

Service Bulletin

Machinery Affected: MatchPoint BLADE™ wood processing system
Document: SB225
Title: Installing Waste Deflectors
Distribution: Customers Upon Order



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Part # and Rev.	SB225
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Revised By	
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Applicability	Prior to 89100-501k
Effectivity	Frames 1–140



Purpose and Scope

With the addition of the waste deflector kit, the waste conveyor on the *BLADE* saw will knock waste on its side. This kit will reduce jams as boards exit the waste conveyor.

Overview

First, remove the obsolete wedge tip skirt and dust flaps. Second, install the waste deflector, mesh guard, and waste deflector guard.

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 SB225KIT

Qty.	Part Description	Part #
1	Waste deflector guard	89684-501
1	Waste deflectors with bracket	89686-501
1	Mesh guard	89774
9	1/4" Lock washers	364034
9	1/4"-20x5/8" Socket-head cap screws	326155
3	1/4" Flat washers	365115

Before beginning the procedure, gather the supplies listed here.

- Allen wrenches
- Ruler

If you have any questions, call MiTek Machinery Division Customer Service at 800-523-3380.



Procedure

Preparing the Saw

1. Make sure that the saw blade is positioned in its default Home position at 90 degrees (parallel to the infeed chamber wall) with the elevation at its highest point.
2. Make sure that the LASM jaws are moved as far to the outfeed side as possible. This will provide room to move in the saw chamber.



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.</p> <p>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 Machine’s 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.

- 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 electrical enclosure!</p>

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

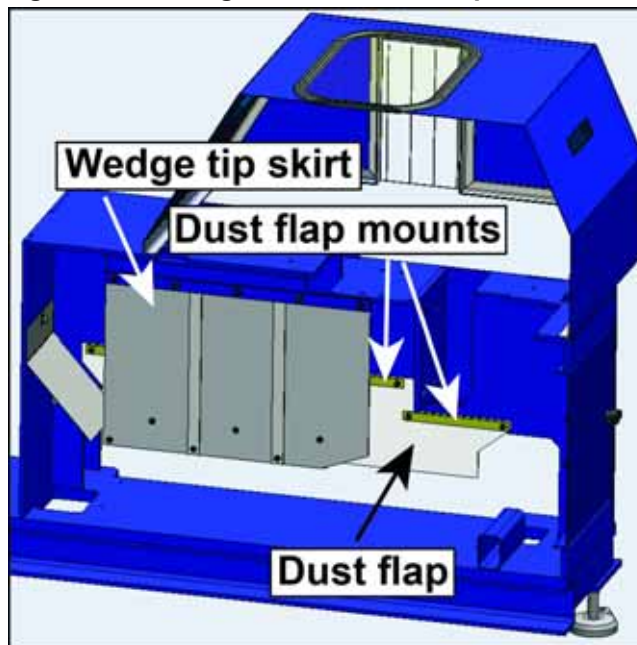
Removing Obsolete Parts



The waste conveyor on the *BLADE* saw moves scrap wood toward either the infeed side or the outfeed side. The obsolete parts described in the removal process are configured identically on the infeed and outfeed sides.

1. Before climbing into the saw chamber, perform the following steps to remove two screws.
 - a) Open the small front door on the outfeed side. It is located under the saw chamber door.
 - b) Locate the clear plastic dust flap and the small dust flap mount that attaches it to the frame. See Figure 1 for the location of the dust flap and its mounts.

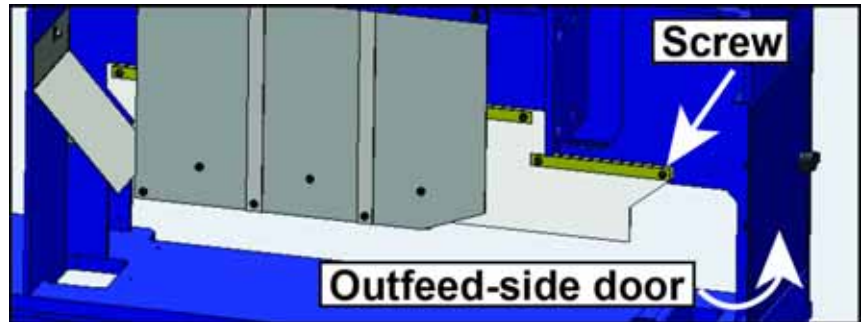
Figure 1: Locating the Small Dust Flap Mount



Cutaway view from the infeed side looking toward the outfeed side. Some parts removed for clarity.

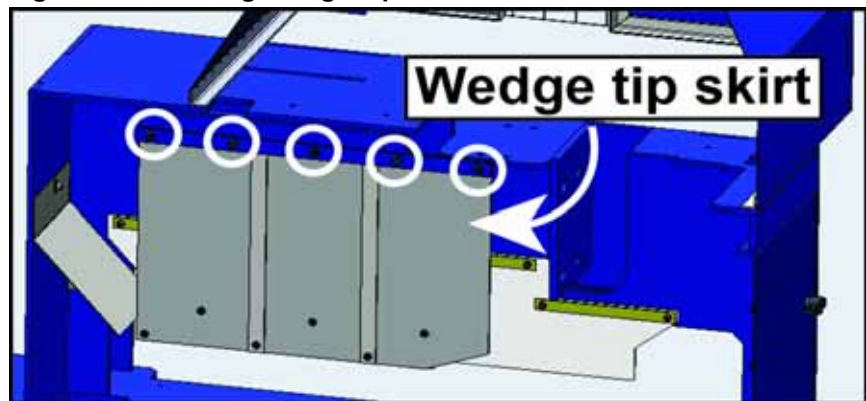
- c) Remove the small dust flap mount screw closest to the door. See Figure 2. Leave the other screws for now.

Figure 2: Removing Screw from Small Dust Flap Mount



- d) Close the front door on the outfeed side.
 - e) Open the front door on the infeed side and repeat steps 1b, 1c, and 1d.
2. After climbing into the saw chamber, perform the following steps to remove the obsolete parts.
- a) Locate the wedge tip skirt on the outfeed side. It is located behind a guard, in front of the dust flap. See Figure 3.
 - b) Remove the five screws holding the wedge tip skirt to remove the skirt.

Figure 3: Removing Wedge Tip Skirt

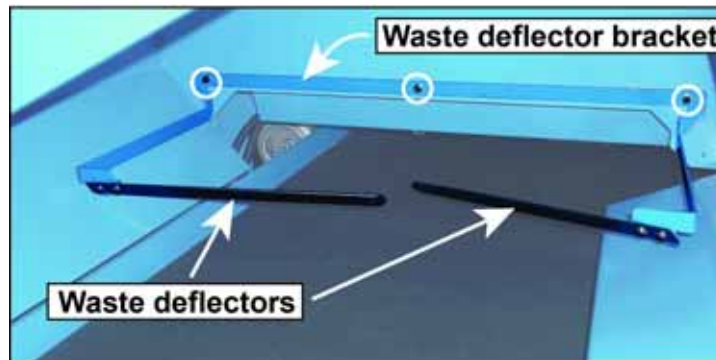


- c) Remove the screws holding the large dust flap mount and the small dust flap mount. The outermost screw on the small dust flap mount was removed in step 1c.
- d) Repeat steps 2b and 2c on the infeed side.
- e) Discard the dust flaps, wedge tip skirts, the small dust flap mounts, and one large dust flap mount. Keep one large dust flap mount.

Installing the Waste Deflector and Guards

1. Attach the waste deflector bracket using the following steps.
 - a) Locate the side of the waste conveyor where the waste exits the chamber. The waste deflector bracket mounts on this side.
 - b) Place the bracket in the place where the large dust flap mount was. See Figure 4.
 - c) Use 3 lock washers and 3 screws to attach the bracket to the frame. The screws should fit into existing holes.

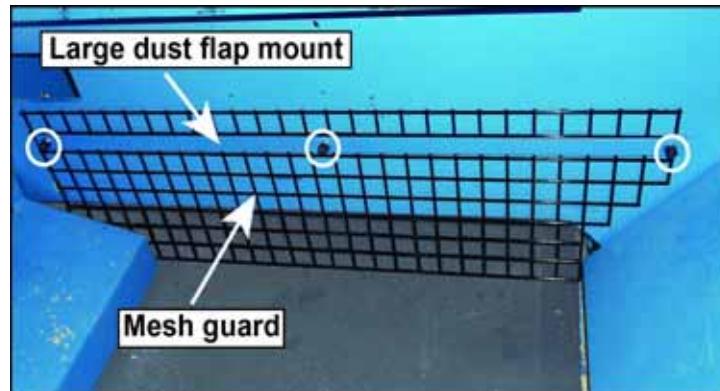
Figure 4: Installing the Waste Deflectors



Waste deflectors installed, shown on the outfeed side.

2. Attach the mesh guard using the following steps.
 - a) Move to the side of the chamber opposite of the waste deflectors.
 - b) Place the mesh guard in the same place where the large dust flap mount was. The bottom of the mesh should be 1/2" above the waste conveyor.
 - c) Place the large dust flap mount over the mesh guard.
 - d) Using 3 lock washers and 3 screws, attach the large dust flap mount and mesh guard to the frame. The screws should fit into existing holes. See Figure 5.

Figure 5: Installing the Mesh Guard



Mesh guard installed, shown on the infeed side.

3. Attach the waste deflector guard using the following steps.
 - a) Locate the place where the wedge tip skirt was mounted on the infeed side of the chamber.
 - b) Place the waste deflector guard with brush where the wedge tip skirt was mounted. The brush should angle toward the saw blade.
 - c) Use 3 flat washers, 3 lock washers, and 3 screws to attach the waste deflector guard to the frame. See Figure 6. The flat washers should be touching the guard with the lock washers on top of them.

Figure 6: Installing the Waste Deflector Guard



Waste deflector guard installed on infeed side. This is the correct side for the guard regardless of conveyor direction.

END OF SERVICE BULLETIN