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MiTek Machinery SERVICE BULLETIN

Service Bulletin	127
Date	11/2/01
Revision Level	A

Product	CyberSaw Inker Assy
Description	Adding Incremental Encoder for Speed Feedback to Willet Inker

Created	Reviewed	Approved
GEM		TBH

Currently, saw software adjusts parameters sent to the Willet inker based on the set speed of the infeed conveyors. This is not always accurate enough to mark each board in the same place. Additionally, since inker parameters are sent to the inker each time a board is marked, many features built into the inker can not be utilized.

To achieve very high marking accuracy and allow the use and adjustment of inker parameters at the inker, so that they remain constant for each board marked, MiTek is issuing this service bulletin to add an incremental encoder to the inker system. The encoder will provide speed feedback directly to the inker system. The inker system will adjust the set parameters, internally, based on speed changes sensed by the encoder/inker combination.

Customers can now adjust parameters such as repeat raster, font, and placement with more confidence that each board will be marked like the board used to set up the parameters.

Service Bulletin Kit (SB127Kit) includes the following:

Qty	PN	Description
4	326094	SHCS, #10-32 UNF X 5/8 LONG
2	327161	HHCS, ¼-20 UNC X 1 LONG
4	327165	HHCS, ¼-20 UNC X 1-1/2 LONG
2	337157	SHSS, ¼-20 UNC X ¾ LONG
6	361601	HEX NUT, ¼-20 UNC
4	364026	LOCK SPRING WASHER, #10
6	364034	LOCK SPRING WASHER, ¼
6	365632	FLAT WASHER, ¼
1	504519	INCREMENTAL ENCODER, DYNAPAR PN HC2530000041
1	90434-501	ENCODER CABLE W/ CONNECTOR
1	530050	TIMING BELT
1	78793	PULLEY, 3/8 BORE
1	78789	GUARD, ORANGE
1	78790-501	MOUNT ASSY
1	78792	PULLEY, 1-1/4 BORE
1		MITEK INKER INSTRUCTIONS WITH INITIAL INKER PARAMETERS

If you are missing any parts, please contact MiTek Customer Service at (800)325-8075.

To install this kit you will need the following tools:

DRILL MOTOR
5/32 DIA DRILL

1) Remove square drive shaft from the stationary end bearing.
   a) Remove square drive shaft drive chain from the square drive shaft sprocket by removing the master link connecting clip and removing the master link from the chain.
   b) Remove the square drive shaft sprocket from the shaft by loosening the sprocket set screw and sliding the sprocket off the shaft. Do not loose the sprocket key.
   c) Loosen the set screws of all the bearings along the length of the square drive shaft.
   d) Slide the square drive shaft towards the left until there is a gap of about 2 inches between the end of the shaft and the bearing.
2) Install drive pulley.
   a) Install two ¼-20 UNC X ¾ long set screws (PN 337157) into the 1-1/4 inches bore drive pulley (PN 78792). Make sure set screws do not extend into bore.
   b) Slide pulley onto round section of square drive shaft. Push pulley until it is snug against the square section of the shaft.
   c) Tighten two pulley set screws to secure pulley to shaft.
   d)