Install procedure for load table thin plate ramp kit.

Document number: 719-00619A

Product

- Magnus VLF MCU
- Magnus VLF CL

FCO priority

As required by the site and PSS.

Machines affected Possibly all MCU and CL devices that use 0.008” or 0.2mm plates.

Background

The Load table front beam can catch plates that are excessively curved and normally thin [0.008” or 020mm]. There are two kits available, one has the parts for the clip in rail and the other has parts for permanent mounting to the rails and the front beam on the load table

Solution

Install the sheetmetal ramps to the rail assemblies and the front beam.

Time required Approximately 100 min.

Parts required

Part Number	Part Name	Quantity
518-01573A	KIT, PLATE RAMP, THIN CURLED PLATES, MTA	1 pc

Tools required

- Allen keys
- Needle nose pliers
- 2 useful hands with fingers attached.

a) Installing the front beam fixed plate ramps.

1. Move the backbone to the tilted load position <backbone tiltedload>, unlock the panels <door unlock> and open the front and rear hoods.
2. Lower the finger guard on the load table pullout frame support beam. Loosen the ¼ turn fasteners holding the table rails down.
3. Remove the unload table panels and the load table rail sets.
4. Remove the rail guides from the front beam; there should be 8; and replace with the plate ramps supplied. See the kit assembly drawing which defines the location for each part that attaches to the front beam.



Figure 1: Plate ramps in position on rails and front beam.

b) Installing the plate ramps on the rail sets.

5. Replace the mounting bracket on the drum side of the load table rail sets. This may or may not be required depending on the serial number of the device because newer devices may have the new part already.
6. Pay attention to the number written on the replacement mounting bracket assembly as the ramps may have already been mounted to the mounting bracket. Also notice that there are extra springs assembled to the mounting bracket which can be removed if required.



Figure 2: New plate ramps on rail set.

7. Reinstall the load table rails into the device.
8. Check that the leading edge of the load table does not catch plates as they are slid over the rails and onto the front beam. If the plate edge catches on the leading edge of the front beam then remove that set of rails and gently bend that location of the leading edge down farther with a hammer and punch. Be careful not to damage the coating on the front beam.

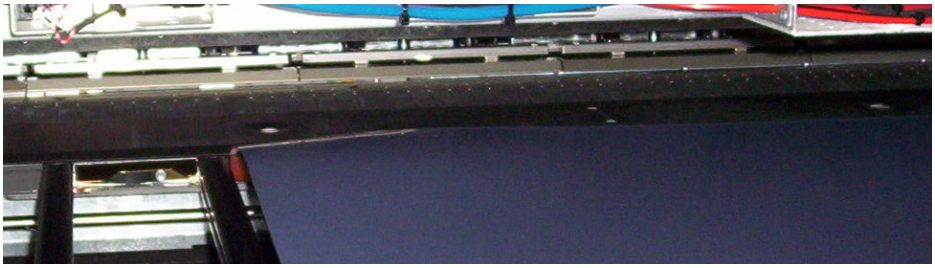
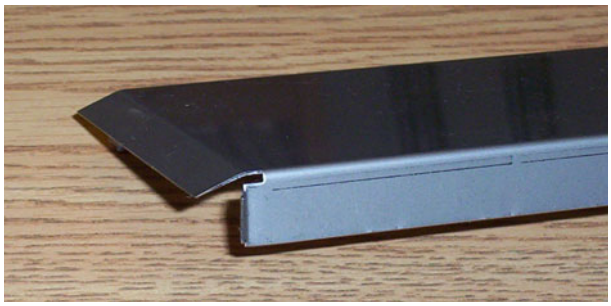


Figure 3: Plate caught on front beam lead in edge.

9. Re-check for plates catching on the load table front beam leading edge.

c) Assemble and install the clip in plate ramps [optional].

10. Assemble the tape to the plate ramps. Ensure that the surfaces are degreased clean and dry.
11. Wrap the extra length tape under each of the two lead-ins on the end of the ramp.



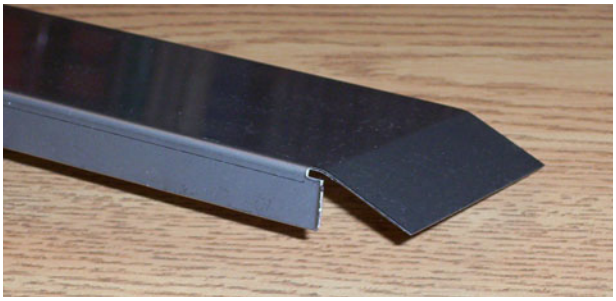


Figure 4 & 5: Plate ramp ends.

12. Trim the excess tape from the ramp following the perimeter of the ramp including the two lead-in sections. Do not trim the ends of the ramps where the tape is wrapped around to hold these edges from peeling.

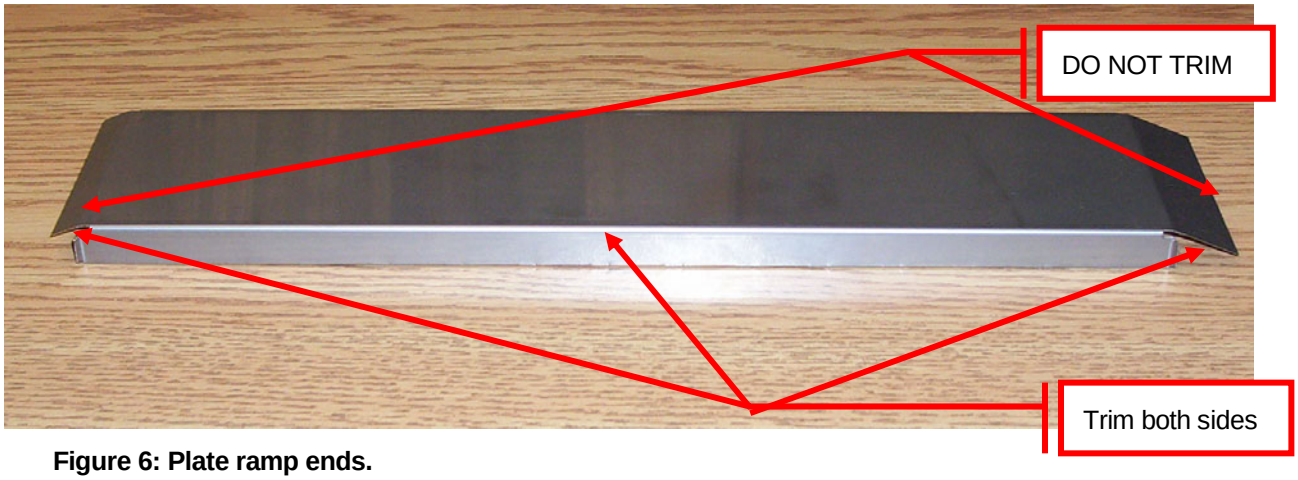


Figure 6: Plate ramp ends.

13. Install the clip in plate ramps. Orient the part so the short ramp is toward the drum. Put the ramp under the rails, between two rails, at the location where the ramp will be placed. Ensure the ramp will not interfere with the pullout table rails or the vacuum cups.
14. Push the tabs on one long side of the part into the groove in the side of the rail. Notice the tapers on the tabs that will grab onto the side of the rail.

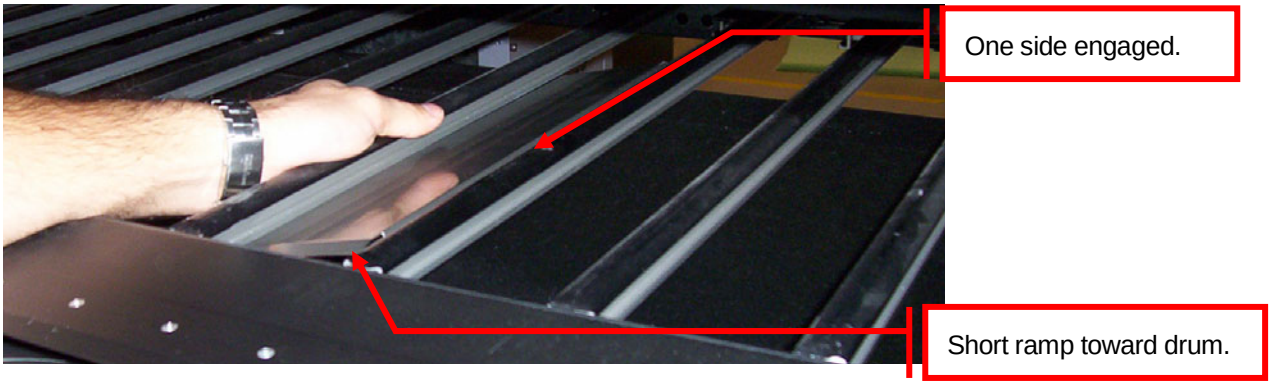


Figure 7: Ramp under rails with one side clipped in.

15. Then push the other long side up between the rails until the tabs engage.

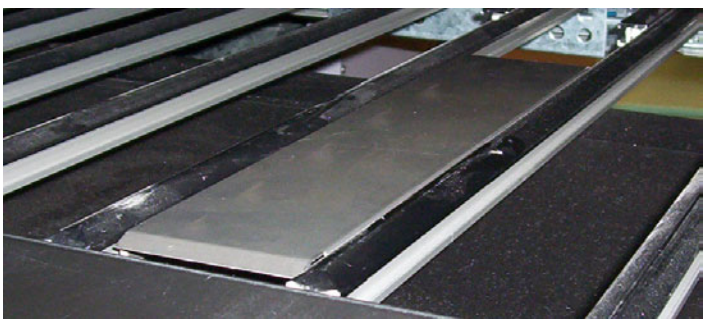


Figure 8: Ramp under rails with one side clipped in.

16. Check that the ramp is secure and will not fall out or slide easily. If the part slides easily or will not stay in location remove the part by pushing it out the bottom and bend the tapered part of the tabs out at a steeper angle and retry the installation.

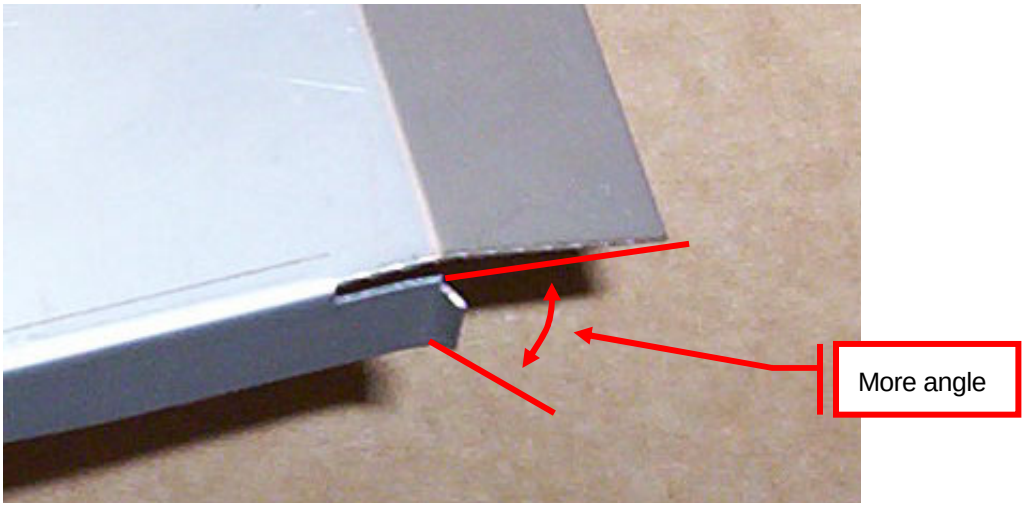


Figure 9: Ramp tapered tab bent out farther [steeper angle].

d) Testing the new parts.

17. Re-install the unload table panels, move the finger guard back to up position, tighten the ¼ turn fasteners holding the rails sets to the pullout frame and close the hoods.
18. Turn the key switch to mechanical hazard mode.
19. Test by loading a few plates of the most offending size.
20. If the results of the test show that the plates are being caught under a rail but over the plate ramps as shown in the picture then we still have a problem to overcome. Maybe the fetcher engine center position could be adjusted slightly [like 1mm or so] to reduce this scenario.



Figure 10: Plate caught under the rail but over the plate ramp.

21. Turn the key to disable mechanical hazard mode.
22. Lock the panels.

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Technical contact	Gordon Andrew
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