MiTek®
Machinery Division

Service Bulletin

Machinery Affected:	**BLADE™ Saw**
Document:	**SB202 rev. A**
Title:	**Replacing the Saw Blade**
Applies To:	**All BLADE Saws, as of Prototype and First Build**
Distribution:	**Customers, Upon Order of Saw Blade**

NEW TORQUE SPECS!

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Date Created	13 Nov. 2013
Created By	R. Tucker
Approved by	M. Kanjee
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Revised By	R. Tucker
Approved By	M. Kanjee
Applicability	89060-501, all models
Effectivity	as of Prototype (September 2013)

Purpose and Scope

When replacing a dull saw blade, follow this procedure to ensure that the blade is secure and can safely operate. Before starting, ensure you have the proper customer-supplied tools listed in Table 1-2

Overview

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

Table 1-1: Parts in SB202 rev. AKIT

Qty.	Part Description	Part #
1	Saw blade, 17”	005-06071
1 box	Flat head screws, 50 screws per box	325184
1	Service Bulletin 202 document	SB202

Before beginning the procedure, gather the supplies listed in Table 1-2.

Table 1-2: Customer-Supplied Items

Part Description
Torque wrench and T30 *Torx*™ driver (also called star or hexalobular internal shaped driver)

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

Procedure

Electrical Lockout/Tagout Procedures

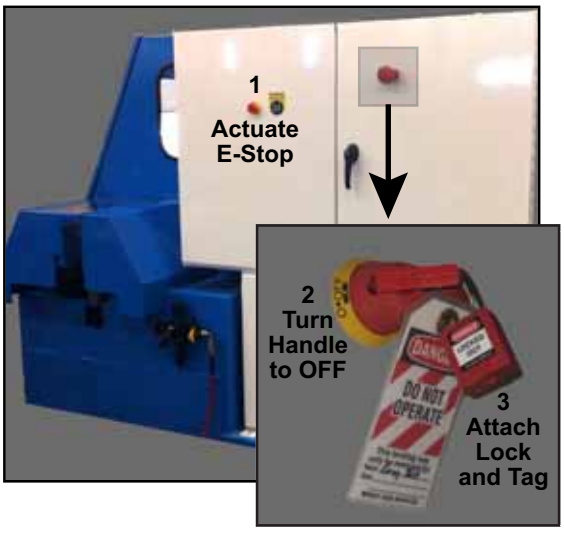
	⚠ WARNING
	**ELECTROCUTION HAZARD!** **Verify that all power to the machine has been turned off and follow approved lockout/tagout safety procedures before performing any maintenance.** **All electrical work must performed by a qualified electrician.** **If it is absolutely necessary to troubleshoot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

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 1.

Figure 1: Lockout/Tagout on the Main Electrical Enclosure



	⚠ 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 pneumatic shutoff valve before performing any maintenance on the equipment.**

How to Replace the Blade

	⚠ CAUTION
	**CUT HAZARD.** **Saw blades are sharp. Wear gloves and eye protection when handling blade.**

1. Gather the following supplies:

   a) New or sharpened saw blade.

   b) Correct screws (6):

      • Each new saw blade kit comes with a box of 50 screws. Keep the extra screws to reinstall a used blade after sharpening.

   c) Correct Torque wrench and T30 Torx™ driver (also called star or hexalobular internal shaped driver).

2. After ensuring the power is locked out, loosen and remove the screws labeled in Figure 3 on page SB202 rev. A6. Discard the screws.

3. Remove the saw blade and place in a safe place for sharpening or re-tipping.

4. Prepare the surfaces:

	⚠ WARNING
	**Mounting surfaces and hardware must be clean and dry when installing saw blade.** **Dust, dirt, and lubrication may cause the blade to come loose, causing injury or death.**

   a) Blow off dust from the hub, the bolt threads.

   b) Wipe down the mounting surface on the new saw blade and the hub.

   c) Ensure all parts are clean, dry, and free of lubricants.

   d) If using a used saw blade, measure its diameter from outside edge of tooth to outside edge of tooth. If the diameter is less than 16-5/8”, discard the blade.

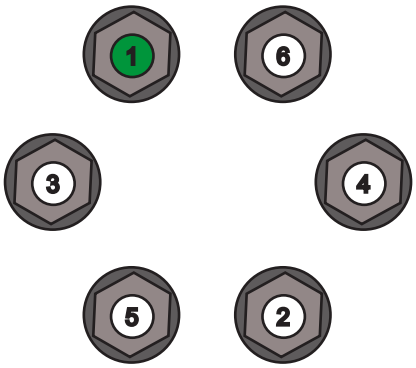
   e) Place a new/resharpened saw blade so the holes are aligned with the holes in the hub.

	**⚠ WARNING** **Use new screws every time the blade is replaced.** **Do NOT use thread adhesive.** **Torque to specifications given in Figure 3!**

Use only 1/4”-28x5/8” flat head screws of the same strength and specifications as MiTek SB202KIT supplies.

5. Using new screws obtained from MiTek with your last new saw blade purchase, install all 6 screws.
   - Use the driver and screws described in step 1.
   - Hand tighten all 6 screws in the order shown in Figure 2.
   - Using a torque wrench, tighten the screws in the order shown in Figure 2 until they all reach the recommended torque shown in Figure 3 on page 6.

Figure 2: Tighten Bolts in This Pattern



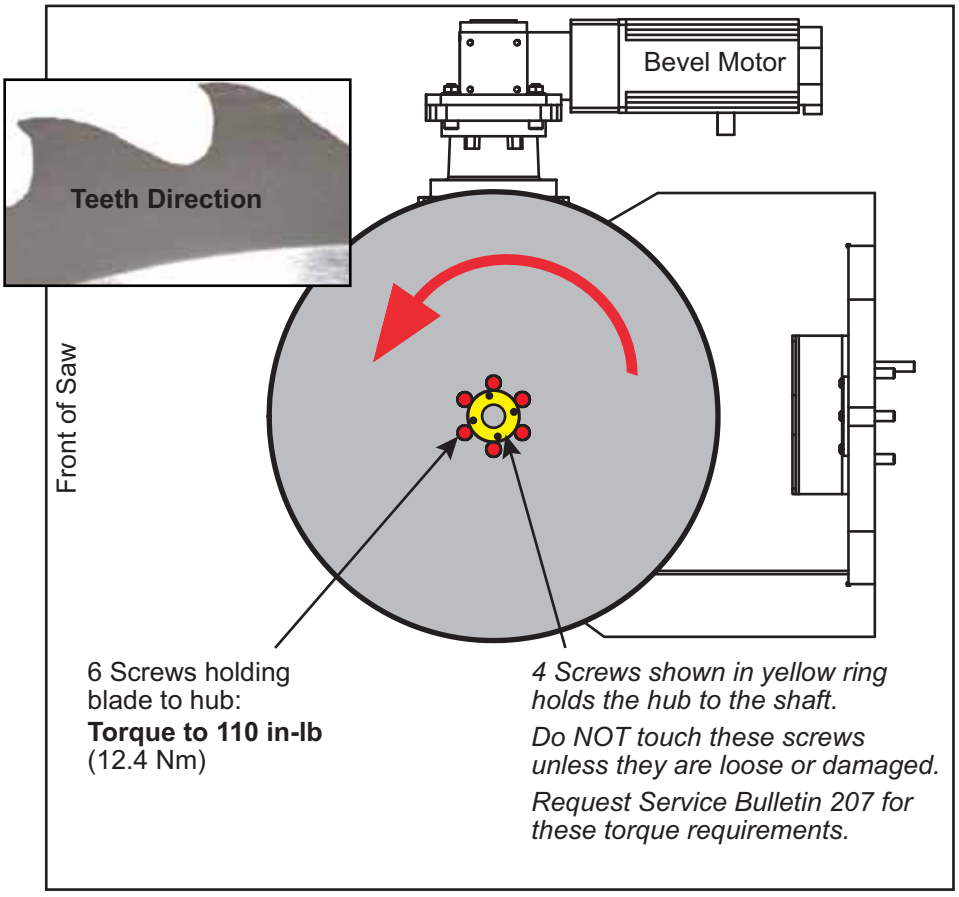
To prevent the screws from shearing off, which could result in serious injury, do **not** use thread adhesive.

6. Remove the lockout/tagout device and start the saw blade rotation to observe its motion. It should not have any wobble or vibration when rotating.

Check the saw blade weekly for the following and replace or repair when needed:

- Cracks, warping, missing or dull teeth, etc.
- Observe any wobble or vibration during rotation
- Check that the bolts holding the blade to the hub are secure.

Figure 3: Torque Specs for Saw Blade
(View from side of saw, with blade at 90 degrees.)



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