Kodak

Automatic Pallet Loader

Hinged Corner Panel Upgrade

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Revision History

Revision	Date	Author	Comments
1		S.Damiano	First draft
2	07 May 2008	A.Blignaut	Formatted and edited
3	12 may 2008	A.Blignaut	Some photos replaced + minor edits

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1. OVERVIEW

This procedure is to upgrade the front APL corner panel to allow it to hinge 180°. This will allow the center sliding panels to move an additional 102 mm (4 in.) towards the power box side of the APL, increasing the opening while loading plate pallets into the APL.

2. PARTS/TOOLS REQUIRED

- Upgrade kit 518-03402A
- Portable drill

3. HINGED CORNER PANEL UPGRADE

1. Unlock the APL. Type `>>apl unlock` .
2. Open the front corner panel on the power box side of the APL.
3. Remove the light, switch, and emergency stop switch from the current corner panel.

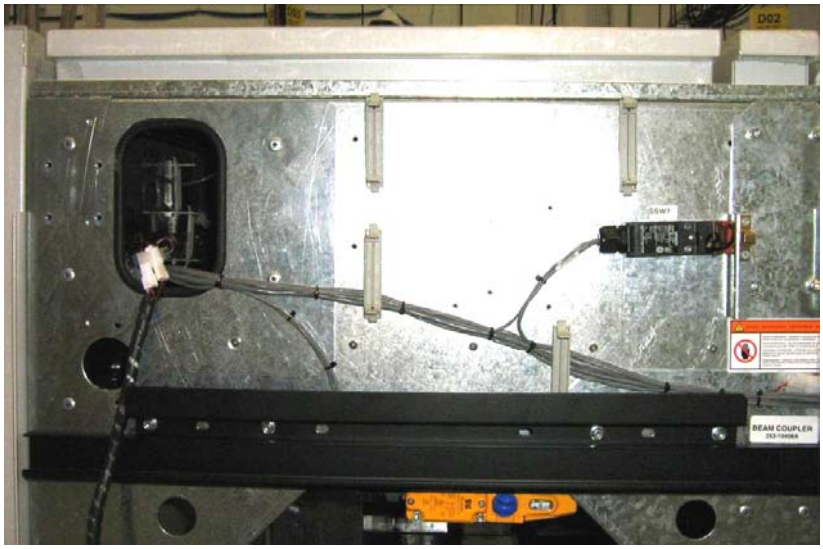


4. Remove the bottom hinge bracket from the frame—four M5 SHCS.
5. Ensure that no cables are attached to the corner panel and lift the corner panel off the upper hinged bracket.

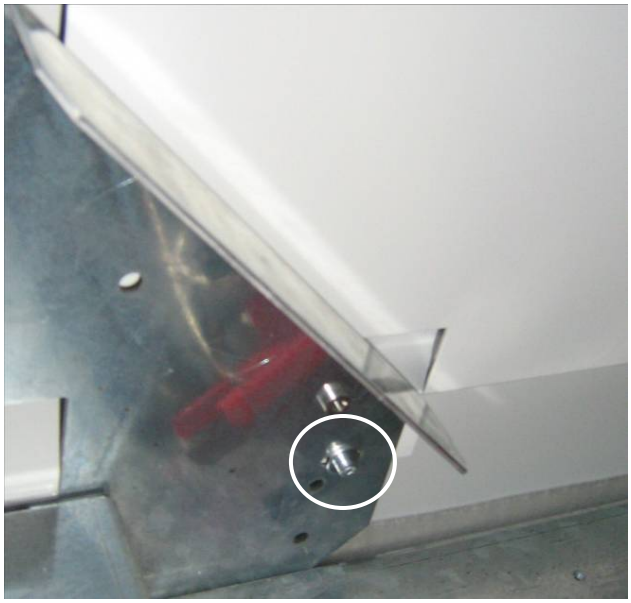
6. Remove the upper hinged bracket—four M5 SHCS.



7. Remove the bottom door rail from the frame—four M5 SHCS.
8. Remove the top door rail from the frame—two M4 BHCS.
9. Install the longer top door rail (252-20020A) and bottom door rail (252-20225A).
   Note: Align the door tracks as best as possible to the existing tracks to ensure smooth door movement.

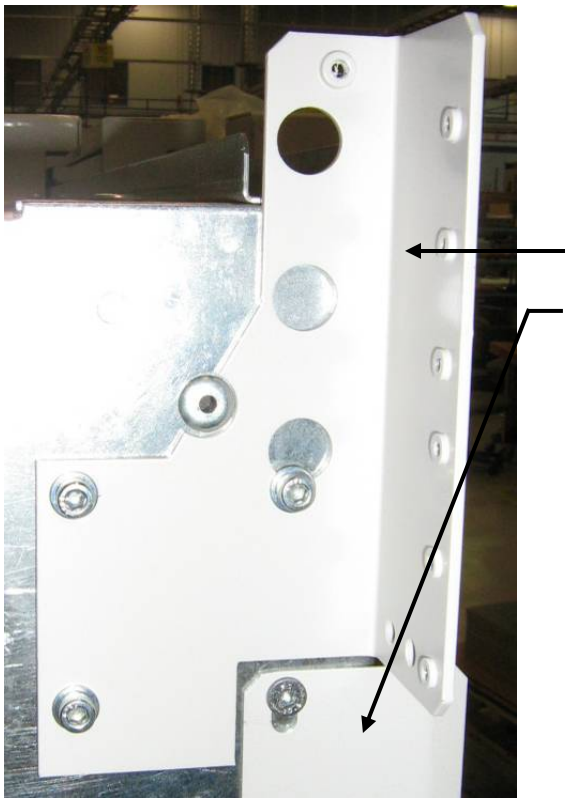


10. Remove the power box side panel next to the corner panel that you removed. There are two M5 SHCS inside at the bottom corners and two M5 SHCS inside along the top frame securing the panel in place.



Bottom M5 fastener

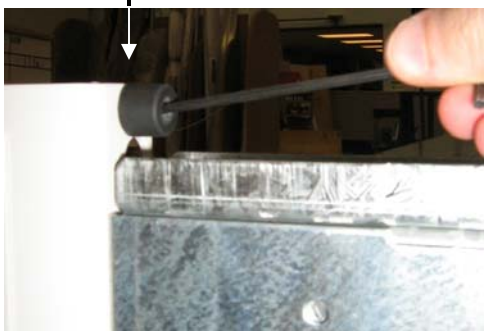
11. Install the new top and bottom hinge brackets (252-20551A & 252-20552A) to the frame using M5 SHCS, opposite corners of the frame to which the old hinge brackets were installed on. The same side of the frame where the door blind is installed on. If the APL is a right eject, then 252-20551A will be installed on the top. If the APL is a left eject, then 252-20552A will be installed on the top. Install the bumper (59-3057) onto the top bracket only using a M4 SHCS (52-4482).

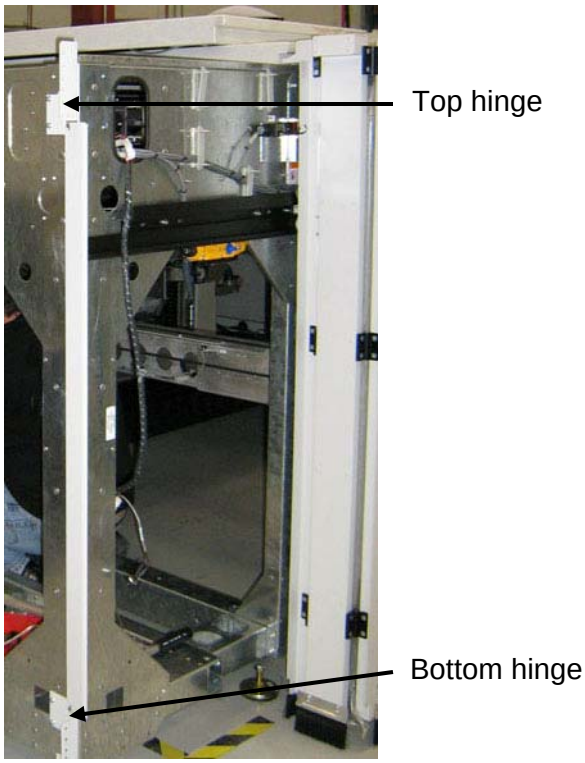


Top hinge bracket

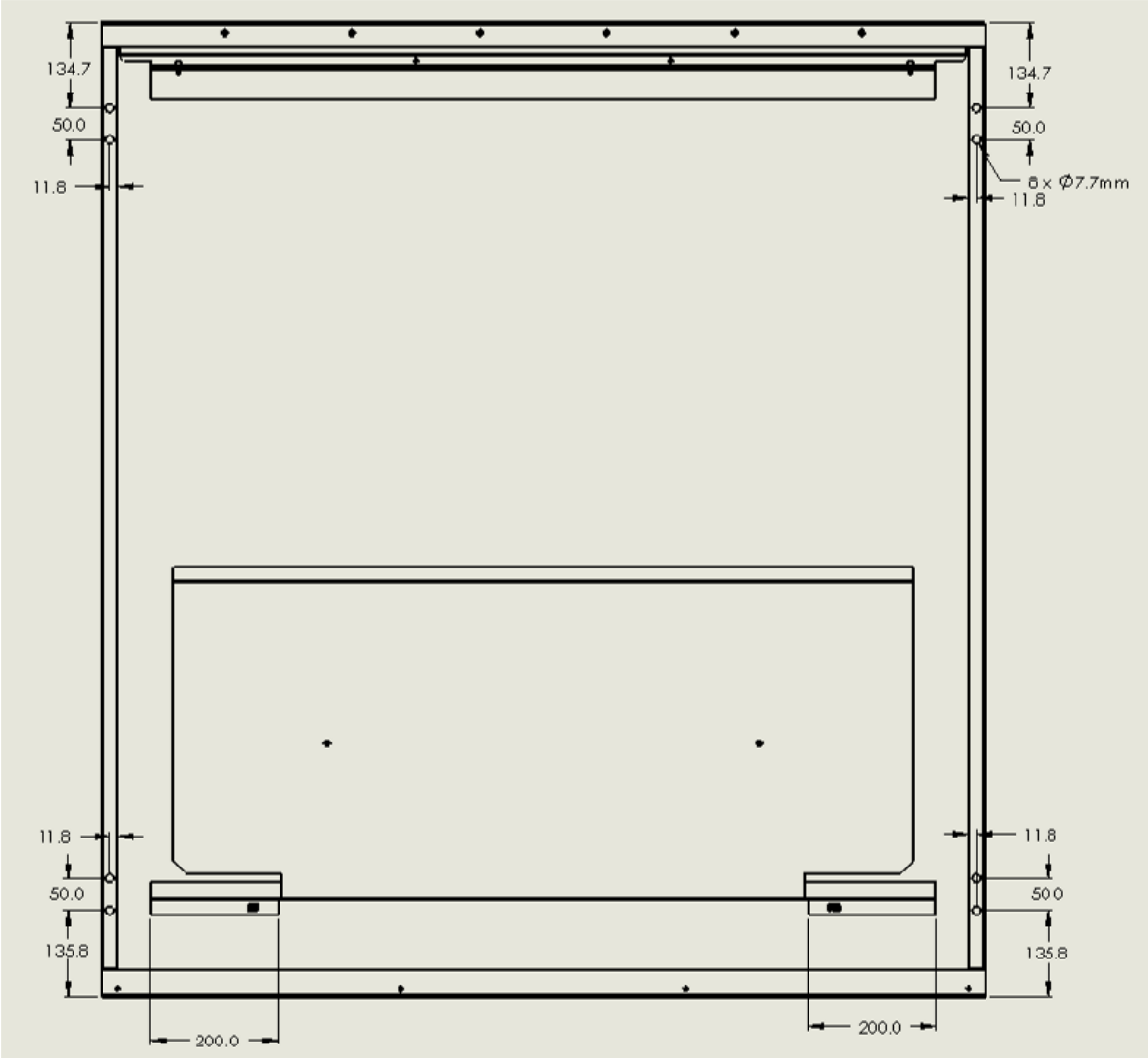
Door blind

Bumper



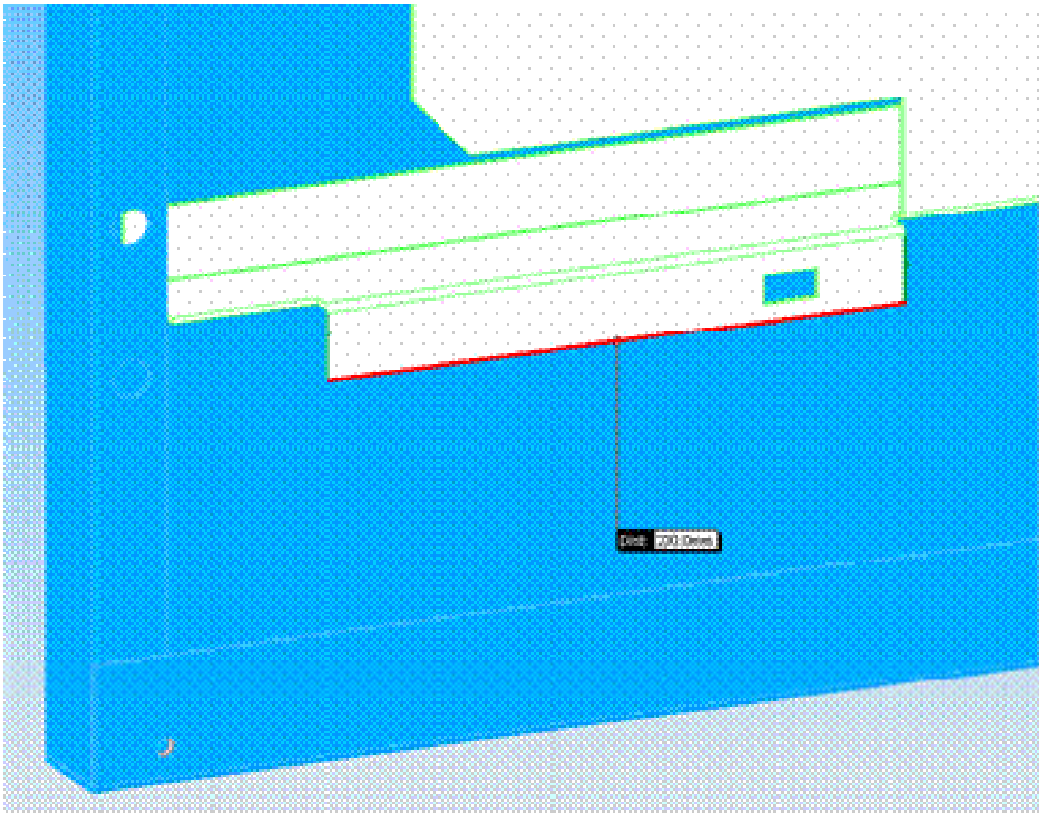

Top hinge
Bottom hinge

12. Drill four clearance holes for M5 SHCS heads in the power box side panel nearest the corner panel, using the ø7.7mm drill (690-00486) provided in kit.
    Note: Only the side nearest the corner panel should the holes be drilled, the drawing supports both left and right eject APLs.

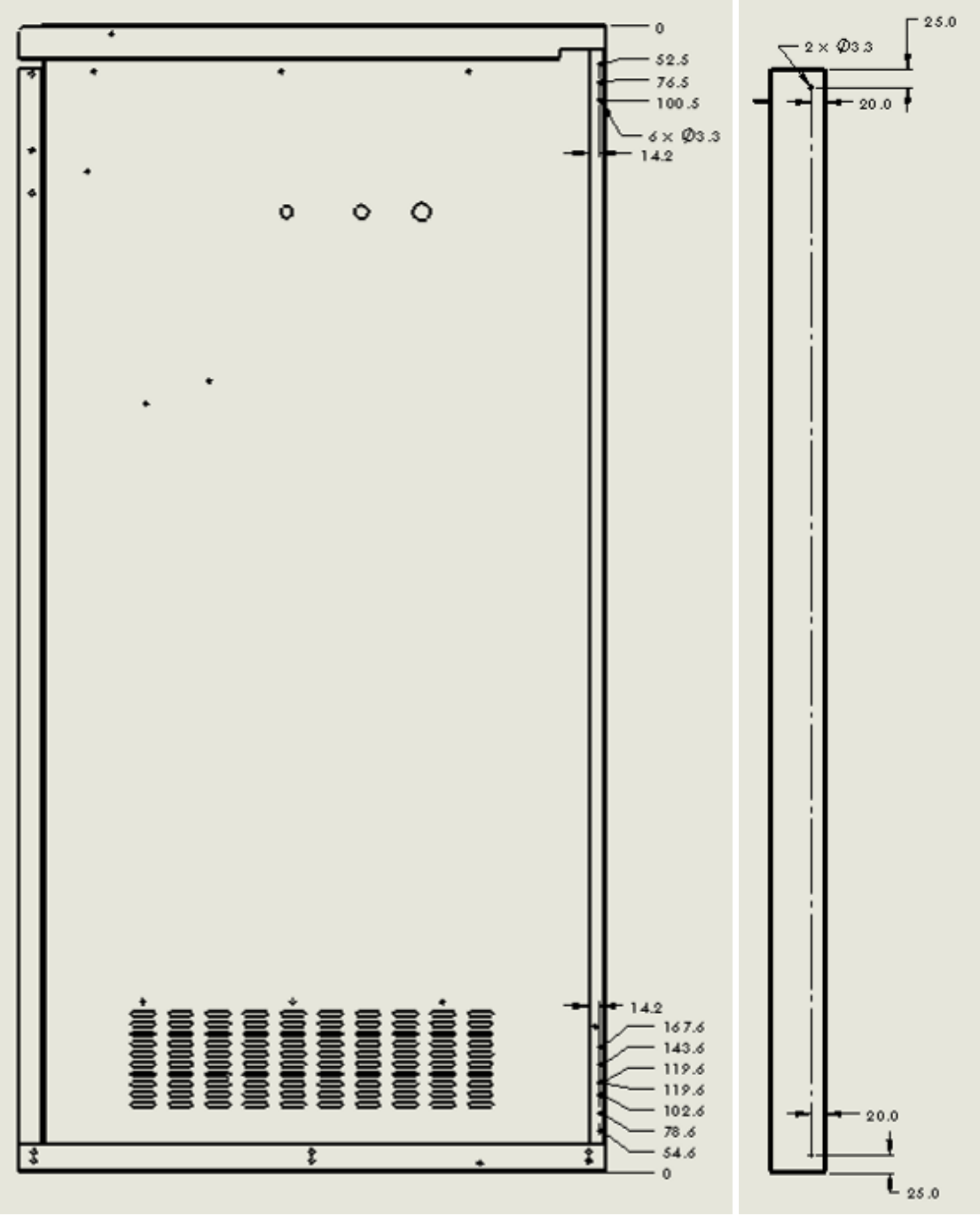


All dimensions are in millimeters.

13. Trim the welded stiffener to 200 mm as shown in the drawing above using the hacksaw (90-1143) provided in the kit. Cut the stiffener flush with the bend.
    Note: Only the side nearest the corner panel must be done.

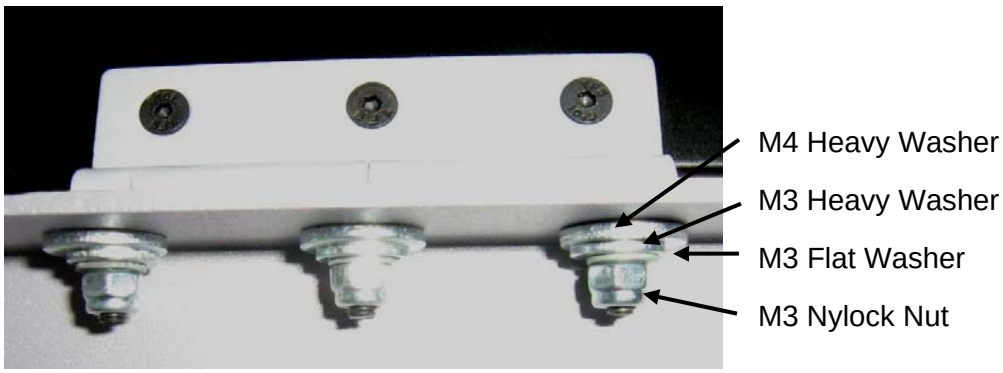


14. Using the ø3.3 mm drill (690-01651), drill nine holes in the corner panel for the hinges, and two holes on the side for the rubber bumpers.
    The door brush may need to be removed for drilling, install it when finished.



15. Install the two rubber bumpers (360-00008) using M3X10 (52-4523) screws.

16. Install the top hinge and the lowest bottom hinge onto the corner panel—do not install the upper bottom hinge. Use M3X12 (300-00155), M4 heavy washer (52-3247), M3 heavy washer (52-3292), M3 flat washer (52-3057) and M3 Nylock nut (52-3197).
    If the APL is a right eject, then use 252-20120A. If the APL is a left eject, then use 252-20122A.



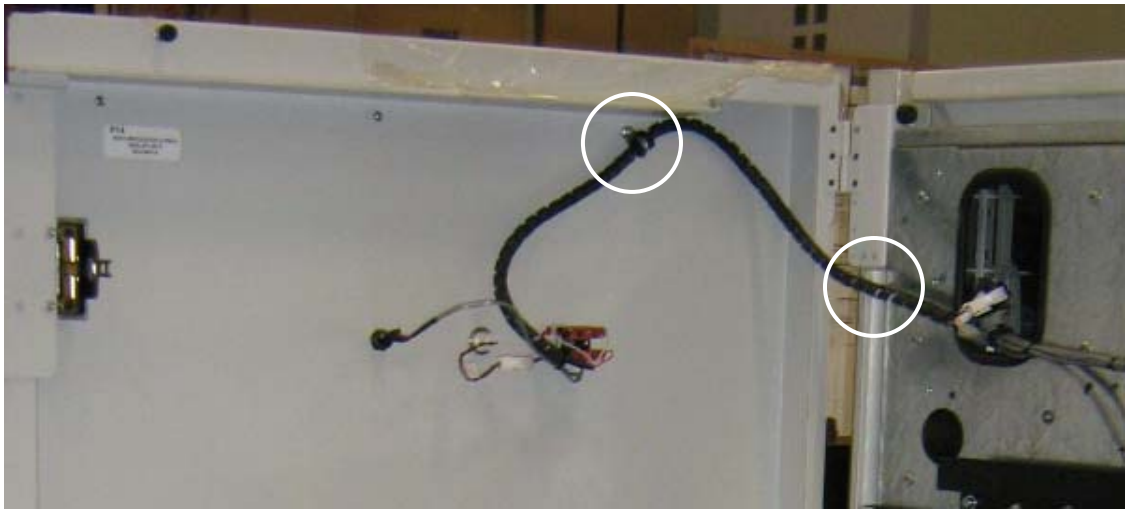
17. Install the other two hinge halves to the corner hinge bracket on the frame using M3X8 FHCS 52-4595).
    Note: Use the far upper and far lower set of PEMs to install the hinges.

18. Slide the two corner panel hinges together, mounting the corner panel onto the frame. Install the third hinge (the upper bottom one).



19. Connect the cables and switches to the corner panel.

20. Secure the cables with cable ties to ensure that they do not bind or get pinched when closing the door.



21. Install the side power box panel.



