
MiTek[®]

SERVICE BULLETIN

Document ID:

SB317

Title:

Replacing the LASM Bearings

Affected machinery: BLADE II™ 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.

MiTek Automation
Phone: 800-523-3380
Fax: 636-328-9218
www.mitek-us.com

Copyright © 2026 MiTek[®]. All rights reserved.

Part # and Rev.	SB317
Print Date	9 July 2026
Effectivity	All BLADE II saws
Revision Date	
Revised By	
Rev. Approved By	
Orig. Release Date	9 July 2026
Orig. Created By	P. Hopper
Orig. Approved By	R. Tucker

Purpose and Scope

This service bulletin instructs how to replace the LASM bearings used in the BLADE II 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 SB317KIT

Quantity	Description	Part #
2	O-RING BUNA, 5mm OD, 3mm ID, MCM 9262K441	416092
2	CARRIAGE BEARNG BLADE II R162281220, LASM RAIL	416099
1	Service bulletin document	SB317

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



Supplies Needed

4mm hex key

Hammer

5/32" flat tip pin punch

3/16" flat tip pin punch

Mobilux™ EP 2

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](#).

	 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. If access to the electrical enclosure is required, turn off the power at the building's power source to the equipment before opening the 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



Procedure

Replacing the Bearings

1. Before powering off the machine, open the saw chamber door.

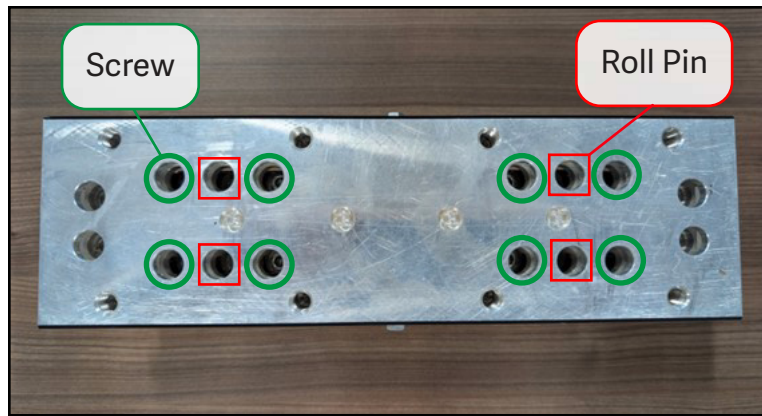


	 WARNING
	MOVING PARTS CAN CRUSH AND CUT. Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures.

2. Lockout/tagout the electrical and pneumatic systems of the machine using the [Lockout/Tagout Instructions on page 3](#).
3. With power locked out as previously described, remove the LASM rail from the machine.
 - The steps for this procedure can be found in the BLADE II saw machine manual in the following section: **Machine Maintenance > Component Replacement > LASM Rail Replacement > LASM Rail Removal**.
4. Once removed, disassemble the LASM, then clean the LASM carriage. Inspect all parts for wear and damage, replacing any as necessary.

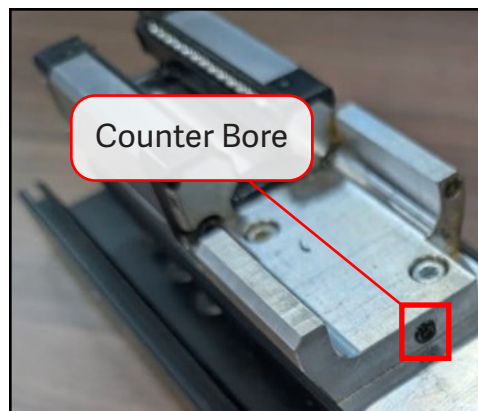
5. Remove the eight bearing block screws (indicated by green circles) from the LASM carriage with a 4 mm hex key. See [Figure 2](#).

Figure 2: Bearing Block Screws and Roll Pins



6. Knock each bearing block free by firmly tapping a 5/32" flat tip pin punch inserted into one of the bearing screw holes.
7. Remove the four roll pins (indicated by red squares) with the 5/32" punch and hammer ([Figure 2](#)).
 - Keep the existing o-rings as spares.
8. Clean the LASM carriage completely.
9. Place a new o-ring in the o-ring counter bore. See [Figure 3](#).
 - *Note: Use a small amount of fresh grease on the o-ring to help hold it in place.*

Figure 3: O-Ring Counter Bore



10. Hold the new bearing in place with the open end toward the center of the carriage so that the grease passages are aligned. Then run the screws down until they touch, but the bearing is still slightly free.
 - Do not remove the plastic bearing retainer. This will be done on Step [15](#).

11. Place a roll pin in a carriage roll pin hole and drive it with a 3/16" flat tip pin punch and hammer through the carriage and firmly into the bearing block. Repeat for the second roll pin. See [Figure 2](#).
12. Tighten the bearing retaining screws.
13. Repeat Steps [9-12](#) for the remaining o-ring, bearing, and roll pins.
14. Clean the LASM rail and all components.
15. Remove the plastic bearing retainers and reinstall the LASM carriage.
16. Install the pulley rail ends with the idler pulley, then reinstall the belt. Loosen the idler pulley if necessary.
17. Tension the LASM tension belt per the instructions found in the BLADE II saw equipment manual in the following section: **Machine Maintenance > Select Component Overview and Maintenance > LASM Assembly > LASM Belt Tensioning**.
18. Install LASM end caps, stainless steel strip, dust caps and strip hold downs per the instructions found in the BLADE II saw equipment manual in the following section: **Machine Maintenance > Select Component Overview and Maintenance > LASM Assembly > Cleaning the LASM Linear Rail (with Air holes on End Caps)**.
19. Install the LASM rail per the instructions found in the **LASM Rail Installation** section of the BLADE II saw equipment manual.
20. Grease the bearings by following the instructions found in the following section of the BLADE II saw equipment manual: **Machine Maintenance > Bearings (Lubrication) > LASM Linear Module**.
21. Remove lockout/tagout devices and test the LASM by moving it to the minimum and maximum positions to ensure it moves back and forth smoothly.

END OF SERVICE BULLETIN