MiTek®
Machinery Division

Service Bulletin

Machinery Affected:	***MatchPoint BLADE™***
Document:	**SB205**
Title:	**Replacing the Gas Springs on Saw Chamber Door**
Applies To:	**All *BLADE* Saws**
Distribution:	**Customers, Upon Order**

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Revised By	R. Tucker
Approved By	M. Kanjee
Applicability	all saws
Effectivity	all saws

Purpose and Scope

When replacing the gas springs on the *BLADE*™ wood processing system saw chamber door, follow these instructions carefully. If the gas springs are installed incorrectly, they may fail prematurely.

Overview

The parts included in this kit are shown in Table 1 or Table 2. Please ensure all parts are present before starting this procedure.

Table 1: Parts in SB205KIT-A (Frames 121 and Higher)

Qty.	Part Description	Part #
2	Gas spring	370575
1	Service Bulletin document	SB205

Table 2: Parts in SB205KIT-B (Frames 1-120)

Qty.	Part Description	Part #
2	Gas spring	370575
4	Clevis mount kit to replace old bracket and eyelet (includes capscrews and shoulder bolt)	89771-501
1	Service Bulletin document	SB205

If, during installation, the following parts are unable to be re-used, order them using these part numbers. The parts are shown in Figure 2.

Table 3: Additional Parts on the Finished Gas Spring Assembly

Qty.	Part Description	Part #
2 per gas spring	Eyelet with threaded collar	370564
2 per gas spring	Clevis mount to replace old bracket and eyelet (includes capscrews and shoulder bolt)	89771-501

Before beginning the procedure, gather the supplies listed here:

- lock and tag
- flat-blade screwdriver
- Allen wrench set

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

Procedure

Electrical Lockout/Tagout Procedures

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

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.

Figure 1: Lockout/Tagout on the Main Electrical Enclosure

1. Engage an E-stop on the machine.
2. Turn the disconnect switch handle on the machine's main electrical enclosure to the "off" position. See Figure .

	**⚠ WARNING** **ELECTROCUTION HAZARD.** **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!**

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

Pneumatic System Lockout/Tagout Procedure

	⚠ WARNING
	**MOVING PARTS CAN CRUSH AND CUT.** **Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures.** **Turn off the air switch before performing any maintenance on the equipment.**

	⚠ WARNING
	**HIGH PRESSURE HAZARD.** **Bleed pneumatic lines before performing any maintenance on the pneumatic system.**

Replacing a Gas Spring

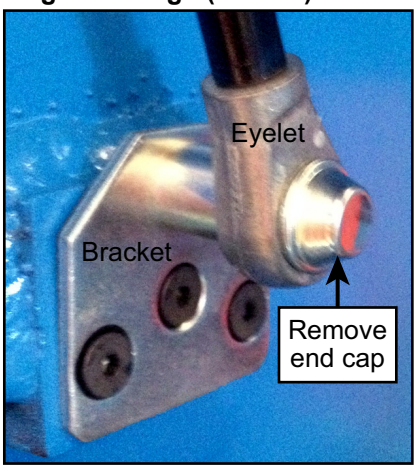
1. After performing lockout/tagout, open the saw chamber door.
2. Cut two 2x4 boards to the correct length to act as braces to keep the weight off the gas springs as you are changing them.

   Only change one gas spring at a time so the other gas spring can assist in holding up the door. Do not rely on that single gas spring or just the boards to do the job.
3. Remove ONE gas spring by following these steps:

   a) **If your bracket looks like Figure 2,** you should have kit B which comes with new mounting brackets. Perform these steps to remove a gas spring:

      1) Gently pry off the end cap at each end of the damaged gas spring assembly using a slotted screwdriver.
      2) Pull each end of the gas spring assembly off its bracket to remove the gas spring assembly.
      3) Unscrew each of the 2 eyelets from the gas spring and set aside for reuse if they are in good condition.
      4) Remove the bracket from the frame and door.

Figure 2: Bracket and Eyelet for Original Design (370562)



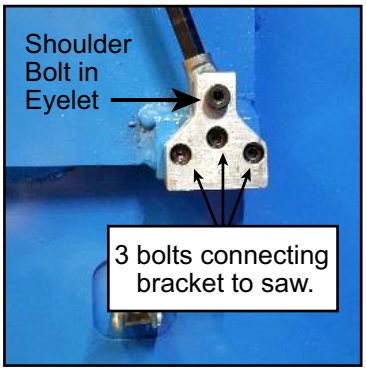
If any eyelets are damaged, stop this procedure and order as instructed on page 2. It is recommended to examine all other eyelets at this time.

If the eyelets are in good condition, save them for re-use and continue to step 5.

   b) **If your bracket looks like Figure 3,** you should have kit A. Perform these steps to remove a gas spring:

      1) Remove the shoulder bolt from both ends of the gas spring and remove the gas spring from its mounting brackets.
      2) Unscrew both eyelets (shown in Figure 2) and examine them to ensure they are in good condition.

Figure 3: Clevis Mount Design for New Gas Springs



4. If your existing brackets look like Figure 2, replace them with the clevis-mount brackets shown in Figure 3 (supplied in kit B).

a) Remove the 3 screws in each bracket and discard the screws and bracket.

b) Place Blue *Loctite*™ adhesive on the supplied 10-24x1-1/2" socket head cap screws.

c) Install the new clevis-mount brackets as shown in Figure 3, using the same holes as previously used.

d) Wait 10 minutes for the *Loctite* to dry before installing the gas springs.

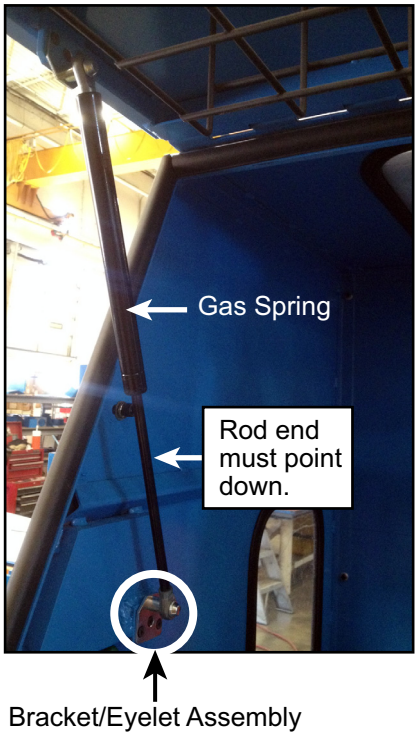
5. Install the new gas spring assembly:

a) Screw the eyelets (from previous assembly or purchased separately) onto each end of the new gas spring.

b) Install the new gas spring, with the rod end pointing down:

1) Insert the eyelet on the cylinder end into the clevis mount slot on the door mounting bracket.
2) Apply Blue *Loctite* to the 5/16" shoulder bolt and secure the eyelet.
3) Repeat to attach the rod-end of the gas spring to the mounting bracket inside the saw chamber.

Figure 4: Gas Spring Assembly



6. Repeat the process to replace the second gas spring.

It is important to replace both gas springs so the door opens evenly and shuts completely.

7. Open and close the saw chamber door to ensure it is operating correctly.

8. Remove the lockout/tagout devices.

END OF SERVICE BULLETIN