

Safety Notice

Machinery Affected: *Cyber[®] A/T, Cyber, SmartSet Pro, SmartSet,[®] EasySet[®] and ElipSaw[®] Saws*

Document: **SB167**

Title: **Replacing the Motor Mount Feet with a Saw Motor Foot Plate**

Applies To: ***Emerson[®] (US Motors) Blade Motor Installed Between 30 June 2004 and December 2005***



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Purpose and Scope

This Service Bulletin procedure should be completed by customers using *MiTek[®] Cyber[®] A/T, Cyber, SmartSet Pro, SmartSet,[®] Easy-Set,[®] and ElipSaw[®]* saws with *Emerson[®] (US Motors)* blade motors.

The motor mount feet and bolts on *Emerson (US Motors)* blade motors may break, resulting in an unsafe scenario where the motor is supported only by the brake assembly. In this Service Bulletin, you will find instructions for removing the motor mount feet and replacing them with a new saw motor foot plate.

This notice is applicable to:

- Saws manufactured between 30 June 2004 and December 2005, which include component saws from frame number 401 and higher and *ElipSaw* saws with frame number 6 and higher.
- All saws that had blade motors replaced with Emerson (US Motors) blade motors between 30 June 2004 and December 2005.

Corrective Action

To ensure safe operation of your saw, the motor mount feet must be replaced with the saw motor foot plate.

The replacement should take 1-2 hours per motor. Plan on doing the work during a time when the saw can be completely shut down and locked out. If there are any questions, please call *MiTek* Machinery Division Customer Service at 800-523-3380.

Parts and Supplies

Table 1 lists the tools and supplies needed to complete the procedure.

Table 1: Tools and Supplies Required

Description
Standard socket set
Ratchet
Torque wrench
Screwdriver set


Table 2 lists the parts included in SB167KIT.

Table 2: Parts Included in SB167KIT

Quantity	Part Number	Description
1	77698	Saw motor foot plate
4	327231	5/16-18 x 3/4" thread-forming screws
4	327259	3/8-16 x 7/8" hex-head bolts
1	SB167	Service Bulletin 167


Procedure

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>


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.
2. 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>

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


Installing the Saw Motor Foot Plate

CAUTION	
	<p>Saw blade is sharp and can cut.</p> <p>Use caution when handling the blade. Failure to exercise caution may result in serious injury.</p>

1. Remove the saw blade.
2. Disconnect all wiring from the motor. Note how the motor is wired so it can be rewired following replacement of the motor mount feet.

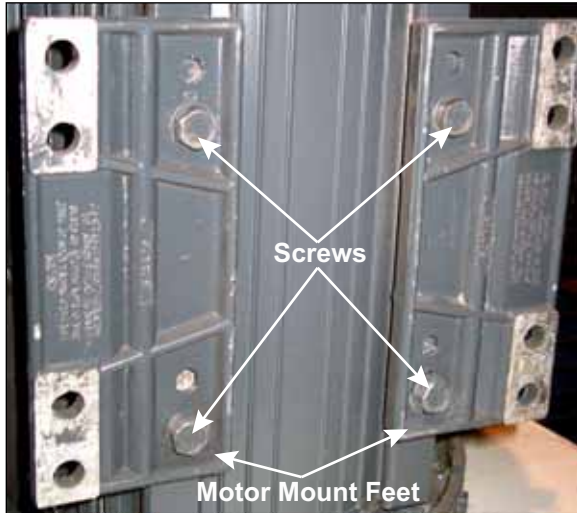
CAUTION	
	<p>Two people should handle the motor. The 7-hp motor weighs approximately 70 lb and the 12-hp motor weighs approximately 90 lb.</p> <p>Failure to exercise care may result in injury to personnel and/or damage to equipment.</p>

3. Remove the motor from the quad using a 9/16-in. socket and ratchet and discard screws. Keep lock washers.

WARNING	
	<p>Do not attempt to service motor hub. If service is required, remove entire motor and hub and call MiTek Customer Service to arrange for service.</p> <p>Failure to follow this restriction may result in blades coming loose from the motor shaft, which may result in serious injury or death.</p>

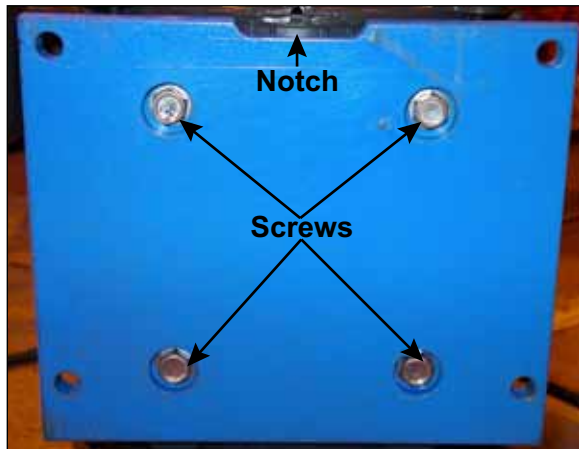
4. Remove the motor mount feet from the motor using a 1/2-in. socket and ratchet. Discard screws and motor mount feet. See Figure 1.

Figure 1: Remove the Motor Mount Feet (View From Bottom)



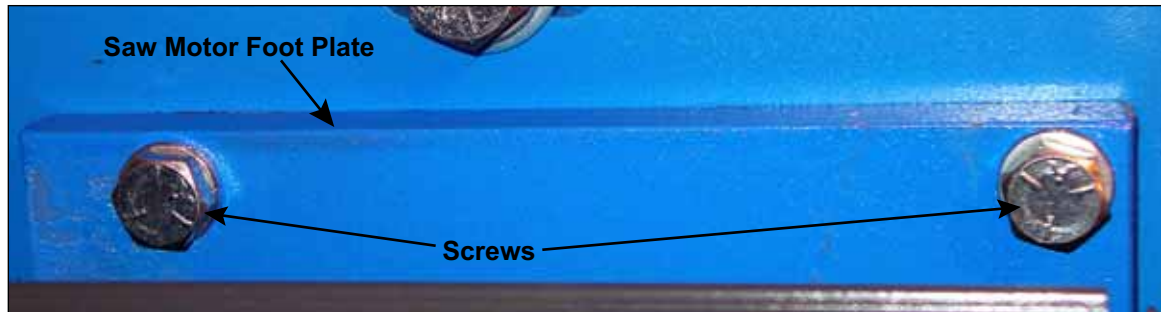
5. Attach the saw motor foot plate to the motor with the 5/16-18 x 3/4-in. thread-forming screws using a 1/2-in. socket and torque wrench. Torque screws to 17 to 19 ft-lb. The notch in the motor foot plate must be toward the shaft end of the motor. See Figure 2.

Figure 2: Attach the Saw Motor Foot Plate (View From Bottom)



6. Attach the plate and motor assembly to the saw's quad with the 3/8-16 x 7/8-in. screws using a 9/16-in. socket and ratchet. See Figure 3.

Figure 3: Plate Assembly Mounted on Quad



7. Rewire the motor in the same way it was previously wired.
8. Reattach the saw blade. Torque blade screws to 18 ft-lb.
9. Remove the lockout and tagout devices. Disengage the E-stop and restore power to the computer and saw.
10. Recalibrate the saw and check saw blade braking time. Adjust as necessary. Refer to the saw manual for guidance.



Recalibrate the saw and blade braking time before operating the saw.

END OF SERVICE BULLETIN