

Service Bulletin

Machinery Affected: BLADE™ Wood Processing System
Document: SB222 rev. A
Title: Replacing a Shock Absorber
Applies To: All
Distribution: Customers: Upon Order



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Applicability	All



pliers (for lock nut)
 tape measure
 small, slotted
 screwdriver

Purpose and Scope

This Service Bulletin describes how to properly install the shock absorbers. If the shock absorbers are installed incorrectly, it will result in damage to saw components.

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 SB222KIT-A, For Top Clamp

Qty.	Part Description	Part #
1	Shock absorber, top clamp (4 per saw)	447010
1	Service Bulletin document	SB222

Table 2: Parts in SB222KIT-B, For Infeed Side Clamp and Outfeed Clamp

Qty.	Part Description	Part #
1	Shock absorber, infeed side clamp or outfeed clamp	447009
1	Service Bulletin document	SB222

Before beginning the procedure, gather the supplies listed in the margin. If you have any questions, call MiTek Machinery Division Customer Service at 800-523-3380.



Procedure

Preparing the Saw

1. Move the component requiring the shock absorber, to improve accessibility:
 - For the infeed side clamp, move the gripper to Home position.
 - No positioning is required when replacing the infeed side clamp or outfeed clamp shock absorber.
2. Power down the operator interface (touch screen computer).
3. Power down the saw, turning the disconnect switch to Off.
4. Lock out and tag out the source that supplies power to the saw, following the instructions in the next section and your internal procedures.

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. If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.</p>

When Working on a Machine Outside the 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. Engage an E-stop on the machine.
2. Turn the disconnect switch handle on the machine’s main electrical enclosure to the “off” position.

	 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 enclosure!</p>

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

Pneumatic System Lockout/Tagout Procedure

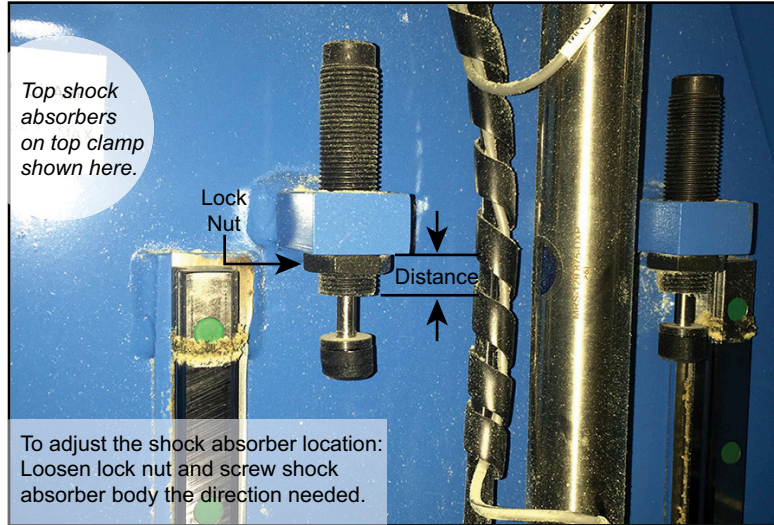
	 WARNING
	<p>MOVING PARTS CAN CRUSH AND CUT.</p> <p>Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures. Turn off the air switch before performing any maintenance on the equipment.</p>

Installing New Shock Absorber



If there is an adjustable knob on the non-collapsible end, do not turn it! It adjusts the spring tension which should NOT be changed.

Figure 1: Adjusting the Shock Absorber Location



1. Unscrew the locknut and damaged shock absorber and discard all pieces.
2. Install the new shock absorber into the bracket:
 - a) Remove the lock nut from the new shock absorber.
 - b) Place the collapsible end through the bracket, pointing the correct direction, and screw it in to the distance indicated in Table 3.
 - c) Slide the lock nut over the collapsible end and tighten against the bracket.
3. Check that the sensors on the cylinder that control “fully open” and “fully closed” are set correctly. Their location may need to be slightly adjusted.



If the shock absorber is not easy to access, manually push on the clamp mechanism to move it away from the shock absorber.

For the top clamp, open the saw chamber door and engage the clamp lever to hold the top clamp up.

Table 3: Shock Absorber Installation Properties

Location	Qty	PN	Distance	Collapsible piston points...
Top Clamp: Top (retract)	2	447010	1" from bottom surface of bracket to end of shock absorber body.	Down
Top Clamp: Bottom (extend)	2	447010	1/2" from top surface of bracket to end of shock absorber body.	Up
Infeed Side Clamp	1	447009	See Figure 2.	Toward front of saw
Outfeed Clamp	1	447009	Adjust so there is 2-1/2" between tip of lumber exit chain and camfollower surface.	Toward front of saw

Figure 2: Top View of Infeed Side Clamp Rollers

