MiTek®
SERVICE BULLETIN

Document ID:
SB309

Title:
Replacing the Saw Blades

Affected machinery: Floor Web Saw
Distribution: Customers upon order
Sensitivity: Approved for customer use

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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Purpose and Scope

This service bulletin instructs how to replace the four angled saw blades and the one cut-off saw blade used in the Floor Web Saw.

Overview

Parts Included

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

Table 1: Parts in SB309KIT

Quantity	Description	Part #
5	Saw blade 16"	811040
45	Bolts	325209
1	Service bulletin document	SB309

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

Supplies Needed

- Torque wrench fitted with a hex bit capable of 20 ft-lb
- Gloves for handling the saw blades

Lockout/Tagout Instructions

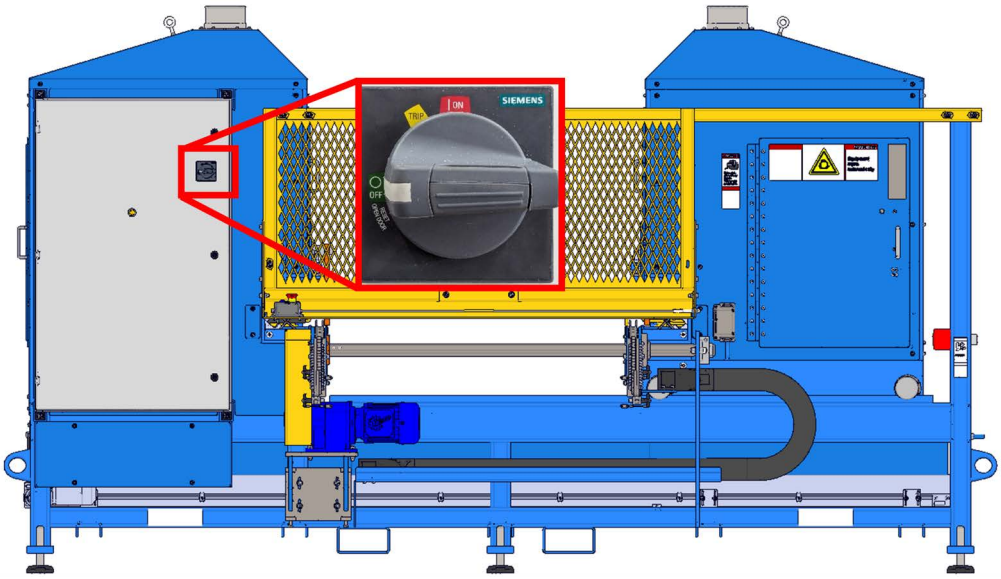
Electrical Lockout/Tagout Procedure

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.** **When the disconnect switch is off, there is still live power within the disconnect switch's enclosure. Always turn off the power at the building's power source to the equipment before opening this electrical enclosure.**

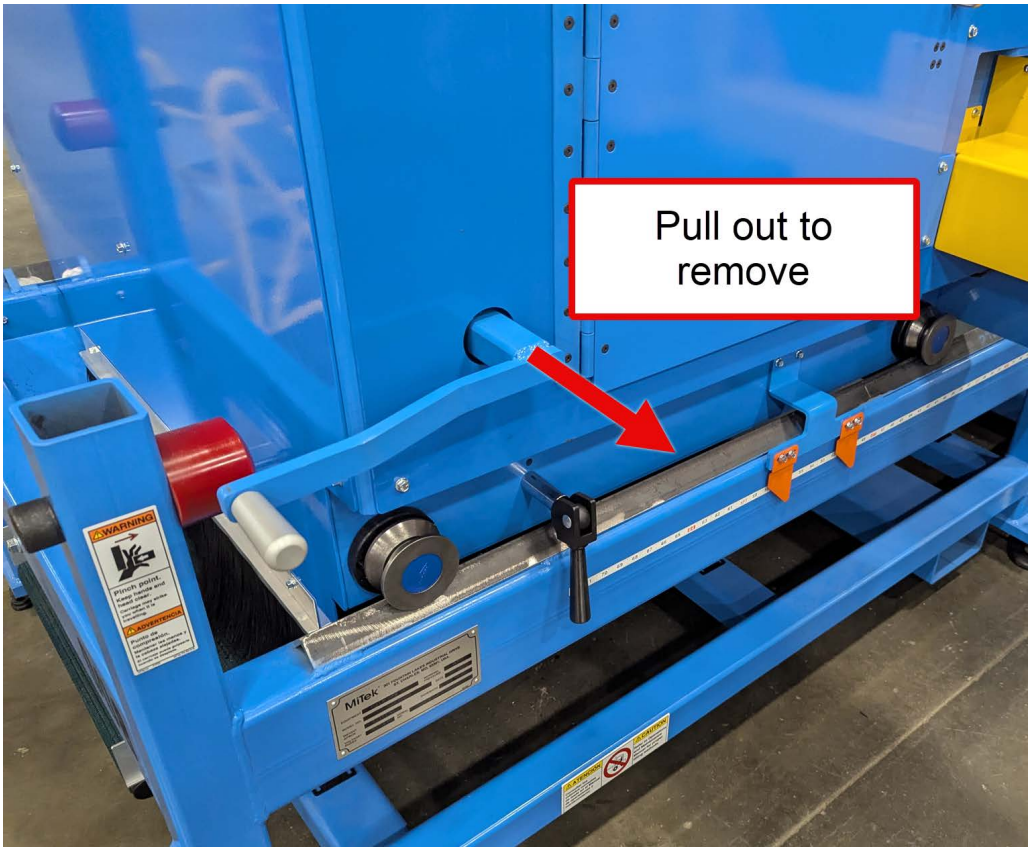
1. Engage an E-stop on the machine.
2. Turn the disconnect switch handle to the Off position (Figure 1).

Figure 1: Disconnect Switch



3. Open the door to the enclosure and use a multimeter to verify that the power is off.
4. Close the enclosure door and attach a lock and tag that meet OSHA requirements for lockout/tagout.
5. Remove the hand crank from the carriage cabinet.

Figure 2: Hand Crank



6. Attach a lock and tag to the hand crank that meets OSHA requirements for lockout/tagout.

Procedure

Recommended Minimum Schedule for Replacing Blades

The frequency of blade changes and repairs depends on the amount of use and the species and grade of lumber that is cut. Certain blades will wear faster than others because of their location relative to the incoming lumber.

Table 2: Recommended Blade Replacement Schedule

	One Shift	Two Shifts
Angled Saw Blades	Every month	Every two (2) weeks
Cut-off Saw Blade	Every two (2) months	Every month

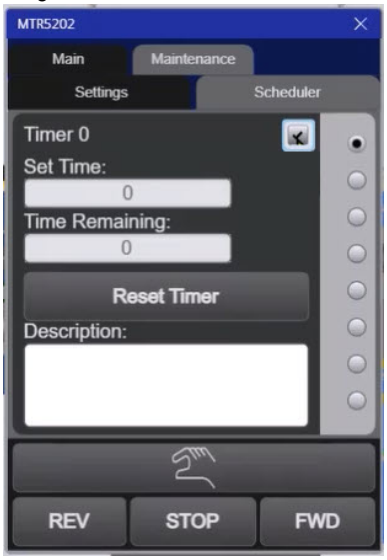
Your plant may need to change the blades more often for optimum saw operation.

Every shift the operator should perform the following tasks to check the saw blade for signs of wear and replace or repair accordingly:

- Check the blade diameter.
- The saw blade must be removed and discarded if it's less than 16".
- Check for cracks, warping, missing or dull teeth, etc.
- Check that the bolts holding the blade to the hub are secure.

In the scheduler tab of the motor faceplate, you can set alarms to alert you when it is time to replace the saw blade.

Figure 3: Scheduler Tab on Motor Faceplate



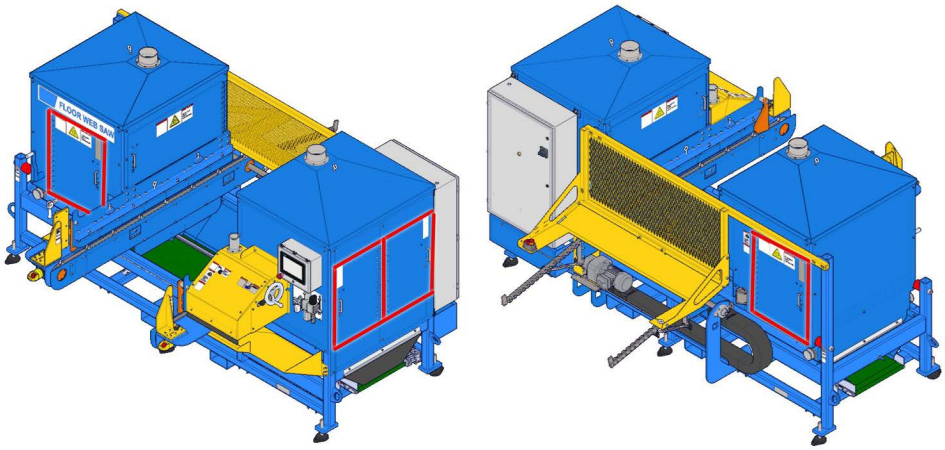
Wax Coating

Some blades have a wax coating over the teeth to make them easier to handle and to protect the teeth from breakage during shipping. Remove this coating after installing the new blade.

Removing the Angled Saw Blade

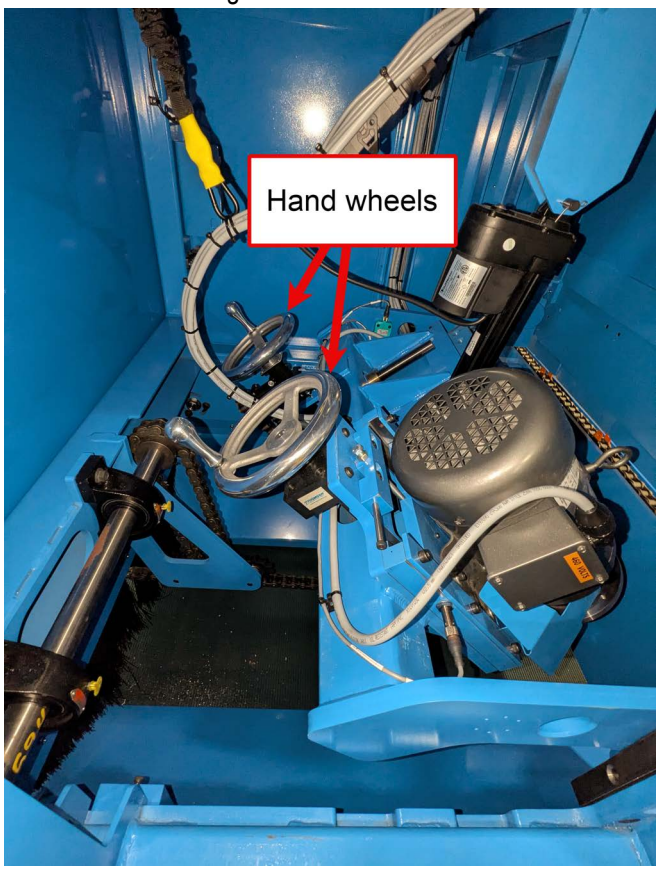
1. Open the access doors to the cutting cabinet to change the angled saw blades.

Figure 4: Saw Access Doors



2. Lockout/tagout the hand crank and the electrical system of the machine using the Lockout/Tagout Instructions on page 3.
3. Turn the hand wheel of the saw blade being replaced counterclockwise to move it as far back (closest to the access doors) as possible.

Figure 5: Hand Wheels



4. Use a hex wrench to remove the three bolts that attach the blade to the hub. **Discard** the old bolts.
5. Remove the blade.

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

6. Blow off dust from the hub and the bolt threads. Remove all pitch and debris from threads.
7. Wipe down the mounting surface on the new saw blade and the hub. Use a 320-grit emery cloth, if necessary, to remove pitch.
8. Ensure all parts are clean, dry, and free of lubricants.

Installing the Four Angled Saw Blades

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", discard it.

1. Install a new saw blade. Ensure the teeth are facing the correct direction.

Figure 6: Stationary Cabinet Saw Blades and Cut-off Saw Blades

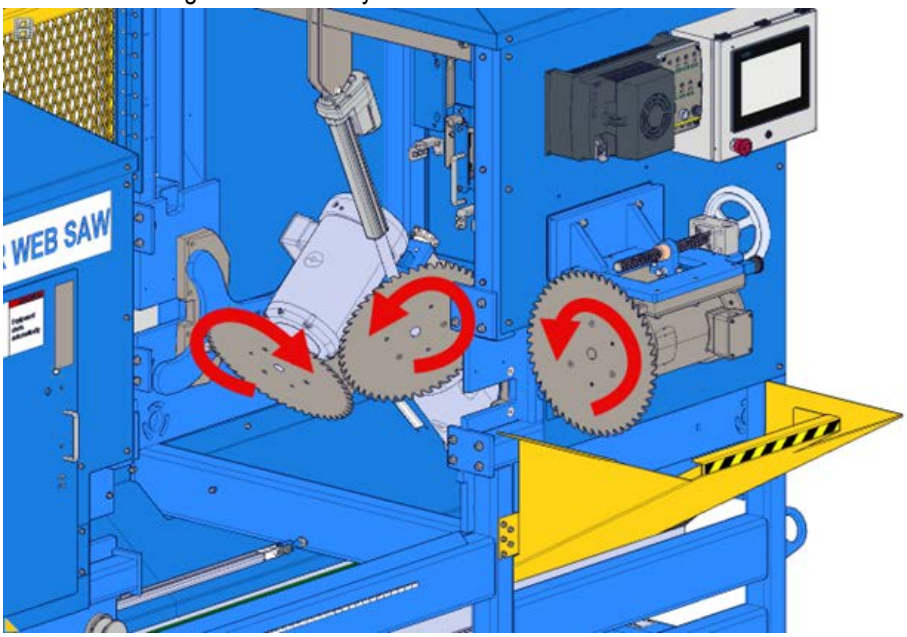
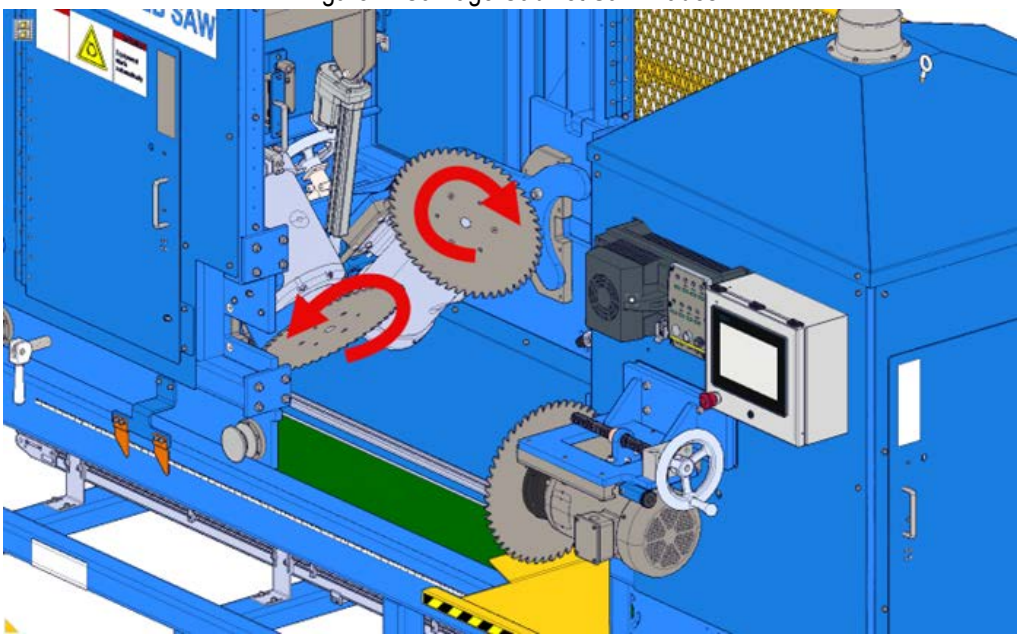


Figure 7: Carriage Cabinet Saw Blades



2. Using the supplied bolts, replace the bolts. Use a torque wrench fitted with a hex bit to torque the bolts to 20 ft-lb.
3. Turn the hand wheel to return the saw blade to its prior position.
4. Close the access door.

Replacing the Cut-Off Saw Blade

	⚠ 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. Lockout/tagout the hand crank and the electrical system of the machine using the Lockout/Tagout Instructions on page 3.
2. Turn the hand wheel counter clock-wise to move the saw blade as close to the back as possible.
3. Remove the bolts located indicated in Figure 8.

Figure 8: Bolts to Remove Cut-off Saw Housing

4. With the wheel and all bolts removed, pull the yellow housing away from the machine to access the saw blade.
5. Use a hex wrench to remove the three bolts that attach the blade to the hub. **Discard** the old bolts.
6. Remove the blade.
7. Blow off dust from the hub and the bolt threads. Remove all pitch and debris from threads.
8. Wipe down the mounting surface on the new saw blade and the hub. Use a 320-grit emery cloth, if necessary, to remove pitch.
9. Ensure all parts are clean, dry, and free of lubricants.

Installing the Cut-Off Saw Blade

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", discard it.

1. Install a new blade. Ensure the teeth are facing the correct direction, refer to Figure 6.
2. Using the supplied bolts, replace the bolts. Use a torque wrench fitted with a hex bit to torque the bolts to 20 ft-lb.
3. Replace the cut-off saw housing.
4. Use the hand wheel to move the saw blade back into position.

5. Remove lockout/tagout devices and test one board. You may need to recalibrate your machine.

Specs for Sharpening the Saw Blade

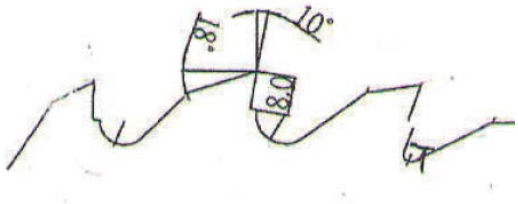
Saw blades can be sharpened to significantly extend their life. They must be sharpened by a reputable blade sharpener that is familiar with carbide tips. It is important to meet the specifications etched into each saw blade. If any specification is not met, it can cause the saw blade to cut inefficiently, inaccurately, and/or rotate out of balance. The specifications are further defined in Table 3.

Table 3: Saw Blade Specifications

Spec Description	Dimension
Tip-to-tip diameter	16"
Kerf (blade thickness)	0.202"
Z= qty of teeth	50
Ø = diameter of center hole	1 1/8"
SK = keyways	0º
Hook	10º
Face angle	0º
Top angle	15º
Angle left-to-right (or right-to-left) of ATB*	0º
RPM max	4300 rpm
Model # of saw blade	as shown on saw blade
ATB	indicates an alternating top bevel
Serial # of saw blade	as shown on saw blade

* ATB = Alternating Top Bevel

Figure 9: Saw Blade Tips Diagram



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