



Machinery Affected: MatchPoint® Blade™ Saw
Document: SB216
Title: Printer Heater Installation
Application: TEMPCO™ EHR00045 Heater
Distribution: Customers Upon Order

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Date Created	01/03/2018
Created By	Ted Peterson
Approved By	S. Larson
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Revised By	R. Tucker

Purpose and Scope

Older *BLADE* saw MPAs (master printer assemblies) do not have an enclosure heater unit installed. This procedure explains how to install the 120V enclosure heater unit.

The parts included in this kit are shown in Table 1. Please ensure all parts are present before starting this procedure.

Table 1: Parts Included in SB216KIT

Qty.	Part Description	Part Number
1	Enclosure heater and hardware	508001
2	Tie wrap pad	504313
2	3 ½" zip tie	508700

Before beginning the procedure, gather the following supplies:

Table 2: Tools Required

Drill	Slotted screwdriver
Metal-rated drill bit set	2.4 mm slotted screwdriver
12" metal ruler with minimum 1/16" increments	#1 Phillips screwdriver
Permanent marker	Socket set with 6" extension

If you have any questions, call MiTek Machinery Division Customer Service at 800-523-3380.

Procedure

Electrical Lockout/Tagout Procedures

	WARNING
	<p>ELECTROCUTION HAZARD!</p> <p>Verify that all power to the machine has been turned off and follow approved lockout/tagout safety procedures before performing any maintenance.</p> <p>All electrical work must performed by a qualified electrician.</p> <p>If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.</p>

Working on a Machine, outside the Machine’s Main Electrical Enclosure

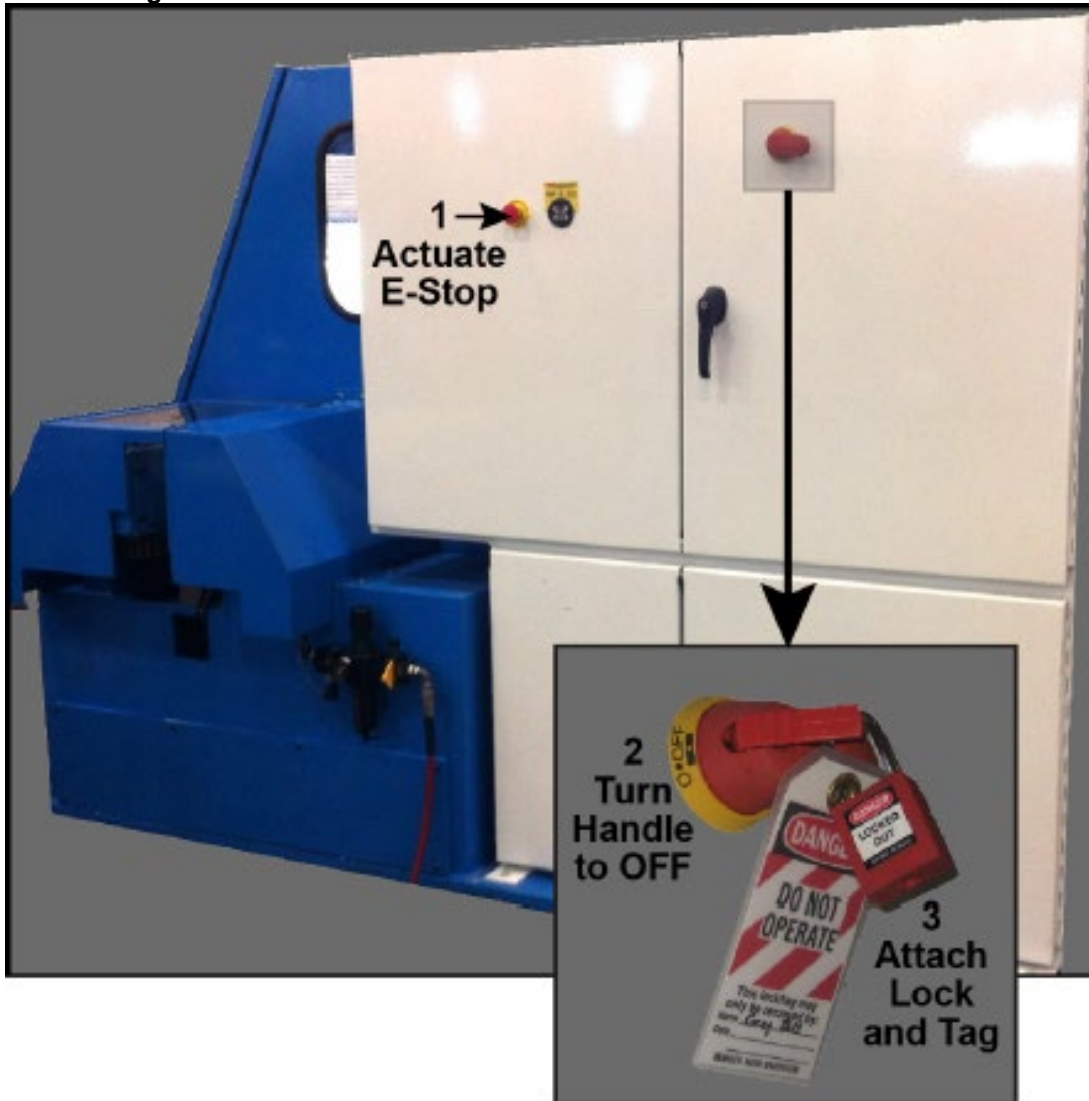
Before performing maintenance on any machine with electrical power, lockout/tagout the machine properly. When working on a machine outside of the machine’s main electrical enclosure, not including work on the electrical transmission line to the machine, follow your company’s approved lockout/tagout procedures which should include, but are not limited to the steps here.

1. Place the load arms on the *BLADE* saw infeed in the Up position.
2. Power down the *BLADE* saw computer on the saw operator interface.
3. Engage an E-stop on the machine.
4. Turn the disconnect switch handle on the *BLADE* saw’s main electrical enclosure to the “Off” position. See Figure 1. Turning this disconnect switch will prevent power from reaching the Auto Deck.

	WARNING
	<p>ELECTROCUTION HAZARD.</p> <p>When the disconnect switch is off, there is still live power within the disconnect switch’s enclosure. Always turn off power at the building’s power source to the equipment before opening this electrical enclosure!</p>

5. Attach a lock and tag that meets OSHA requirements for lockout/tagout.

Lockout/Tagout on the Main Electrical Enclosure

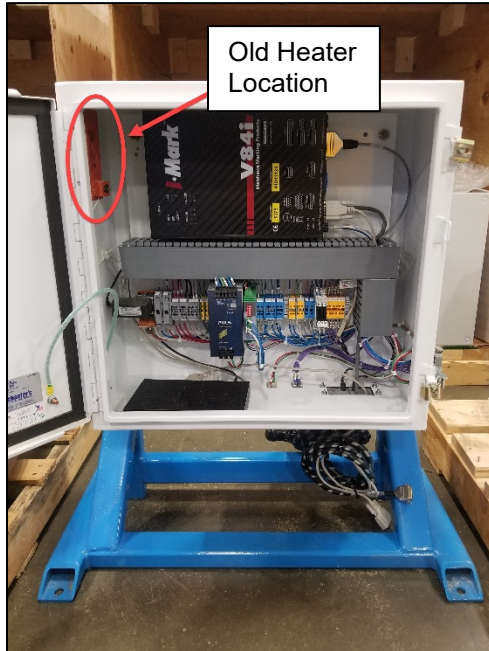


Installation of Printer Enclosure Heater

Open the panel to gain access to the printer enclosure holding your print controller. The pictures here show the heater already installed. Choose the step below that describes your current (damaged) heater.

Note: A V84i enclosure might be mounted to the back side of the Infeed Rail.

Old Heater Shown in Master Printer Enclosure (for V84i Print Controller)



If replacing the old-style heater:

1. Unscrew and discard the damaged heater, but keep the hardware.
2. Choose any location where the heater will have air flow around it and will not be touched by wires or other components, and mark the hole locations. The location used in new enclosures is shown in the next step, but your enclosure may not accommodate that exact location.
3. Protect electronic components from metal shavings that may fall in the next step.
4. Drill holes appropriate for the hardware you plan on using. It is acceptable to use the old hardware if it fits, or you may use the new hardware provided.
5. Vacuum metal shavings out of the enclosure.
6. Install the new heater.

New Heater Shown in MPERIA Print Controller Enclosure



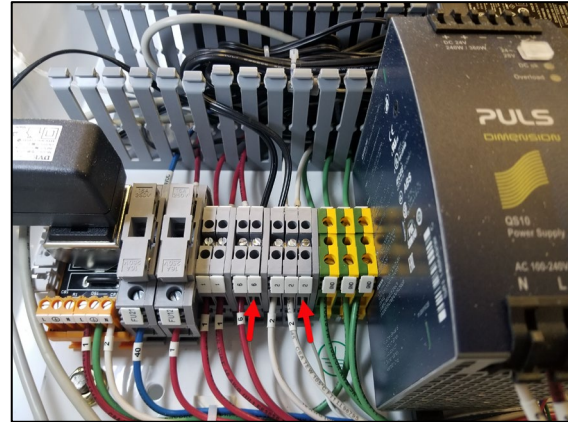
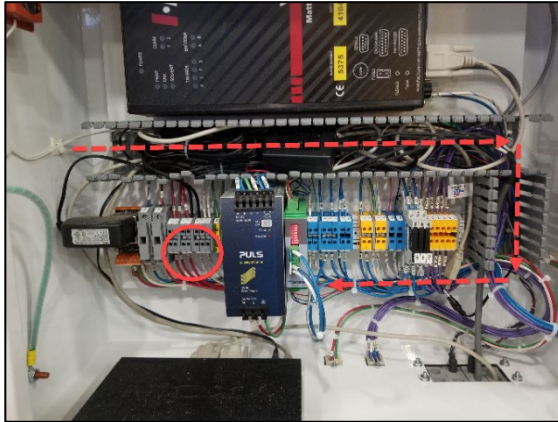
If replacing a heater that looks the same as new one:

1. Unscrew and discard the damaged heater and hardware.
2. Use the enclosed hardware to screw the new heater in place using the same holes.

Wiring of Master Printer Assembly (MPA) Enclosure Heater

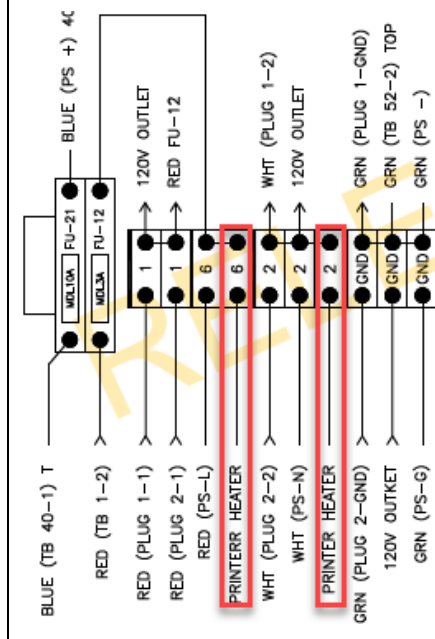
1. Route wires from enclosure heater through both the horizontal and vertical wire ducts, positioning the wire as far back in the ducts as possible. From the bottom of the vertical wire duct, guide the wires along the main wire bundle to position 2 and 6 on the output of the terminal block. Secure in terminal block utilizing a 2.4 mm slotted screwdriver. See in Figure 5.

MPA Heater Wiring Position

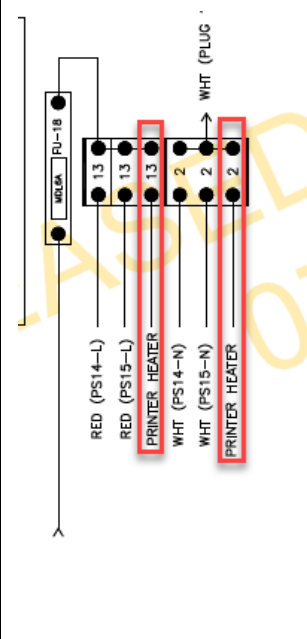


V84i Printer Enclosures Wiring Schematics

MPA Enclosure Wiring (All Printer Options)



Secondary Enclosure Wiring (Only Printers with Two 32-Valve Print Heads)



2. Replace the wire duct covers and install the enclosed tie wrap pads wherever they are needed to restrain the excess enclosure heater wire. See Figure 6.
3. Ensure all tools and debris have been removed from enclosure and latch panel shut.
4. Disengage all safety measures and continue to operate saw.

END OF PROCEDURE