MiTek®

SERVICE BULLETIN

Document ID:

SB262-C

Title:

Upgrading to MPERIA Printer Option C

Affected machinery: BLADE II™ Linear Saw

Distribution: Customers upon order

Applies to: BLADE II saws upgrading from printer option A to printer option C

Sensitivity: Customers should not attempt to install this service bulletin. Installation of this service bulletin by anyone other than a MiTek technician will void the machine warranty.

CAUTION:
MiTek recommends printing this document in high resolution using color ink. Many of the graphics may be unclear and may create an unsafe condition if this recommendation is not followed.

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Part # and Rev.	SB262-C
Print Date	11 June 2025
Effectivity	Frames 488-Present
Revision Date	
Revised By	
Rev. Approved By	
Orig. Release Date	28 May 2025
Orig. Created By	P. Hopper
Orig. Approved By	R. Tucker

Purpose and Scope

This service bulletin instructs how to install an MPERIA printer option C, upgrading from an option A.

Overview

Parts Included

The parts included in this kit are shown in Table 1-1 and Table 1-2. Please make sure all parts and supplies are present before starting the procedure.

Table 1-1:Parts in SB262-CKIT

Quantity	Description	Part #
2	ASSY, CAP/PICK-UP TUBE W/ FILTER, 41206373	005-00135
1	CONNECTOR- Y (KC000265)	005-00139
49	Tubing- Ink (per foot) (KC000270)	005-00144
1	Connector Insert Male CPC Fitting 41008853	005-00148
1	FTG, 1/8 BARB TEE 41009575	005-06209
1	FLOW DIVIDER BRACKET	005-06210
1	PRINT CABLE, SX32E/V84E, 7 OR 16V, 16FT	168019
1	CONTAINER BOTTLE, 1LITER WIDE MOUTH, 11000646	168161
2	C’SCW,SKTHD,10-32X5/8 (VMI)	326094
2	WSHR,FLT,10 (VMI)	365109
1	TY-Wrap	508704
3	FTG, TUBE SUPPORT 2030X4	747776
3	FTG, MALE CONNECTOR 681X4X4	747777
1	FTG, FLOW DIVIDER	747778
1	EDGE PRINTER ASSY (See Table 1-2)	89370-501
1	Service bulletin document	SB262-C

Table 1-2: Edge Printer Assembly

Quantity	Description	Part #
1	PRNT HD 8000-7, MAXI 41038236, MATTHEWS	168157
2	C’SCW,SKTHD,10-32X3/4 (VMI)	326095
4	C’SCW,SKTHD,1/4-20X1/2 (VMI)	326153
2	C’SCW,SKTHD,1/4-20X5/8 (VMI)	326155
4	C’SCW,SKTHD,1/4-20X2-1/2 (VMI)	326173

Quantity	Description	Part #
10	WSHR,LCK,1/4 TYP.M (VMI)	364034
10	WSHR,FLT,SAE,1/4 X5/8X.062,TYP.A,N (VMI)	365115
1	E-CHAIN,B15I-038-048-0 12LINKS,W/BRK'T1038-34PZ	503169
1	LIMIT,SWITCH,PLUNGER,24V OMRON D4C-1601	515951
1	EDGE PRINTER BRACKET	89323
1	PRINTER TOP BRACKET	89338
2	PRINTER MOUNT BLOCK	89339
1	E-CHAIN MOUNT EDGE PRINTER	89341

If you have any questions, call MiTek Automation Support at 1-800-523-3380.

Supplies Needed

- Aviation Snips
- Torx screwdriver
- Adjustable Wrench
- Teflon tape

Lockout/Tagout Instructions

Electrical Lockout/Tagout Procedure

The lockout/tagout instructions for the electrical systems will be referenced as necessary in this document. Service Bulletin instructions start on page 5.

	⚠ WARNING
	**ELECTROCUTION HAZARD.** **All electrical work must be performed by a qualified electrician.** **Verify that all power to the machine has been turned off and follow approved lockout/tagout safety procedures before performing any maintenance.** **If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.**

1. In the BLADE software, raise the saw blade to its highest position, ensure the stroke is pulled all the way back, and angle the saw blade so that it is horizontal.
2. Close the machine software and shut down the PC using the **Power** > **Shut down** method in Windows.

3. Engage an E-stop on the machine.
4. Turn the machine's disconnect switch to the Off position. This is usually required to open the main electrical enclosure's door.
5. 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.
6. Attach a lock and tag that meet OSHA requirements for lockout/tagout to the electrical service entry panel.
7. Open the door to the enclosure to which you need access. Using a multimeter, verify that the power is off.

Figure 1: Lockout/Tagout on the Power Source Panel

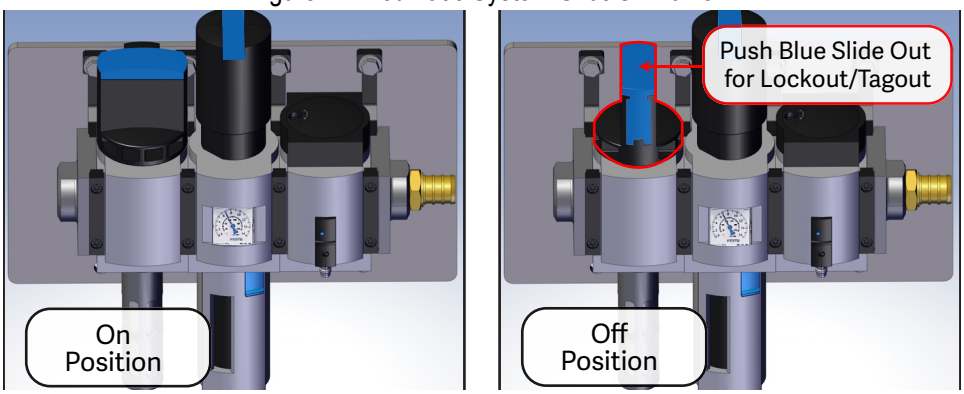
Pneumatic System Lockout/Tagout Procedure

The lockout/tagout instructions for the pneumatic system will be referenced as necessary in this service bulletin.

	⚠ WARNING
	**HIGH PRESSURE HAZARD.** **Bleed pneumatic lines before performing any maintenance on the system.** **Working on pressurized lines may cause injury.**

1. After lockout/tagout of the electrical power, turn off or close the system's air shut-off valve and attach a lock and tag. See Figure 2.

Figure 2: Pneumatic System Shut-Off Valve



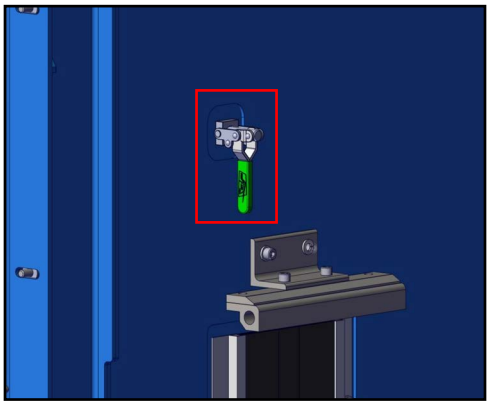
Procedure

Installing the New Printer Upgrade

	**⚠ WARNING** **MOVING PARTS CAN CRUSH AND CUT.** **Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures.**

1. Raise and lock the Top Clamp. You will need the assistance of another person:
   a) Open the saw chamber door.
      • Note that opening the door will cause the air pressure to release and the top clamp to fall if it is unclamped position.
   b) Ask another person to lift the top clamp to the unclamped (topmost) position.
   c) With the other person holding the clamp in place, engage the lever inside the saw chamber on the infeed side

Figure 3: Top Clamp

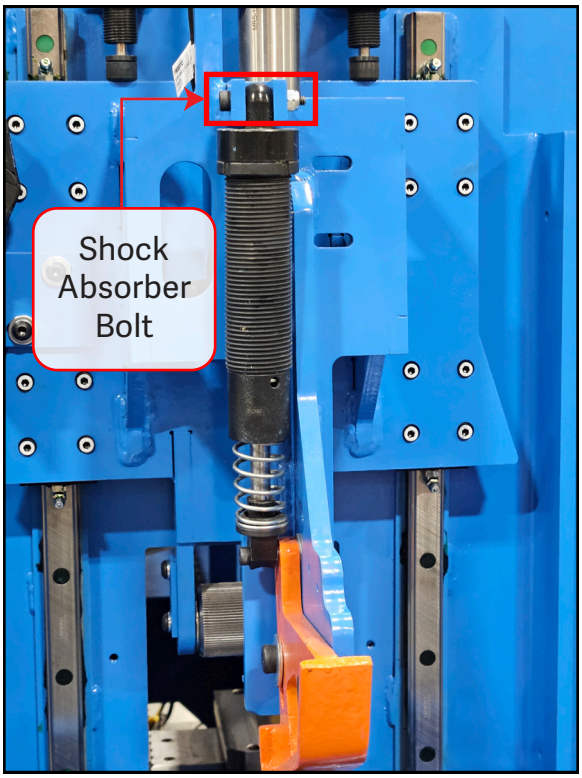


2. Lockout/tagout the electrical and pneumatic systems of the machine using the Lockout/Tagout Instructions on page 3.

Installing the Edge Print Head

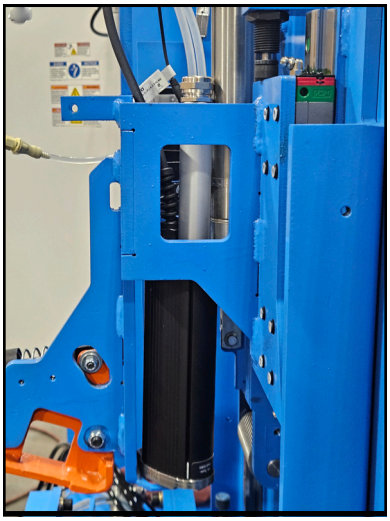
3. Use a torx screwdriver to remove the shock absorber shoulder bolt, indicated in Figure 4, and pull the shock absorber down.

Figure 4: Edge Printer Shock Absorber



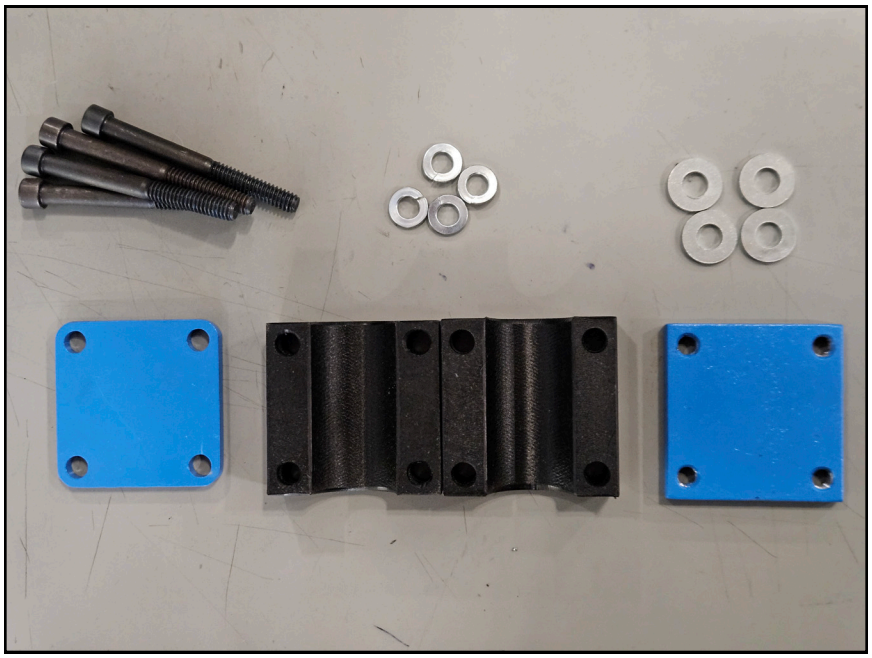
4. Insert the edge print head into edge printer mount and align it to the rear support (Figure 5).

Figure 5: Edge Printer Inserted



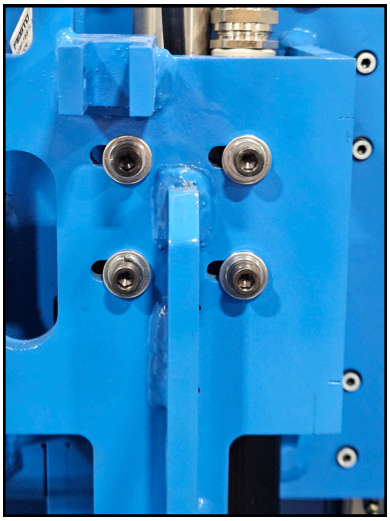
5. Attach the edge print head with the edge printer mount block.
   - Assemble the four 1/4-20X2-1/2 rear support screws with flat washers and locking washers shown in Figure 6.

Figure 6: Printer Mount Block Assembly



   - Feed the rear support screws through the machined holes in the hold down bracket (Figure 7).

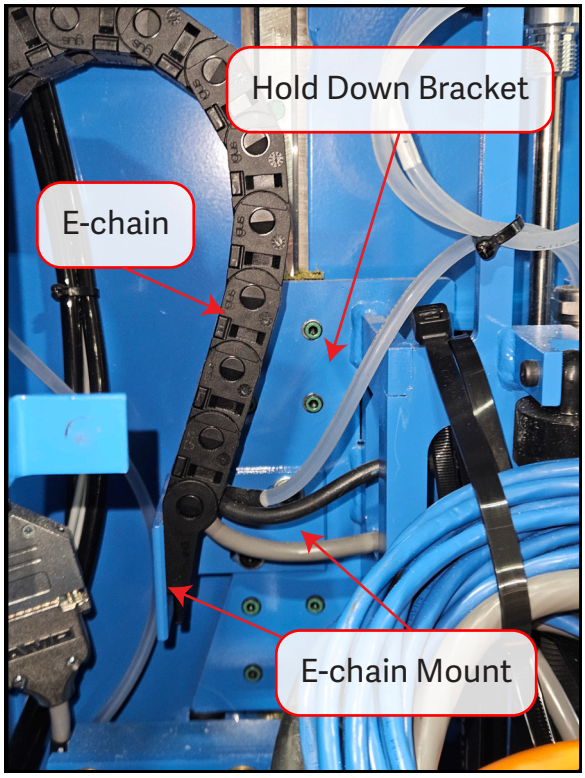
Figure 7: Rear Support with Assembled Bolts Inserted



- Fit the printer top bracket (no threads) on the inside of the hold down bracket using the exposed screws.
- Place the two printer mount blocks around the edge print head and hold them in place with the exposed screws.
- Lastly, place the edge printer bracket (threaded) at the back of the printer mount block assembly and tighten the assembled screws into the blocks until the print head is flush with the support.

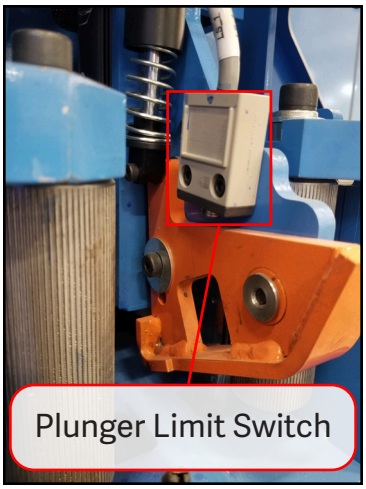
6. Return the shock absorber to its upright position and reinsert the bolt.
7. Attach the E-Chain mount to the hold down bracket using two of the 1/4-20X5/8 screws with 1/4 flat washers and locking washers (See Figure 8).

Figure 8: E-Chain Mounted to Hold Down Bracket



8. Snap the E-Chain to the e-chain mount, then attach it to the hold down bracket using the four 1/4-20X1/2 screws with 1/4 flat washers and locking washers (See Figure 8).
9. Mount the plunger limit switch to the lumber ski weldment using the two 10-32X3/4 screws (Figure 9).

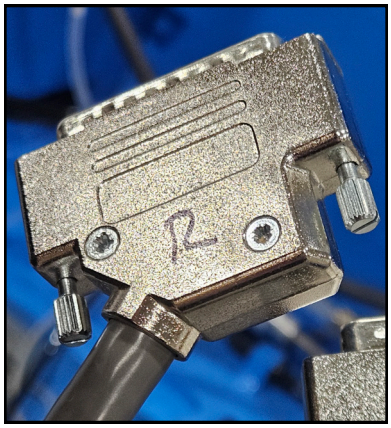
Figure 9: Plunger Limit Switch Mounted to Lumber Ski Weldment



Running the Cable and Ink Lines

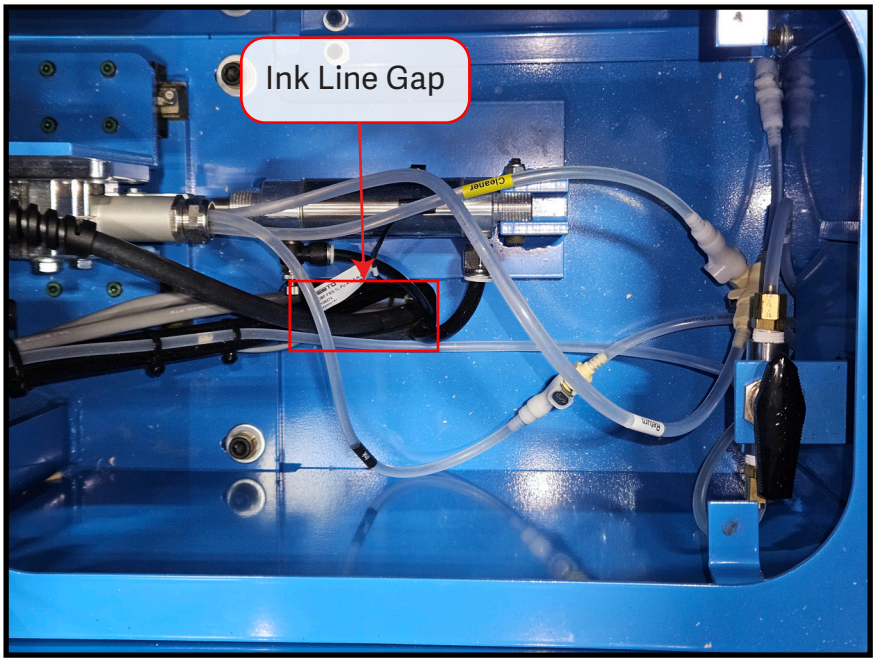
10. Arrange the printer cable so that the angled cable connector (Figure 10) can be fed through the saw chamber using the built-in trough.

Figure 10: Angled Cable Connector



11. Feed the ink lines and printer cable into the saw chamber cable trough through a hole in the print enclosure (See Figure 11).

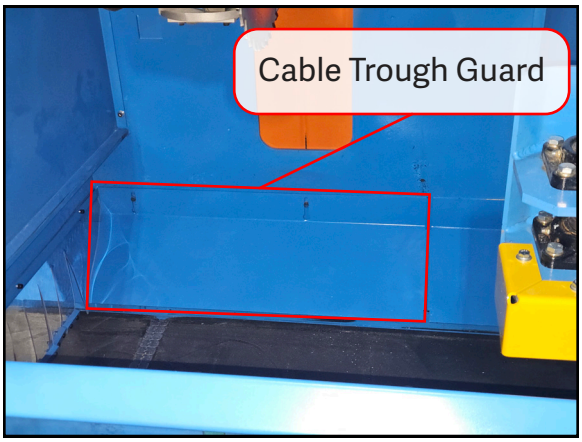
Figure 11: Printer Ink Line Gap



	⚠ CAUTION
	**CUT HAZARD.** **Saw blades are sharp. Wear arm protection, cut resistant gloves, and eye protection when stepping into the saw chamber.**

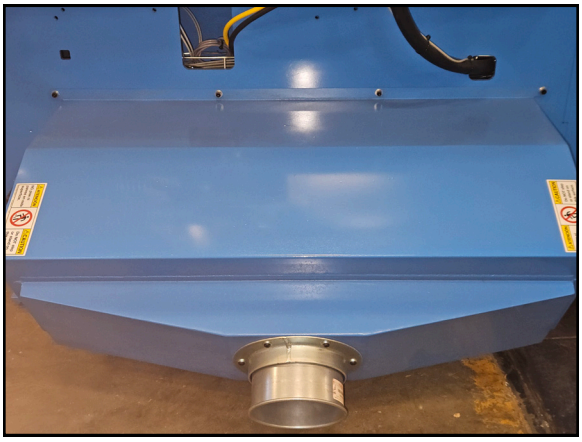
12. Remove the two cable trough guards (Figure 12) by lifting them up to access the cable trough inside the saw chamber.

Figure 12: Cable Trough Guards



13. Feed the cable and lines through the cable trough until they reach the other side.
14. Remove the dust hood (Figure 13).

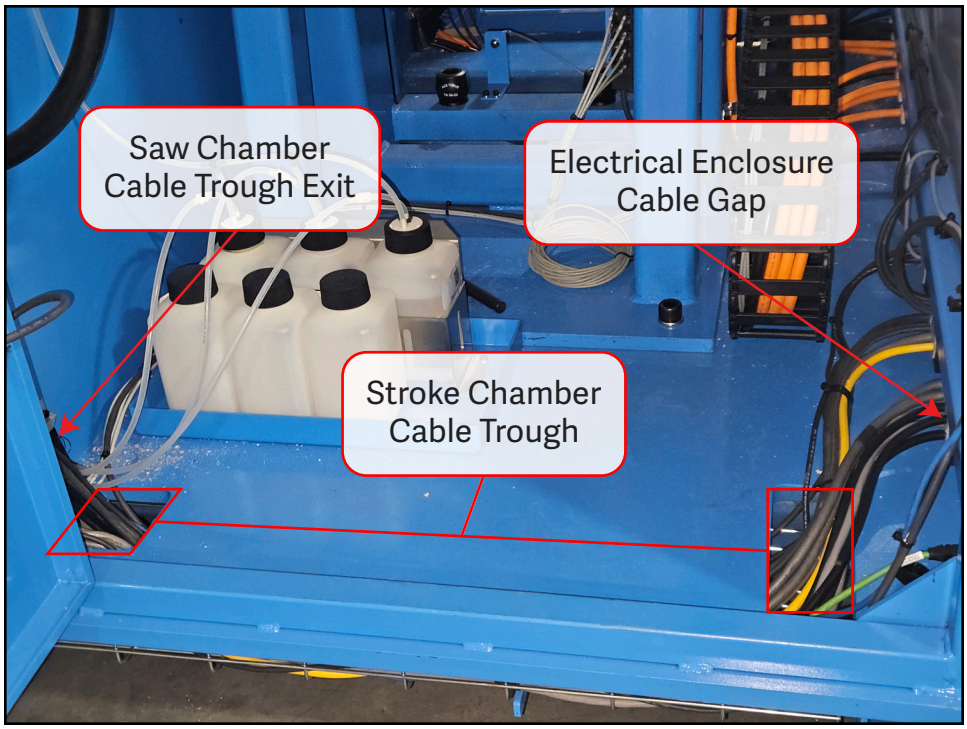
Figure 13: Dust Hood



15. Where the dust hood was removed, on the right edge of the frame, feed the cables and lines into the stroke chamber through the gap in the panel.
16. Open the saw stroke chamber.

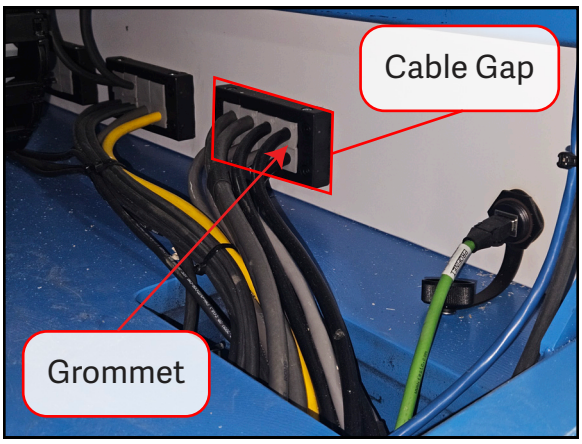
17. Feed the printer cable through the stroke chamber cable trough shown in Figure 14 to the electrical enclosure cable gap.

Figure 14: Stroke Chamber Floor



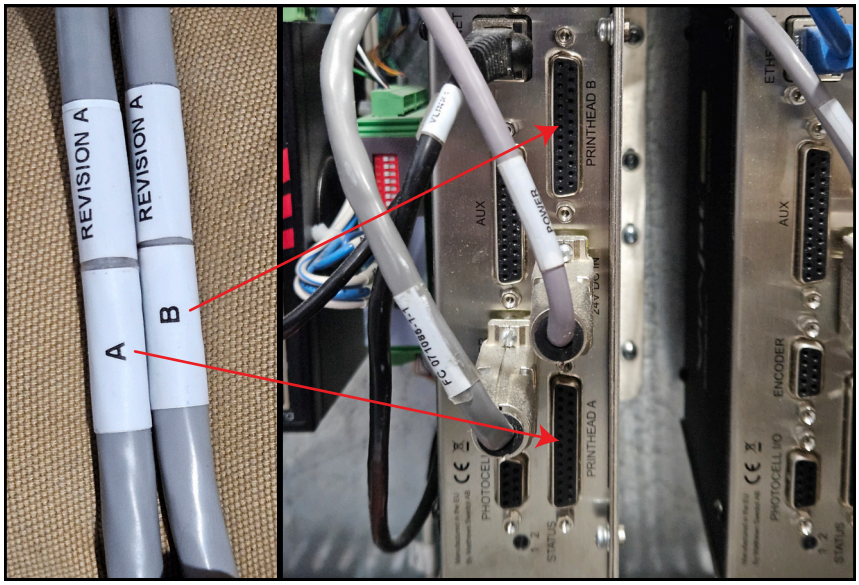
18. Feed the cable into the electrical cabinet by replacing grommets in the first gap with the supplied cable grommets (Figure 15).

Figure 15: Electrical Enclosure Cable Gap



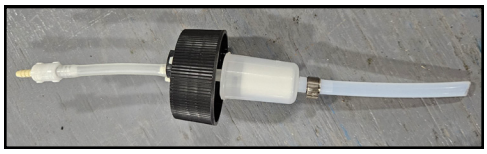
19. Plug the cable into the remaining V-Link port (printhead B), tightening the screws to be snug, but not too tight (See Figure 16).
    - The V-Link port labeled ‘printhead A’ should already be taken up by the front print head.

Figure 16: Printer Cable Connection to V-Link



20. Insert the supplied ink bottle into the bottle holder located in the saw's stroke chamber.
21. Insert the filter assembly into the new ink bottle (See Figure 17).

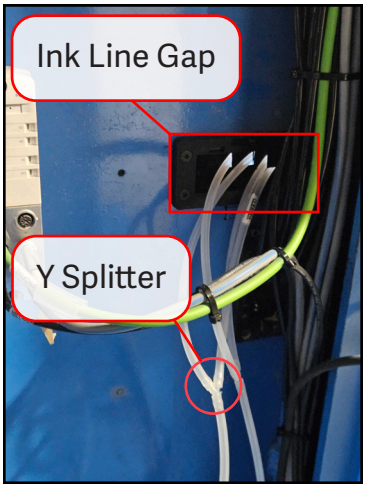
Figure 17: Ink Bottle Filter Assembly



22. Run the ink line, through ink line gap in the printer, to the ink valve. Cut excess line as needed using a pair of snips.

23. Split the cleaner line.
    a) Using a pair of snips, cut the cleaner line near the print ink line gap located in the print enclosure (Figure 11).
    b) Attach the upstream side of the cleaner line to the bottom of the supplied Y connector, and the downstream side to one of the split ends (Figure 18).

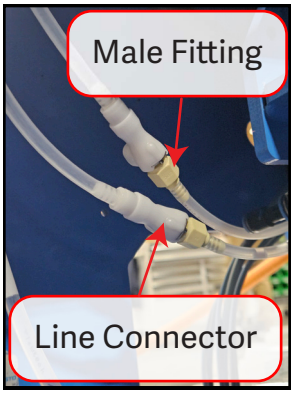
Figure 18: Cleaner Lines Attached to Y Connector at Ink Line Gap



    c) Attach one of the supplied spare ink lines to the remaining split end. See Figure 18..

24. Snip the ink and cleaner lines to length at each print head so that there is little slack and no kinks.
25. Connect the cut lines to the print heads (Figure 19).
    - Attach the supplied male connector fittings to the ends of all lines.
    - Remove the caps from inside the ink and cleaner line connectors.
    - Connect all lines by attaching the line connectors with the male connector fittings.

Figure 19: Lines Connected with Male Connector Fittings



26. Attach the ink and cleaner valve to the printer enclosure.
    - Assemble the ink and cleaner valve by attaching each of the three fittings with Teflon tape (Figure 20).

Figure 20: Ink and Cleaner Valve Assembled

    - Remove the valve handle from the valve body by unscrewing the set screw.
    - Insert the valve body up into the valve bracket and attach it by screwing the valve handle back on (Figure 21).

Figure 21: Ink and Cleaner Valve Secured

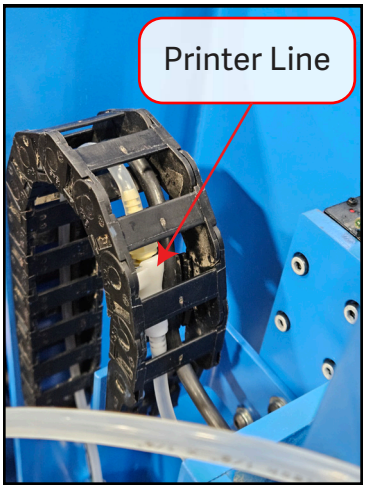
27. Snip the ink and cleaner lines to length at the valve.

28. Insert the supplied bronze tube support (shown in Figure 22) into each of the valve ends.

Figure 22: Bronze Tube Support for Valve Ends

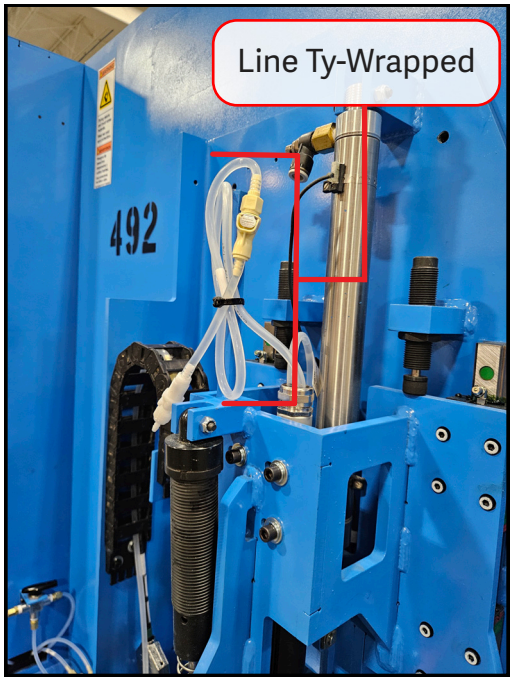
29. Seat the ink line into the left valve head, and the cleaner line into the right valve head. Then tighten the locking nuts.
30. Run the edge printer line through the flexible track (Figure 23) and connect it to the print head as you did for step 25.

Figure 23: Edge Printer Line Connect to Flexible Track



31. Ty-wrap the edge printer line to the top clamp assembly near the shock absorber to prevent it from being pinched during operation (Figure 24).
    - Note how the printer line is kept neat and high. This prevents slack in the line that can get caught during operation.

Figure 24: Edge Printer Line Ty-Wrapped



32. Insert a board of lumber into the saw chamber to measure the distance to the front and rear print heads.
    - Leave approximately a 1/2” gap between the print head and the board.
33. Reaffix the cable trough guards inside the saw chamber.
34. Remove lockout/tagout devices.
35. Release the Top Clamp.

Reconfiguring the MPERIA Printer Setup

To reconfigure the MPERIA printer setup once the assembly upgrade is completed, refer to P0378 - MPERIA Print Option C Blade II on the MiTek SharePoint website.

Test For Errors

Test the machine to ensure it operates smoothly, with no damage or printing errors occurring.