



Typical Sawing 2nd Floor Plan of Equipment and Workers of a Sawmill with Two (2) Single-Cutting Band Head Saws of the VCLCo era.

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Vilas County Lumber Co. Sawmill Equipment

I	The best practice was to have 3 to 4 times the daily production of logs in a Hot Pond. Logs would have been bucked to 16-18 foot lengths in the pinery for the standard 16 foot production length at the Vilas County Lumber Company.
A	Jack Ladder – an endless chain conveyor with dogs inside a “V” shaped inclined trough to convey logs from the Hot Pond to the second floor Sawmill Log Deck.
B	Geared Log Jacker assembly mechanism - Jack Ladder chain drive.
C	Log Deck - there would be a few logs on both sides of the inclined Log Deck ready to be “turned” onto a Carriage. a, b, & c are steam operated. a. Log Kickers - throws log to one side or the other of the inclined Log Deck. b. Log-stop/Loader - prevents log from rolling on the carriage till wanted. c. Oscillating Log Turner Bar - turns/flips log onto a carriage.
D	Overhead Log Turner – chief means of turning large diameter and length logs.
E	Saw - overhead swing cut-off - was hung from the ceiling to cross cut (trim) logs not having been cut properly in the pinery, operated by the 2 Cant-hook man.
F	3-Block (right hand and left hand) Saw Carriages – moving frame on which mechanisms are mounted for holding a log while sawing it (The Setter 3 sitting & two Doggers 4 “holding on” rode this carriage). a. Steam Exhaust and Air Cushion Carriage Bumpers , or b. Spring Carriage Bumpers . c. Head-block and Knee – holds and “dogs” a log to the carriage. d. Set-works - moves Knees a “set” distance pushing the logs sideways for lumber thickness through a Pinion line shaft. e. Steam Feed “Shotgun” Cylinder – a piston mechanism that moves carriage frame back and forth when sawing. f. Steam Exhaust
G	Band (right hand and left hand Head Saw) Saw Mills – thin continuous metal blade that saws slabs and cants from logs.
H	Live (powered) Rolls (30” wide by 60’ long shown) - moves cants from Head Saw to K Edger or the rear of the Sawmill 2 nd floor on the left side.
I	Live (powered) Rolls (30” wide by 30’ long shown) - moves cants from Head Saw to K Edger or Timbers and Cross Ties out to the Timber Dock, on the right side.
J	Transfer Chain - mechanical cross endless roller chain when activated by a foot pedal raised the chain above the rollers to transfer lumber sideways from Live Rolls.
K	Edger Saw with Front Table – saws Cants to rough widths. Cants are pushed over Dead (un-powered) Rolls by hand, through feed rolls into circular rip saws.
L	Screw Rolls - for dumping Slabs to be ground by a M Hog.
M	Hog – grinds up unusable wood to a suitable size for Power House fuel wood.
N	High Speed Rolls - carries the rough cut lumber from the tail end of the Edger.
O	Lumber Assorting Transfer Table - to Trimmer.
P	Gang Trimmer Saw – saws boards to finished length for Green Chain which ran on the Grading and Sorting Dock.
Q	Endless Chain Conveyor - 360’ long on Grading and Sorting “Green Chain” deck.
R	Sorting Deck - final grading and assorting before transporting to the Drying Yard.
S	Slasher Saw - overhead lath slasher saws Slabs, edgings and other poor grade lumber into laths, fuelwood. And, unusable wood for the Refuse Burner.
T	Slab Table - potential wood accumulated for Lath Mill or Gang sash Saw.
U	Lath Binder/Trimmer - binds and saws rough lengths of lath to a length of 48 $\frac{3}{4}$ ”.
V	Sash-Gang (rip) Saw - saws Slabs and cull lumber too large for Lath Mill into sizes that can be cut by the Lath Mill.
W	Lath Mill - cuts appropriate size wood into $\frac{1}{2}$ ” x 1 $\frac{1}{2}$ ” Lath.
X	Lath Slide - built on site for sliding bundles of Lath through a small wall opening.
Y	Deck - Timber & RR Cross Tie loaded onto flat or gondola RR cars for shipment.
Z	Refuse Drag Conveyor - moves unusable wood to a Refuse Burner. Also equipment such as Sawdust Blowers and Drags were used throughout the mill to get rid of such waste.

Typical Sawing 2nd Floor Equipment list of a Sawmill with Two (2) Single-Cutting Band Head Saws, of the VCLCo era.

Vilas County Lumber Co. 2nd Floor Workers

Item	Worker Title	Job Description of the VCLCo Sawmill era workers who actually did the sawing.
1	Deckman	He kept the flow of logs available for sawing and controlled the Jack Ladder and the Log Kicker. He generally scaled all logs entering the Sawmill. He kept records of the various sizes on a tally sheet or a chalk board.
2	Cant-hook Man	Was employed when logs could not be rolled and/or moved automatically.
3	Head Sawyer	Directs how the logs are to be sawed and the speed of the Head Carriage. The most important man in the Sawmill.
4	Setter	Rides Log Carriage frame seated, "setting" the position of the Head Block on the carriage so logs are sawed into the thickness hand signaled by the Head Sawyer, there being too much noise to talk.
5	Dogger	Two (2) Doggers – rode each log carriage frame to adjust mechanism (dogs) that firmly hold logs for Band Mill sawing.
6	Sawyer	Operates Band Mill Saw, Log Loader, Log Turner, and Carriage Feed.
7	Tail Sawyer	He operates the Skid Transfer from the Band Mill.
8	Swamper	He sorts and guides cants emerging from Band Mill Saw onto Live Roll tables for rough sawing (trimming) cants to width.
9	Edger Man	They are very important Sawmill workers because their judgment of selectively determining quality cuts of cants at the expense of quantity, the mills profits could be greatly increased.
10	Trimmer Man	
11	Tail Edger	Or sometimes called Strip-Catcher, who picked up and discards edgings.
12	Slasher Man	Reduced length of waste to be made into Lath.
13	Hog Feeders	He operates the Hog.
14	Log Monkeys	Ordinary laborers (sometimes called Rosin-bellies) in a Sawmill.
--	Clean-up Men	The best fire protection was to keep the mill clean of combustibles.
15	Cut-off Saw Man	Operates Overhead Swing Cut-off Saw.
--	Saw Filer - Band Saw)	Next to the Head Sawyer, the Band Saw Filer was the most important man working in the Sawmill.
--	Saw Filer - circular	Person who had the knowledge for setting hook, pitch, and shape of saw-teeth.
--	Filer Helper	Remedial work in the 3 rd floor Filing Room.
--	Lath Mill Foreman	Responsible for the Gang Sawyer, Cant Unloaders, Gang Tailers, and Hog Feeders.
16	Lath Mill Operator	Operates the Lath Mill cutting Lath to ½" x 1½" thickness.
17	Lath Trimmer Man	Trims Lath to 48¾" length and hand ties bundles of 50 pieces of Lath.
--	Oilier	A worker whose main job is to oil Sawmill machinery.
--	Watchman	The most dangerous time for fire was after shutting down for breaks, lunch and the end of the day and having a hot bearing ignite sawdust or wood and no one is on site to find and extinguish a fire.
18	Tallyman	Records the amount and size of lumber entering the Green Chain.
19	Lumber Grader and Assistants	Those responsible for grading the lumber throughout mill operations and his assistants were graders, according to specific company and industry standards.
20	Sorting Men	Removes green lumber from the Green Chain.
--	Lumber Piler	

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