceed a 900 BF/HR cutting rate. Without the mistakes, Peterson estimates, another 41 board feet would have been added to the team's tally.

2003 Shootout was allowing 2-inch-thick boards. "This really shows the advantage of the circle sawmills," he says. "Nobody I know of builds houses with all 1-inch lumber."

Of the Shootout, Carl Peterson says, "It's an educational process for us, and shows like this are beneficial in allowing people to see a different paradigm. The Great Portable Sawmill Shootout is the high point of our promotional year."

What changes might they like to see in the future? "More logs," he says. "Let us cut the full 2 hours with no time outs, and show the folks what the mill can do. "It would give us a better opportunity to show more about how the mill operates, and how quick it is to sharpen. A 2-hour run is pretty

much what you'd cut out in the bush before you have your cup of tea."

Whether or not these changes might take place in next year's Shootout remains to be seen. One change you *can* count on, however, is in the Peterson mill itself: Next year, the company plans to showcase an automatic mill that's now in the prototype phase. "We've been working on it for the last 18 months," says Peterson. ■

One thing in particular that Peterson liked about the new rules for the

Peterson WPF

Veteran team puts swingblade circle mill through its paces.

The swingblade circle mill is more than just a different way to cut lumber. It's an entirely different way of thinking about how to extract boards from a log – any size log. Peterson's first mill (in 1958) used a



12-inch circular blade driven by a chainsaw motor. Originally designed as a means of cutting lumber from large logs without transporting them to the mill, the swingblade circle mill has evolved into a solidly engineered piece of machinery capable of production and lumber recovery that rivals bandsaw mills.

The Peterson WPF mill was one of two swingblade circle mills represented at the Shootout this year. It provided a rare opportunity to see how they compared with each other, as well as how they stacked up against the other mills. With veteran sawyer Chris Browne guiding the saw through the log and inventor Carl Peterson tailing, the mill was put through its paces.

Peterson has several options for

Carl Peterson Sawyer
Chris Browne Tailer

Log scale	.475
Sawing time	:29:51
Lumber scale	.450
BF/HR	.905
LRF	.0.95
Miscuts (BF)	.11

blades, with cutting capacities of 6, 8 and 10 inches. For the Shootout, the team opted for the 10-inch blade, even though the deeper cuts and slightly wider kerf would mean slower cutting times. "The other swingblade mill has a maximum blade cutting capacity of 8 inches, so we wanted to show what the 10-inch blade could do," says Peterson. "We probably could have gotten a better time and yield with the smaller blade."

To demonstrate the WPF mill in actual working conditions, Browne and Peterson knocked off any obvious rocks or grit, but did not debark the logs. Their strategy was to cut as