

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. Please ensure all parts are present before starting this procedure.

Table 1: Parts in SB205KIT

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

Before beginning the procedure, gather the supplies listed here:

- lock and tag
- slotted screwdriver

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 2: Additional Parts on the Finished Gas Spring Assembly



Qty.	Part Description	Part #
2	Eyelet bracket and end cap <i>Replaces 370562 on frames 1-120. Is built into door on frames 120+.</i>	89771-501
2	Eyelet with threaded collar	370564

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 be 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>

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
	<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>

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

Pneumatic System Lockout/Tagout Procedure

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

	 WARNING
	<p>HIGH PRESSURE HAZARD.</p> <p>Bleed pneumatic lines before performing any maintenance on the pneumatic system.</p>

Replacing a Gas Spring



1. After performing lockout/tagout, remove the gas spring by following these steps:
 - a) Gently pry off the end cap at each end of the damaged gas spring assembly. A slotted screwdriver should be the only tool needed. Set the end caps aside for reuse.
 - b) Pull each end of the gas spring assembly off its bracket to remove the gas spring assembly.
 - c) Unscrew each of the 2 eyelets from the gas spring and set aside for reuse.
 - d) Discard the damaged gas spring, but keep all other parts.

2. If replacing the brackets with 89771-501, do so at this time, using the steps below. If leaving the current brackets, continue to the next numbered step.
 - a) All 4 brackets (2 per gas spring) must be replaced at the same time. Replacing only 1 or 2 will cause the door to close unevenly.
 - b) Remove the 3 screws in each bracket and discard the screws and bracket.
 - c) Place Blue *Loctite*TM adhesive on the screws.
 - d) Install the new brackets (clevis mounts) as shown in Figure 3, using the same holes and the new 10-24x1-1/2" socket head cap screws.
 - e) Wait 10 minutes for the *Loctite* to dry before continuing.
 - f) Repeat until all 4 brackets are replaced.

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

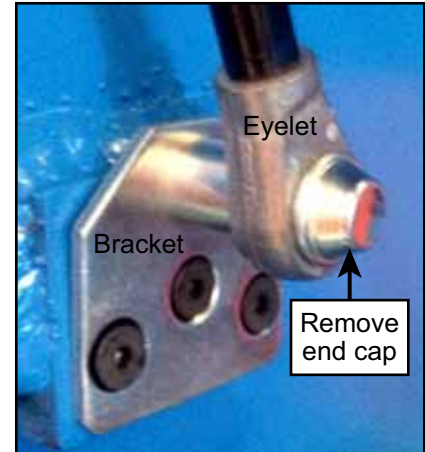


Figure 3: Clevis Mount Design (89771-501)



3. Assemble and install the new gas spring assembly:

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

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

- For bracket 370562: Each eyelet on the end of the gas spring slips over the bracket.

- For clevis mount 89771-501:

- 1) Each eyelet on the end of the gas spring inserts into the slot of the door bracket.

- 2) Apply Blue *Loctite* to the 5/16" shoulder bolt.

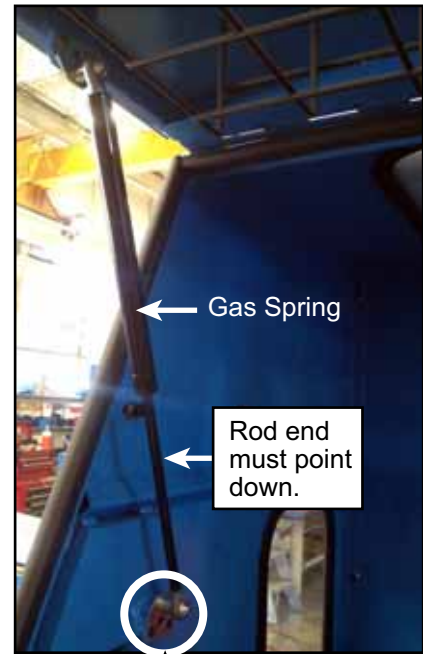
- 3) Secure the eyelet with the 5/16" shoulder bolt.

c) Snap an end cap (from previous assembly) onto each bracket so they hold the gas spring assembly in place.

4. Inspect the second gas spring supporting the saw chamber door. If the rod end is pointing up, turn it around so the rod end points down. This will extend the life of the gas spring.

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

Figure 4: Gas Spring Assembly



Bracket/Eyelet Assembly

END OF SERVICE BULLETIN