



SERVICE BULLETIN

Document ID:

SB249

Title:

Twin-Axis Blade Replacement

Affected machinery: *Twin-Axis Sheathing Saw*

Distribution: Customers upon order

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Created By	A. McIntire
Approved By	R. Tucker



CAUTION: The document should only be printed in color with adequate resolution.
Graphics may be unclear and could create an unsafe condition if this recommendation is not followed.

Purpose and Scope

This service bulletin instructs how to replace the rip or cross-cut blade in the *Twin-Axis Sheathing 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 SB249KIT

Quantity	Description	Part #
1	Saw blade, 13.8"	811006
1	Service bulletin document	SB249

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



Supplies Needed

- New or sharpened saw blade
- 46-mm wrench
- 3/8" spanner wrench

When to Replace the Saw Blades

Depending on the type and size of sheathing material, one blade may wear more quickly than the other. The frequency of blade changes and of repairs also depends on the number of hours the saw is running each week.



Never use a saw blade with a diameter less than 13.5" (342 mm).
Immediately discard any used saw blades that do not meet this criteria.

Check each blade (rip and cross-cut) weekly for signs of wear and replace accordingly.

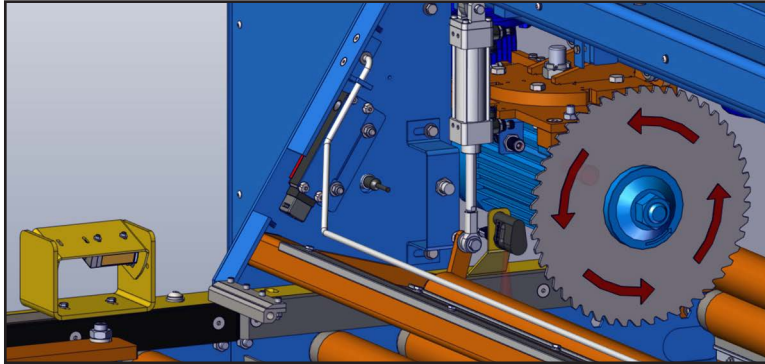
	 WARNING
	Keep saw blades sharp and in good condition. Have the saw blade re-tipped if carbide tips become chipped or come off. Dull blades cause high kickback forces which can cause injury.

Direction of Blade Teeth

The blade teeth of a replacement rip or cross-cut blade must match the following orientation.

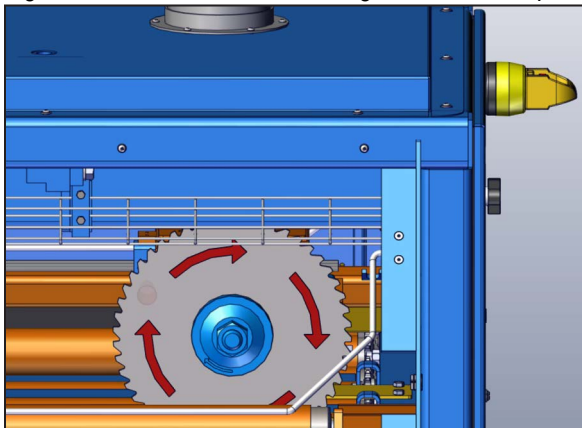
- The rip blade rotates downward toward the infeed end.

Figure 1: Rip Blade Rotating Toward Infeed End



- The cross-cut blade rotates downward toward the non-operator side.

Figure 2: Cross-cut Blade Rotating Toward Non-Operator Side



Specs for New or Used Saw Blades



Use **ONLY** a **NEGATIVE HOOK** saw blade!

A positive hook will pull the material, leading to inconsistent cut lengths and possible material grabbing by the rip blade

A re-tipped carbide blade must meet the following criteria.

- 13.8" (350 mm) = blade diameter
- 3 mm = kerf
- 70 = # of teeth
- 15 = hook angle
- 5 = face angle
- 15 = back angle
- 5 = top angle

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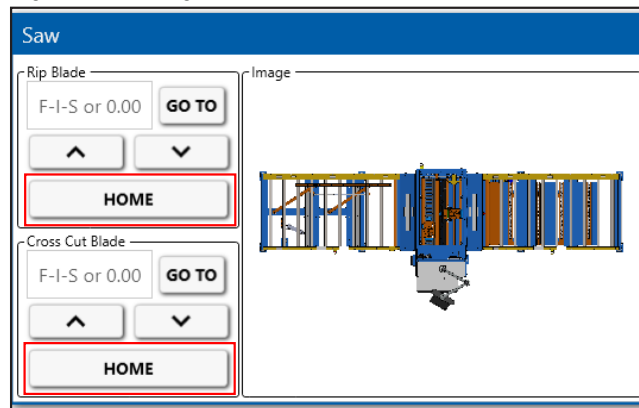
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Procedure

Preparation and Lockout/Tagout Procedures

1. Select and enter the password for the Machine screen on the home screen.
2. Select the **HOME** button for the Rip and Cross-cut blades to ensure they are in the home position.

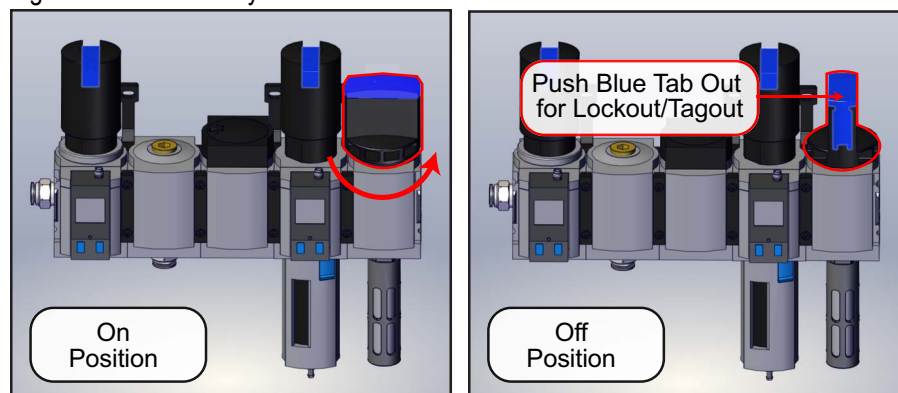
Figure 3: Homing the Rip and Cross-cut Blades



3. Activate an E-stop. Then, turn off or close the system's air shut-off valve and attach a lock and tag. See Figure 4.

	 WARNING
	HIGH PRESSURE HAZARD. Bleed pneumatic lines before performing any maintenance on the system. Working on pressurized lines may cause injury.

Figure 4: Pneumatic System Shut-Off Valve



4. To enable access to the blades, use the open-door pushbuttons to open the operator and non-operator side doors.
 - The cross-cut blade can be accessed from the operator side door.
 - The rip-cut blade can be accessed from non-operator side door.
5. Before beginning to replace either blade, lockout/tagout the electrical system.

	 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 person 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.

6. Turn the disconnect switch handle to the **OFF** position. See Figure 5.

Figure 5: Disconnect Switch



Replacing The Blade

 		 CAUTION
		CUT HAZARD. Saw blades are sharp. Wear gloves and eye protection when handling blade.



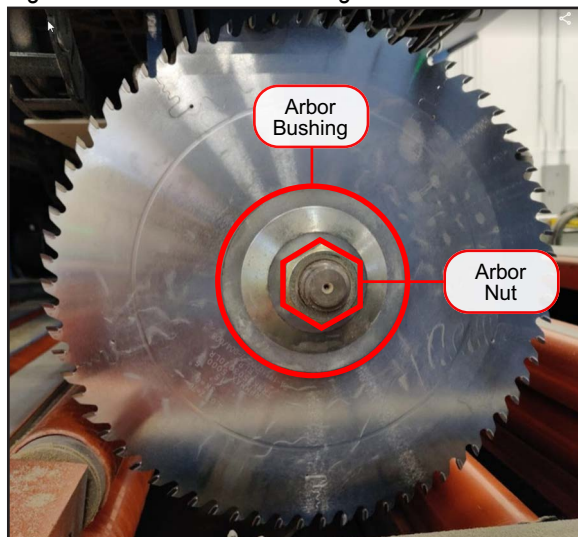
1. After lockout/tagout of the electrical system, use the spanner wrench to hold the blade in place (Figure 6) and the 46-mm wrench to loosen the arbor nut.

Figure 6: Spanner Wrench Placement



2. Remove the arbor nut and arbor bushing.

Figure 7: Arbor Nut and Bushing



3. Remove the old saw blade and place in a safe location for re-tipping or disposal.
4. Place the saw blade and the arbor bushing onto the shaft. Verify the blade teeth are facing the right direction (see *Direction of Blade Teeth*).
5. While holding the blade in place with the spanner wrench, hand tighten the arbor nut into place. Then, use the 46-mm wrench to securely tighten the arbor nut.
6. Once blade replacement is complete, close all saw chamber doors.
7. Remove the electrical and pneumatic lockout/tagouts and power on the machine.
8. Release any active hardware E-stops.
9. Run the standard safety test according to the machine manual instructions.

END OF SERVICE BULLETIN