MiTek®

SERVICE BULLETIN

Document ID:

SB314

Title:

Gripper Clamp Retrofit

Affected machinery: BLADE II™ saw
Distribution: Customers upon order
Applies to: All machines with legacy gripper clamp hardware
Sensitivity: Approved for customer use

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Orig. Created By	A. McIntire
Orig. Approved By	R. Tucker

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 retrofit updated gripper clamps in the *BLADE II* saw. These new clamps have been redesigned to more reliably guide boards into the gripper.

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 SB314KIT

Quantity	Description	Part #
1	Gripper clamp point	76035
1	Gripper clamp point (mirrored)	76036
1	Service bulletin document	SB314

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

Supplies Needed

- Socket wrench and ¼-20 bit

Lockout/Tagout Instructions

Electrical Lockout/Tagout Procedure

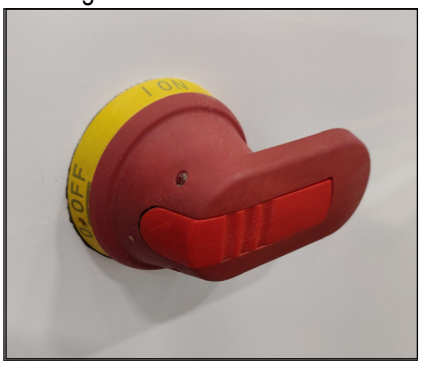
The lockout/tagout instructions for the electrical systems will be referenced as necessary in this document. Service Bulletin instructions start on page 4.

Working on a Machine Outside the Machine's Main Electrical Enclosure

	⚠ 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. If applicable, close machine software and shut down the PC using the **Power** > **Shut down** method in Windows.
2. Engage an E-stop on the machine.
3. Turn the disconnect switch handle to the Off position (Figure 1). This is usually required to open the main electrical enclosure's door.
4. Open the door to the enclosure and use a multimeter to verify that the power is off.
5. Close the enclosure door and attach a lock and tag that meet OSHA requirements for lockout/tagout.

Figure 1: Disconnect Switch



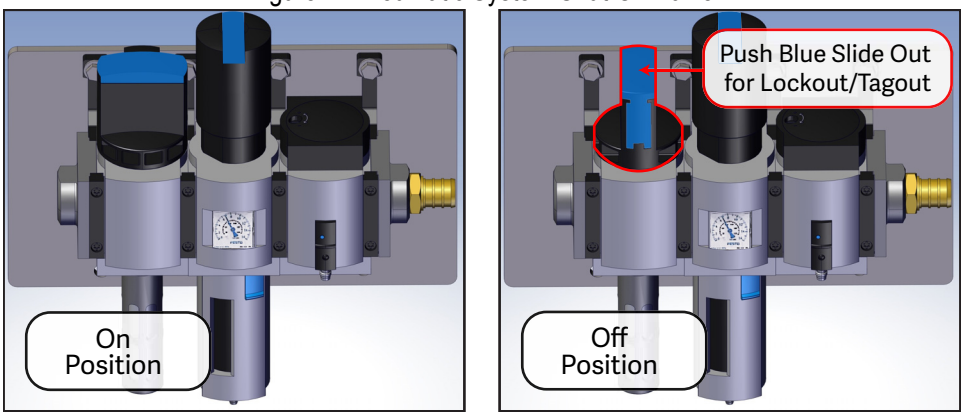
Pneumatic or Hydraulic System Lockout/Tagout Procedure

The lockout/tagout instructions for the pneumatic or hydraulic systems 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.**

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

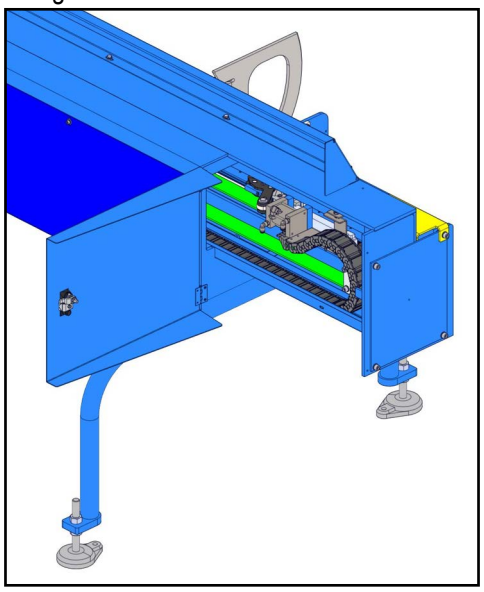
Removing and Replacing Gripper Clamps

	⚠ 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. Use machine software to move the gripper to max position (away from the saw chamber).
1. Lockout/tagout the electrical and pneumatic systems of the machine using the Lockout/Tagout Instructions on page 3.

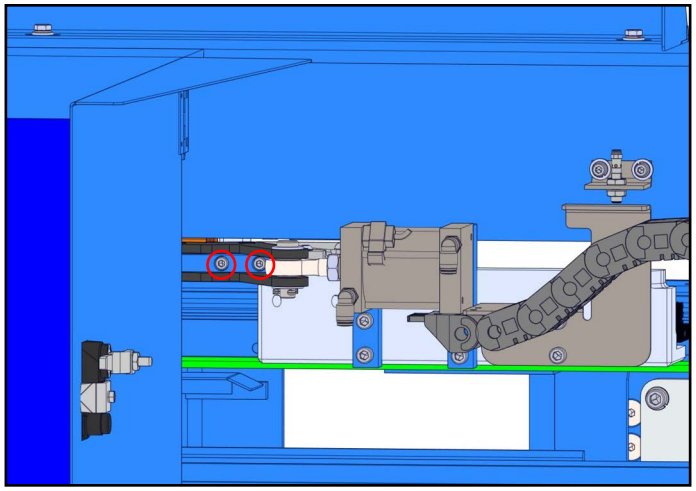
2. With power locked out as previously described, open the maintenance door on the far end of the infeed rail (Figure 3).

Figure 3: Infeed Rail Maintenance Door



3. Remove 2 screws (¼-20) and release clamp arm locator to access the powered gripper clamp. Set aside screws for reuse.

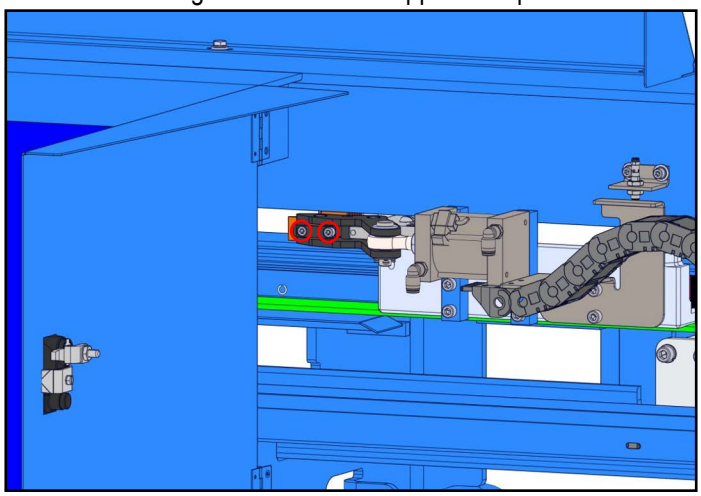
Figure 4: Clamp Arm Location



	NOTICE
	The orientation of the gripper clamps varies between Standard Load (SL) or Rear Load (RL) BLADE II saw builds. The graphics in this document depict a SL setup. The location of the powered and stationary gripper clamps are flipped in a RL setup.

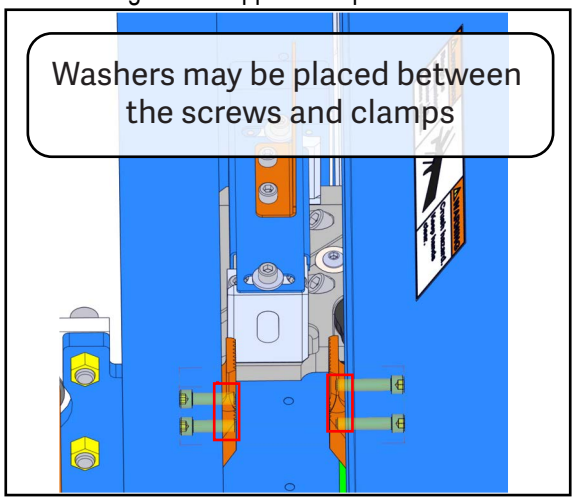
4. Remove 2 screws (¼-20) to remove the powered gripper clamp on the rear side of the infeed rail. Set aside screws and washers (if present) for reuse (Figure 5).

Figure 5: Powered Gripper Clamp



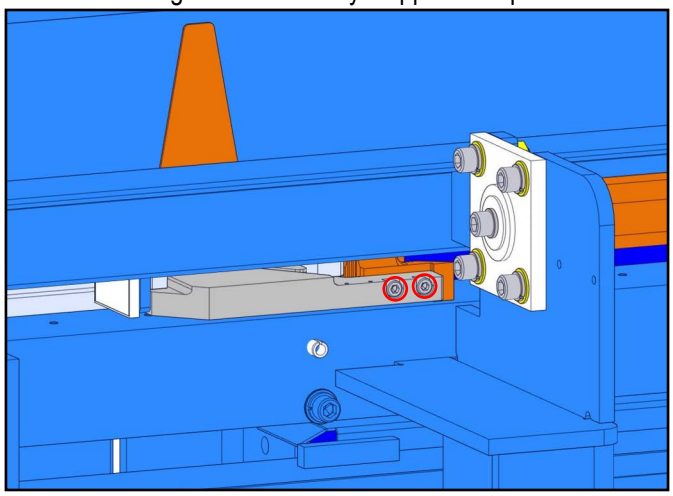
	NOTICE
	In some machine builds, there may be washers placed between the gripper clamp (stationary or powered) and the far side of the screw (see Figure 6). The washers add extra space to prevent potential contact between the top of the clamp and the frame of the infeed rail. **MiTek recommends first installing the new clamps without the washers. A test at the end of this procedure will determine if the washers may be necessary.**

Figure 6: Gripper Clamp Washers



5. Remove 2 screws (¼-20) and release the stationary gripper clamp on the front side of the infeed rail. Set aside screws and washers (if present) for reuse (Figure 7).

Figure 7: Stationary Gripper Clamp



6. Reverse steps 5, 4, and 3 to install the new gripper clamps.
7. Close the maintenance door.
8. Remove lockout/tagout devices and power on the machine.
   - If your machine build included gripper clamp washers, manually jog the gripper to the min and max positions to check for any contact between the clamps and the infeed rail. If contact occurs, reinstall the washers as necessary.

END OF SERVICE BULLETIN