MiTek®
SERVICE BULLETIN

Affected machinery:
Finish Roller II Finishing Press

Document:
SB240

Title:
Adding a Heater

Applies to:
Any Finish Roller II Without a Heater

Distribution:
Customers Upon Order

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Purpose and Scope

This Service Bulletin describes how to add a heater to the equipment listed on the title page that did not previously have a heater.

Overview

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

Table 1: Parts in SB240KIT

Qty.	Part Description	Part #
1	Heater	508029
2	Fuse, 3 amps	516388
2	Flat washer	365611
2	Nut	361916
2	Screw 8-32 x 1/2”	341068
2	Lock washer	364022
2	Rubber washer	365850
1	Wire label sheet, blank	694060
2	Tie wrap pad	504313
2	Cable tie	508700
1	Service bulletin document	SB240

Supplies Needed
Lockout/tagout equipment
Drill
Ruler or tape measure
Marker
Slotted screwdriver
11/32” socket and handle
Lock-jaw pliers
Metal-rated drill bit size 4.5 mm (3/16”)

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

The heater automatically kicks on at 50ºF (+/-9º) and kicks off at 80ºF (+/-5º) to keep your enclosure at a temperature that is safe for the components inside. The components inside will not operate in freezing temperatures.

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.**

Procedure for Working Either on a Machine Inside the Machine's Main Electrical Enclosure or in the Electrical Transmission Line to the Machine

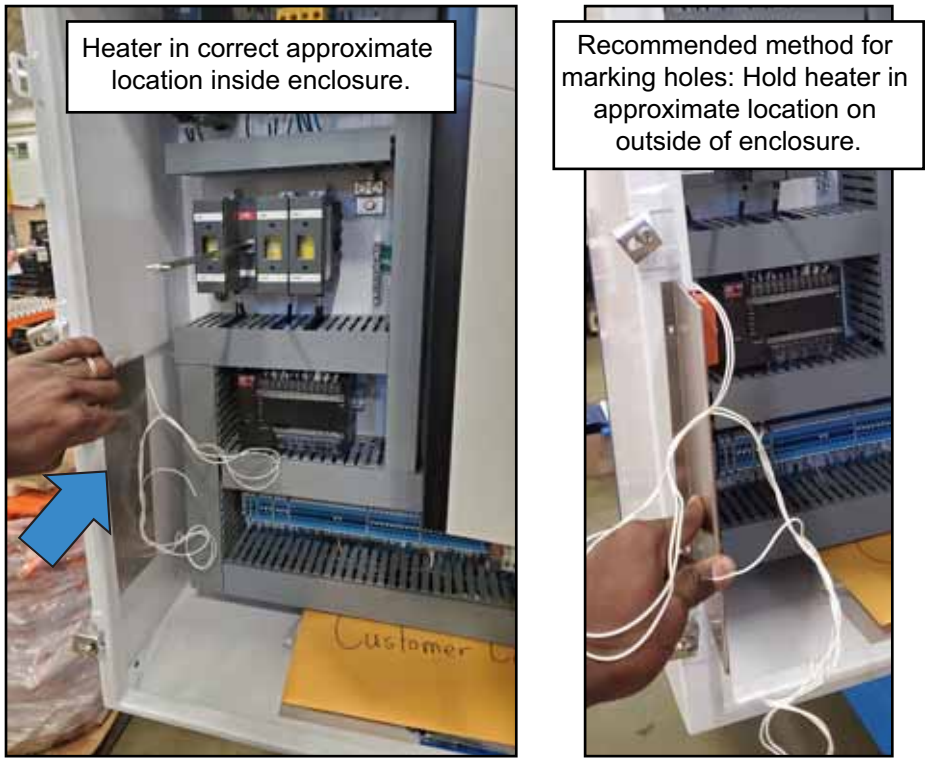
Before opening the main electrical enclosure or attempting to repair or replace an electrical transmission line, lockout/tagout the machine properly. Follow your company's approved lockout/tagout procedures, which should include, but are not limited to, the steps here.

1. Engage an E-stop on the machine.
2. Turn the machine's disconnect switch to the Off position. This is usually required to open the main electrical enclosure's door.
3. Shut the power to the machine off at the machine's power source, which is usually an electrical service entry panel on the facility wall. One example of a locked-out power source panel is shown in Figure 1.
4. Attach a lock and tag that meets OSHA requirements for lockout/tagout to the electrical service entry panel.
5. Wait 20 seconds for the VFD to discharge any remaining power.
6. Open the door to the enclosure and verify that the power is off.

Figure 1: Lockout/Tagout on the Power Source Panel

Mounting the Heater

Figure 2: Marking Holes for Heater Installation



1. After locking/tagging out, cover electrical components with a rag to protect them from metal shavings.
2. Mark holes as shown in Figure 2.
3. Drill the holes from the outside of the enclosure using a 4.5 mm drill bit. A 3/16” drill bit will work if a metric set is not available.
4. Smooth burrs from the holes and vacuum debris from the enclosure.
5. Connect the heater to the enclosure wall using the hardware shown in Figure 3 through the holes just drilled.

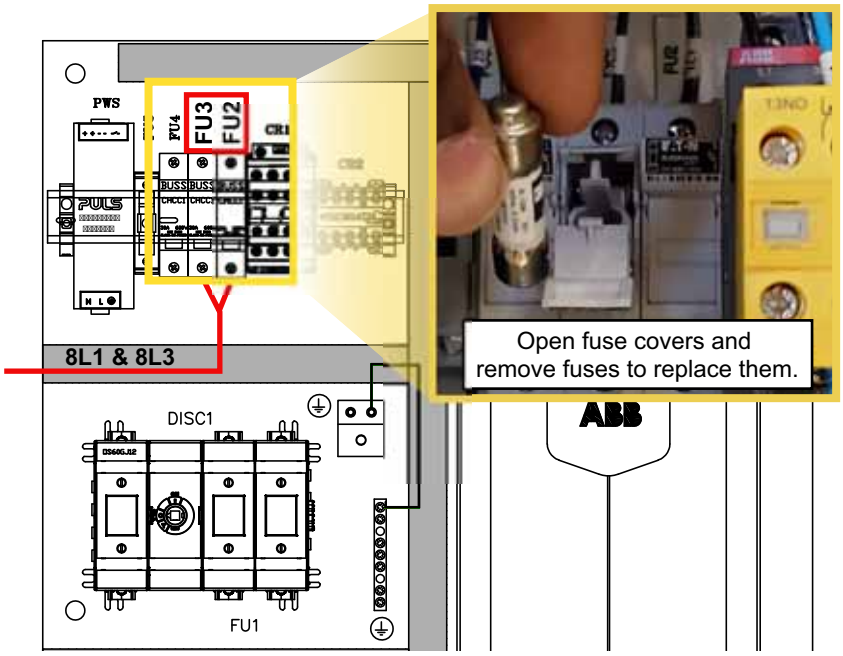
Figure 3: How to Install the Hardware

Wiring the Heater

The fuses supplied are identical to each other. Discard old fuses or save for other uses.

1. Remove Fuse 2 and Fuse 3 from the electrical enclosure, and replace them with the new 3-amp fuses supplied. See Figure 4.

Figure 4: Replace Fuse 2 and Fuse 3



2. Label the wires that are attached to the heater as **8L1** and **8L2** using the supplied wire labels. The order is not important.

3. Route 8L1 and 8L3 wires from the heater into the cable track shown in Figure 4. Use the tie pads and cable ties as needed to keep the enclosure neat and orderly.

4. Connect 8L1 and 8L3 wires to the bottom of the new Fuse 2 and Fuse 3 as described here. They will share the fuse with existing wires.
   - Connect 8L1 to the same fuse that houses wire 3L1.
   - Connect 8L3 to the same fuse that houses wire 3L3.

	⚠ WARNING
	**ELECTROCUTION HAZARD!** **Follow NFPA 70E for proper procedures and personal protective equipment.**

5. Remove the lockout/tagout devices, and use a multimeter to verify the heater wires have power.

END OF SERVICE BULLETIN