



Machinery Affected: *MatchPoint® Blade™ Saw*
Document: SB216 rev. A
Title: Printer Heater Installation
Application: TEMPCO™ EH0005 Heater
Distribution: Customers Upon Order

<i>Part #</i>	SB216
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Purpose and Scope

Older *BLADE* saw MPAs (master printer assemblies) do not have the TEMPCO EHR00005 120V enclosure heater unit installed. This procedure explains how to install the TEMPCO EHR00005 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

<i>Qty.</i>	<i>Part Description</i>	<i>Part Number</i>
1	Enclosure heater and hardware	508030
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

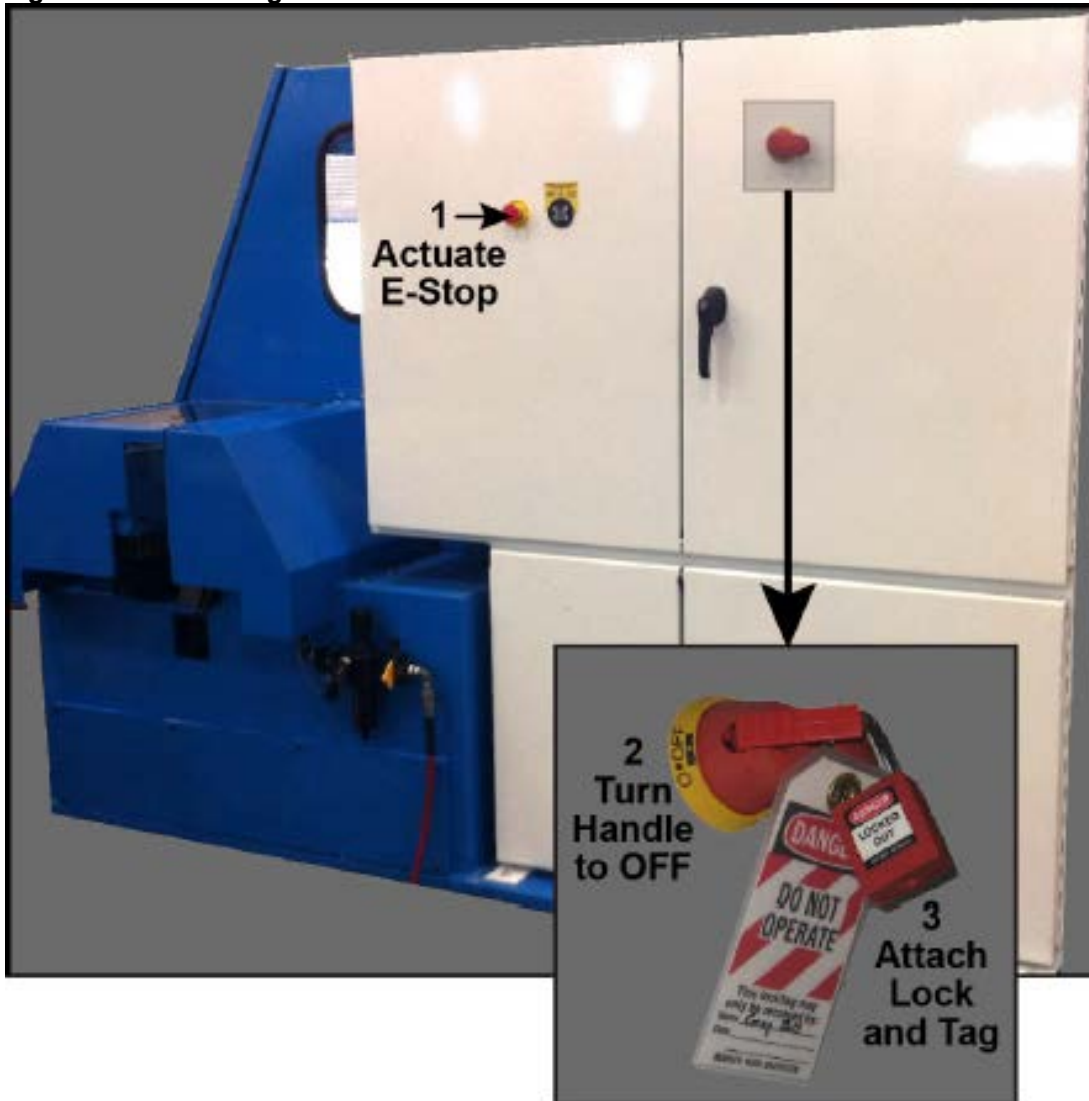
Before performing maintenance on any machine with electrical power, lockout/tagout the machine properly. When working on a machine outside of the machine’s main electrical enclosure, not including work on the electrical transmission line to the machine, follow your company’s approved lockout/tagout procedures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

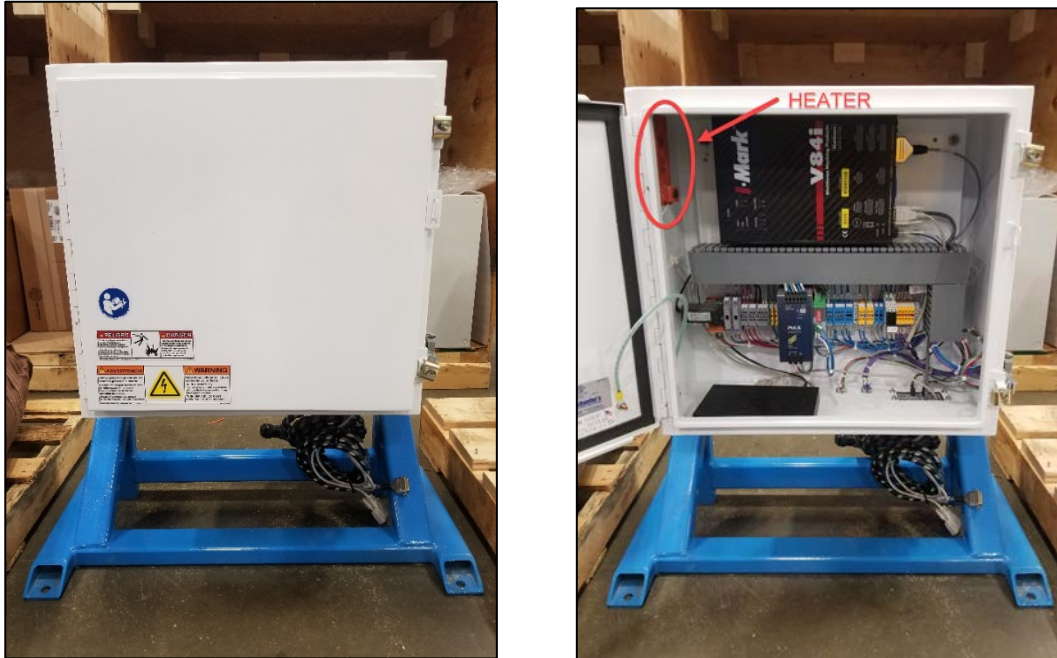
Figure 1: Lockout/Tagout on the Main Electrical Enclosure



Installation of Master Printer Assembly (MPA) Enclosure Heater

1. Open the panel to gain access to the MPA enclosure. Figure 2 shows the heater already installed.
Note: The enclosure may be mounted to the backside of the Infeed Rail.

Figure 2: Master Printer Assembly (Opened and Closed)



2. Make two marks that will later be drilled out for mounting hardware. Make one mark 2-1/4" down from the top left of the front side of the enclosure. Make a second mark 5-1/4" down from the top left on the front side of the enclosure. Both marks should be approximately 1/2" out from the left hand side of the enclosure opening. The distance between the two mounting holes on the Enclosure Heater Mount is approximately 3" apart (on center). See Figure 3.

Figure 3: MPA Heater Enclosure Mounting Hole Position/Location



- Using no larger diameter than a 5/32" metal rated drill bit, bore a hole through both marks made in the previous step.

Note: If necessary, clean debris or burs from the holes.

- Utilizing the hardware enclosed with the heater, fasten the Enclosure Heater to the inside upper left edge of the MPA. See Figure 4.

Figure 4: Interior and Exterior View of Mounting Hardware



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.

Figure 5: MPA Heater Wiring Position

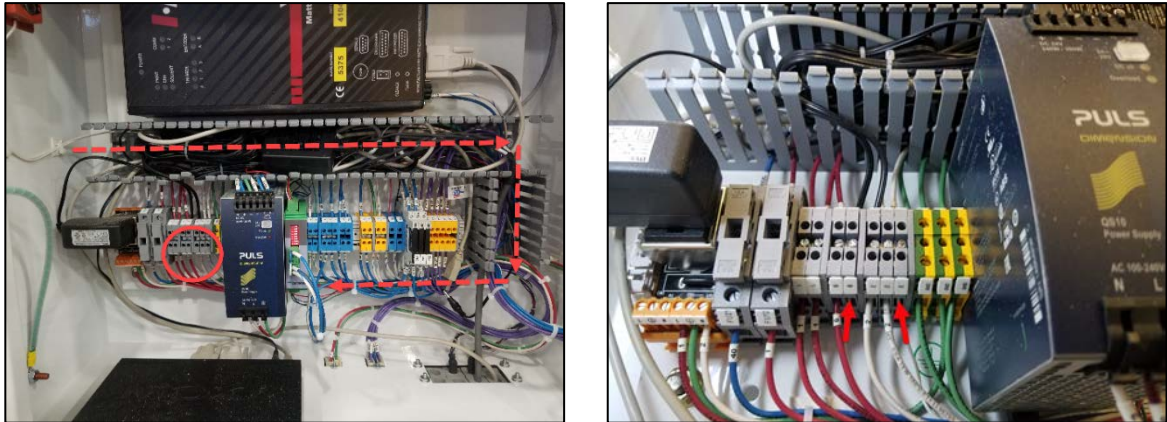
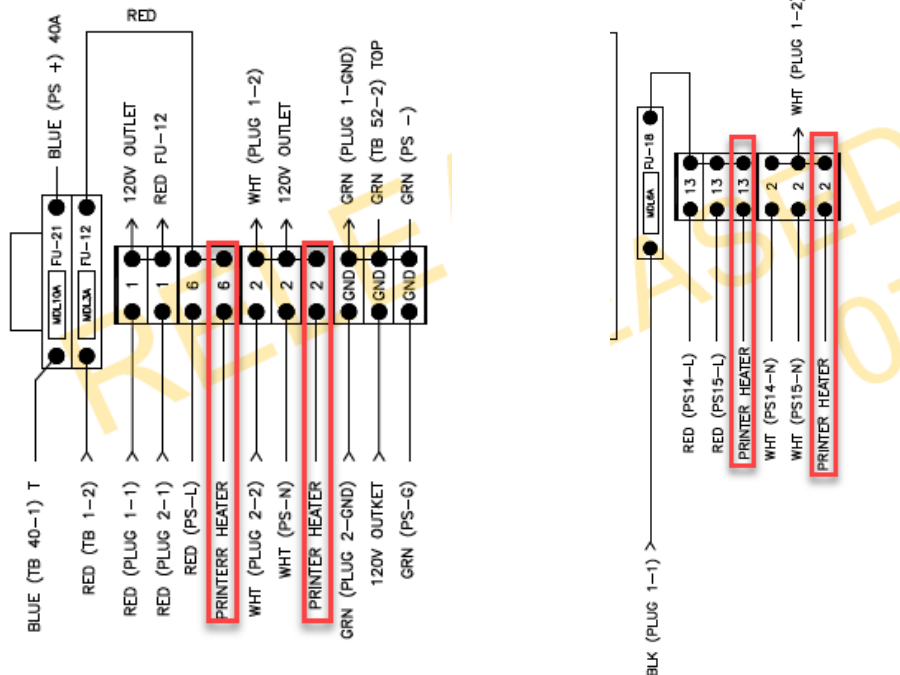


Figure 6: MPA Enclosure and Secondary Enclosure Wiring Schematics

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 two tie wrap pads on the inside left wall of the enclosure. Restrain the excess enclosure heater wire to the tie wrap pads with two zip ties. See Figure 6.

Figure 6: MPA Tie Wrap Pad Approximate Placing



3. Ensure all tools and debris have been removed from enclosure and latch panel shut. Disengage all safety measures and continue to operate saw.

END OF PROCEDURE