Kodak

Automatic Pallet Loader

Picker Shoe In/Out Cylinder Orifices Upgrade

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Revision History

Revision	Date	Author	Comments
1	05 May 2008	S.Damiano	Draft release
2	08 May 2008	A.Blignaut	Edited and formatted

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1. OVERVIEW

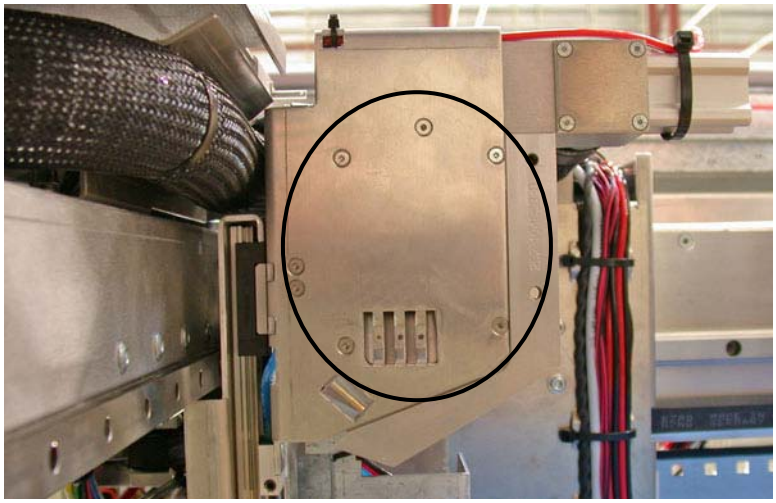
In this procedure you will replace the APL picker shoe in/out cylinder orifices to allow the shoes to extend/retract faster. The procedure for each picker tower is the same, so only one side will be described.

2. PARTS/TOOLS

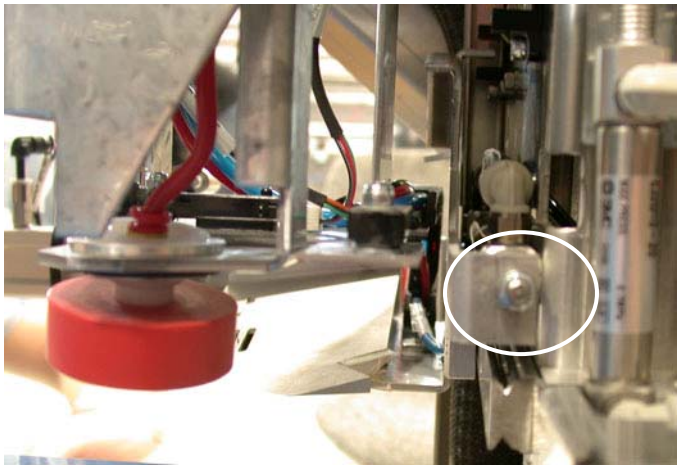
Upgrade Kit – 518-03262A

3. REPLACING THE IN/OUT CYLINDER ORIFICES

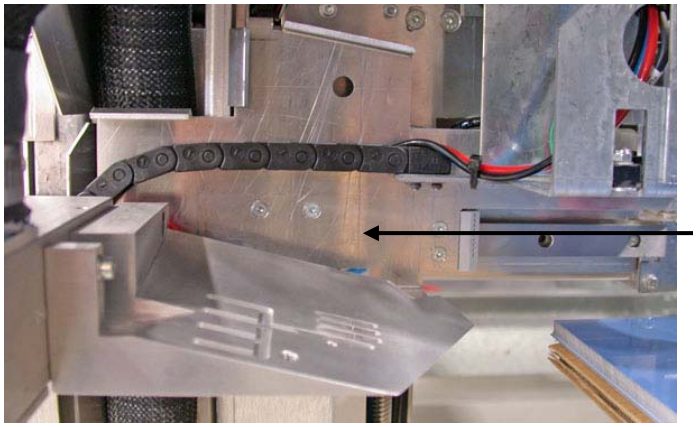
1. Remove the picker shoe—seven screws on the underside of the shoe (two of those screws secure the flex track to the shoe).



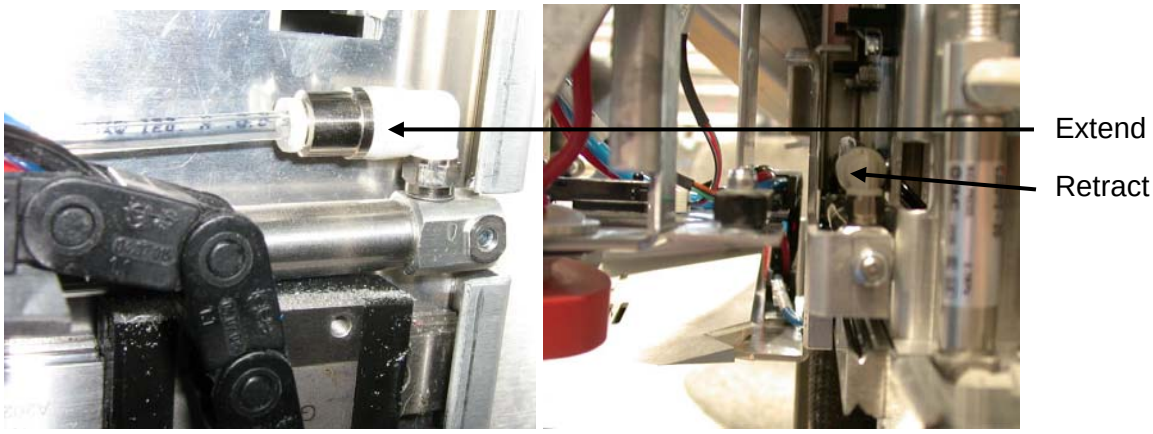
2. Remove the nylock nut at the end of the cylinder.



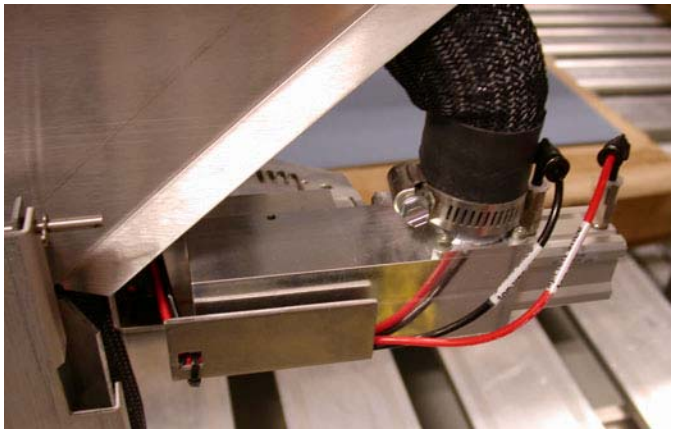
3. Cut any cable ties that secure the cylinder tubes to the bracket and remove the picker shoe in/out bracket—four screws.



4. Replace the extend and retract cylinder orifices with the orifices (336-00105) in the kit.



5. Install the in/out bracket—four screws. Route the tubes between the cylinder and the bracket and secure them with cable ties.



6. Install the cylinder end nylock nut. Tighten the nylock so there is a ~1mm gap between the nylock and the sheet metal bracket. This prevents the cylinder from being over constrained.
7. Install the picker shoe and secure the flex track to the shoe.
8. Replace the cylinder orifices on the other picker tower.