Kodak

ThermoFlex Mid II Hybrid

Platesetter

Installation Guide

English

731-00924A-EN Rev A

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Introduction

The Hardware Installation Guide for the Kodak® ThermoFlex® Mid II Hybrid platesetter describes the process of unpacking and installing a ThermoFlex Mid II Hybrid platesetter at a customer site.

Before you begin to unpack and install the platesetter, confirm that the site is ready according to the site preparation guidelines. For your convenience, the power- and connections-related prerequisites can also be found in the *Connecting the External Components and Power* section of this document.

Unpacking the Platesetter

Note: It is recommended to read this entire section before starting to unpack.

Throughout the unpacking process, handle all packing material with care. You will use these materials again if you need to transport the platesetter in the future.

Requirements

- Two people
- Forklift
- 5/16" hex key

Before Unpacking

Before unpacking the platesetter, ensure that the following conditions exist.



WARNING: Do not proceed with the unpacking if the following conditions do not exist.

- The shipping container is undamaged.

  Important: If the container is damaged in any way, notify the shipping agent immediately.

- The temperature where you are unpacking the platesetter is not less than 0°C and not more than 30°C.
- If the weather is very humid, that the room is air-conditioned.

- The site is large enough to allow easy maneuvering of the platesetter:
  - ❒ There is space for the forklift to lower the platesetter from the shipping pallet.
  - ❒ The doorway clearance is adequate for the platesetter and forklift.

Device	Width	Depth	Height	Weight
Platesetter	2110 mm (83 in.)	1030 mm (41 in.)	1370 mm (54 in.)	910 kg (2006 lb.)
Platesetter shipping container	2250 mm (88.60 in.)	1560 mm (61.50 in.)	1610 mm (63.40 in.)	1145 kg (2524 lb.)
Debris removal cabinet	See the UDRC Site Preparation and Requirements document (725-00089A).			
Workstation	Varies with configuration			
Optional equipment				
UDRC external venting	See the External Venting Upgrade for UDRC document (709-00211A-B-PR01)			

Table 1: Platesetter and packing crate dimensions

Removing the Platesetter From the Packaging

At least two people and a forklift are required to unpack and lower the platesetter from its shipping pallet. The unpacking process is shown in Figure 1 on page 3. The numbers in the instructions below refer to the item numbers shown in Figure 1.

1. Use the forklift to lift the shipping container and place it at the unpacking site.

   Note: Lift the container only from the side indicated on the label on the container.

2. Carefully cut the two steel bands [1] surrounding the carton [2].
3. Open the top flaps of the carton [2].
4. Remove the staples that secure the carton [2] to the shipping pallet [7] and to the support struts [5].
5. Remove the entire carton [2].
6. Remove all the parts that are tied to the shipping pallet at the rear of the platesetter.
7. Remove the top support struts [3] and the side support struts [5].

Important: If there are any signs of ice on the platesetter, do not touch any of the mechanical parts. Wait at least 24 hours (preferably 48 hours) for the platesetter to gradually reach room temperature.

8. The platesetter is secured to the shipping pallet with four screws, brackets and washers [8]. Remove the screws, brackets and washers from underneath the shipping pallet.

9. Using the forklift, lift the platesetter from the shipping pallet. Make sure to lift the platesetter *only* at the designated locations, marked on the pallet frame.
10. Lower the platesetter from the shipping pallet.
11. Remove the nylon wrapping from the platesetter.

    Note: When you cut off the nylon wrapping, be careful not to scratch the platesetter.

12. To move the platesetter, lift its legs so that the platesetter can be rolled on its wheels, and then close the nut on each leg by turning it counterclockwise.
13. Roll the platesetter to its final location.
14. Lower the four legs of the platesetter by turning the nut on each leg clockwise.

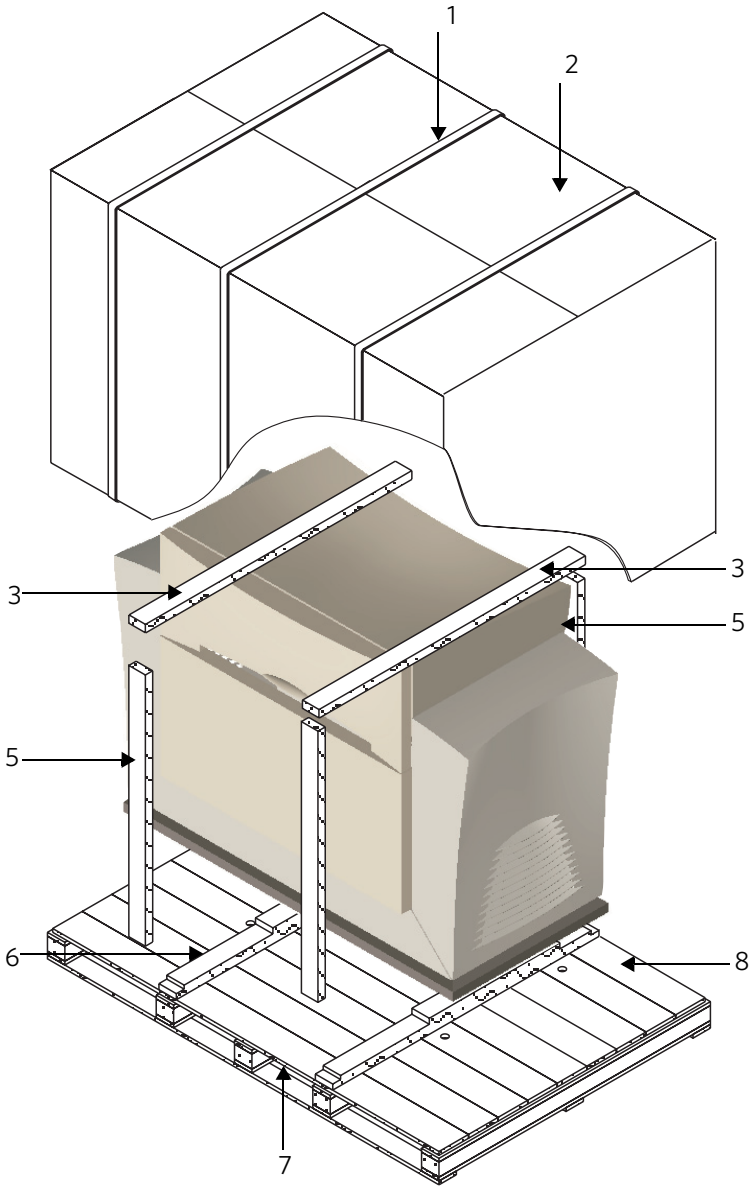


Figure 1: Unpacking the platesetter

Parts Checklist

For a parts list, see the *GCL* forms attached to the platesetter packaging, and *Appendix A: Parts and Tools List* on page 30.

Opening Doors and Panels and Removing Shipping Safeguards

The ThermoFlex Mid II platesetter is shipped with safeguards that prevent excessive movement of internal parts during transport. The safeguards are **red** for easy identification.

This section describes how to open the doors and panels of the platesetter and how to access and remove these safeguards.

Assembly	Qty	Location
Optomech to chassis	4	2 front, 2 back
Carriage to optomech	2	1 front, 1 back
Distribution box	1	distribution box
Loading table	2	sides of loading table
Roller	2	sides, behind front panel
Front panel	2	sides, behind front panel

Table 2: Safeguard types and locations

Note: Use a 5/16" hex key to remove the screws.

1. To open the side doors: insert a screwdriver or hex key into the two holes on the front panel and push down to raise and release the locking mechanism.

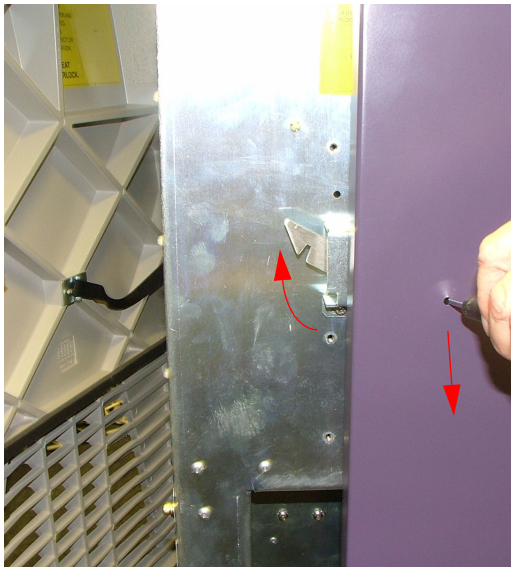


Figure 2: Side door locking mechanism

2. To open the side panels: remove the three cross-head screws on each side panel.



Figure 3: Right side panel

3. With the side doors and panels open, on each side of the platesetter, reach in and remove the two safeguards that secure the loading table to the mainframe. One safeguard is located on each side of the platesetter.

   Note: The loading table safeguards are located deep inside the platesetter and it is difficult to see them. When you remove the safeguards, take care to avoid damaging the imaging head.

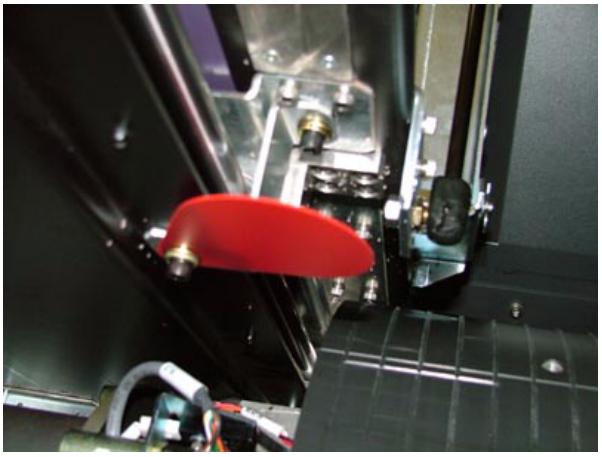


Figure 4: Loading table safeguard

4. To open the loading table: on one side of the platesetter, insert a screwdriver or hex key into the hole as shown in Figure 5, and push up to release the spring lock. The loading table does not open yet, but is slightly loosened.



Figure 5: Releasing the loading table spring locks

5. Repeat step 4 on the other side of the platesetter, and again on the first side, and then slide the loading table toward the back of the platesetter.
6. To unlock the front panel, from each side of the platesetter, open the screw that secures the front panel.

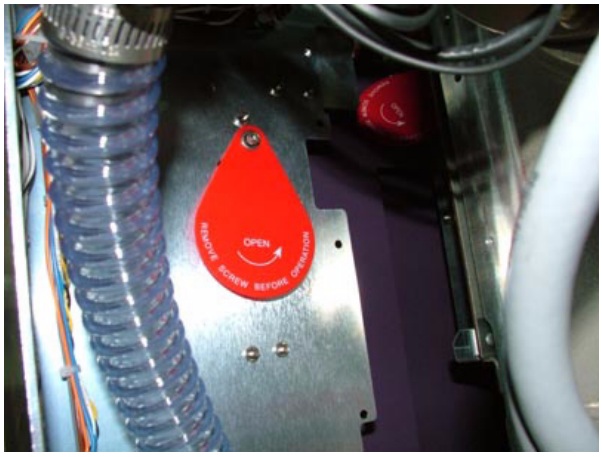


Figure 6: Front panel locking screw

7. To open the front panel, push the button in the middle of the operation bar.

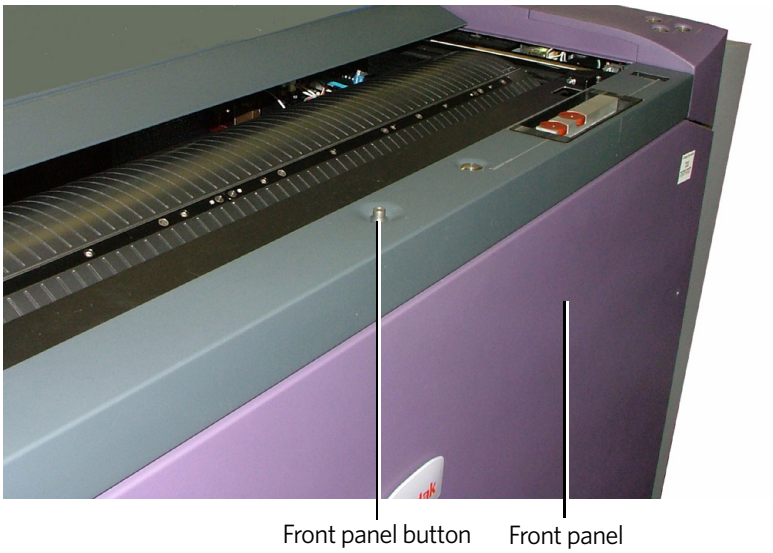


Figure 7: Front panel and front panel button

8. From the front of the platesetter, on each side, remove the roller safeguard.

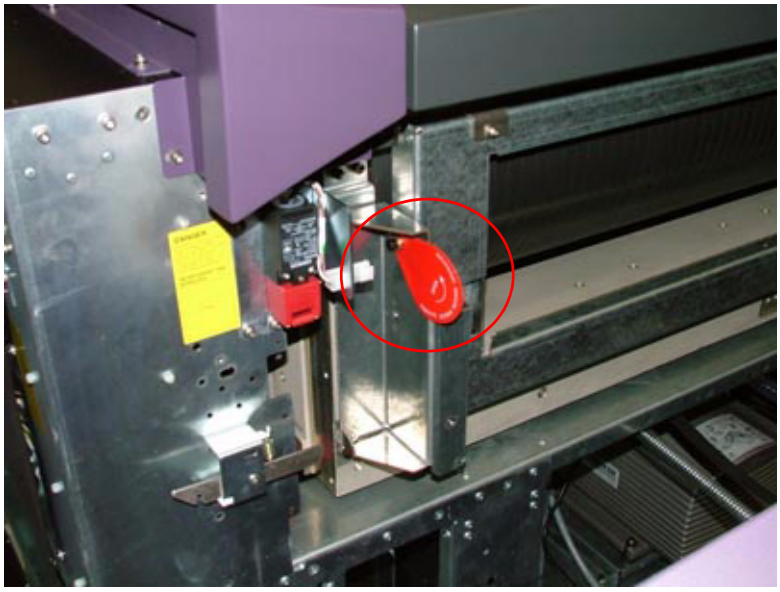


Figure 8: Roller safeguard

9. To open the service door, after the loading table is opened, from the back of the platesetter on both sides, insert a screwdriver or hex key into the hole as shown in Figure 9, and push toward the platesetter.

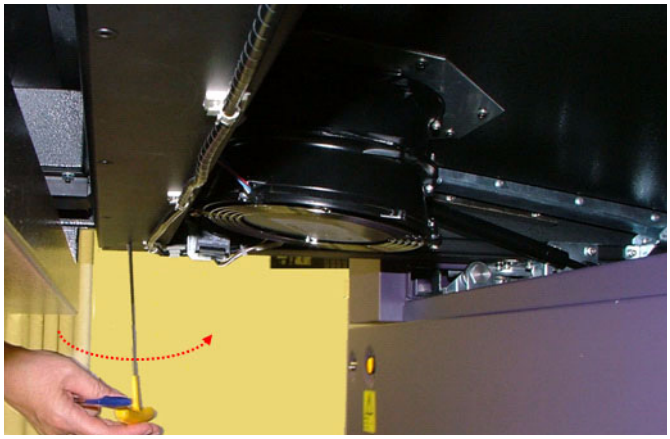


Figure 9: Opening the service door

10. Only after the service door is open, remove the screws that secure the rear panel and open the rear panel.



Figure 10: Rear panel screws

11. Remove the screws from the four safeguards that secure the optomechanic assembly to the mainframe and remove the safeguards.

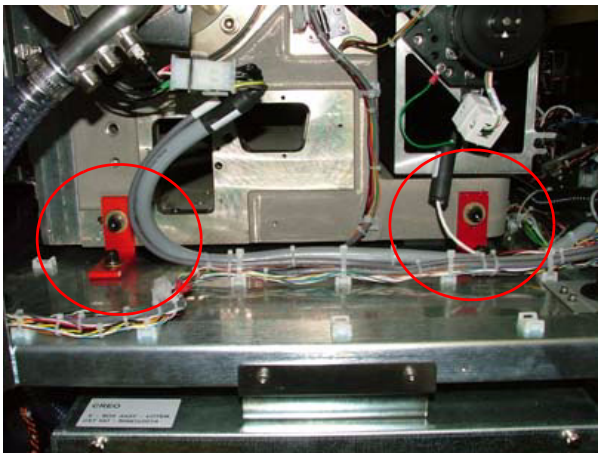


Figure 11: Two optomech-to-mainframe safeguards - left side view

Note: On the left side of the platesetter, the clutch wheel partially obstructs access to one of the optomech-to-mainframe safeguards.

12. Remove the screws from the two safeguards that secure the carriage to the optomechanic assembly and remove the safeguards.

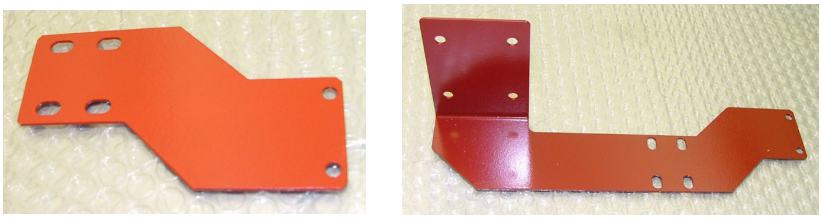


Figure 12: Carriage-to-optomech safeguards

One safeguard is in front of the carriage and one is in back, but you can access both from the back side of the platesetter.

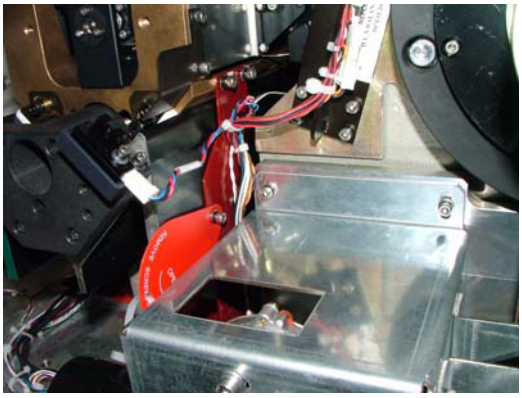


Figure 13: Carriage-to-optomech safeguard - right view

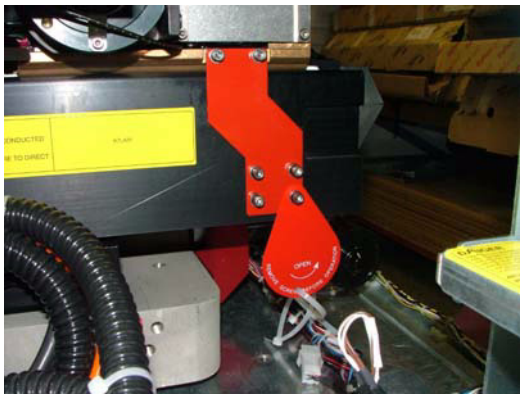


Figure 14: Carriage-to-optomech safeguard - left view

Note: You must remove the carriage safeguards before starting the machine application.

13. Remove the screws from the safeguard that secures the distribution box and remove the safeguard.

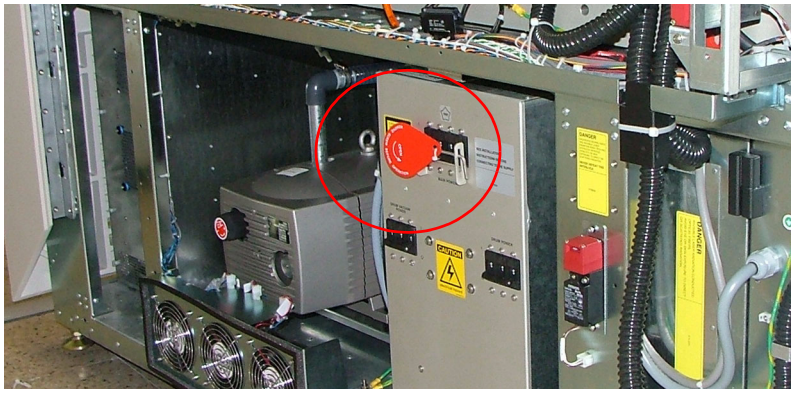


Figure 15: Distribution box safeguard

Note: After removing the safeguards, visually inspect the components inside the machine to confirm that they are undamaged.

Adding Safety Labels

If the safety labels are not in place on the device, affix the labels in the relevant language, as described in the *ThermoFlex Mid II Safety Guidelines* (and in the *ThermoFlex Mid II Hybrid Safety Guidelines* for ThermoFlex Mid II Hybrid With Offset Option, if your device includes the offset option).

Leveling the Platesetter

Final leveling means that the platesetter is positioned on a uniform horizontal plane at all four corners, with all four wheels raised above the floor, to ensure smooth plate loading.

Before you level the platesetter, verify that the following conditions exist:

- All doors can open completely.
- You can access the laser box and other internal components for maintenance work.
- There is adequate room for the UDRC.

To level the platesetter:

1. Place a standard leveling instrument on the main frame side door, and verify that the front and rear of the platesetter are level.
2. If the front and rear are not level, adjust the rear legs. Turn the adjusting nut of one of the rear legs clockwise to increase height, or counterclockwise to reduce height, as required. Then confirm that the device is level, and tighten the locking nut.

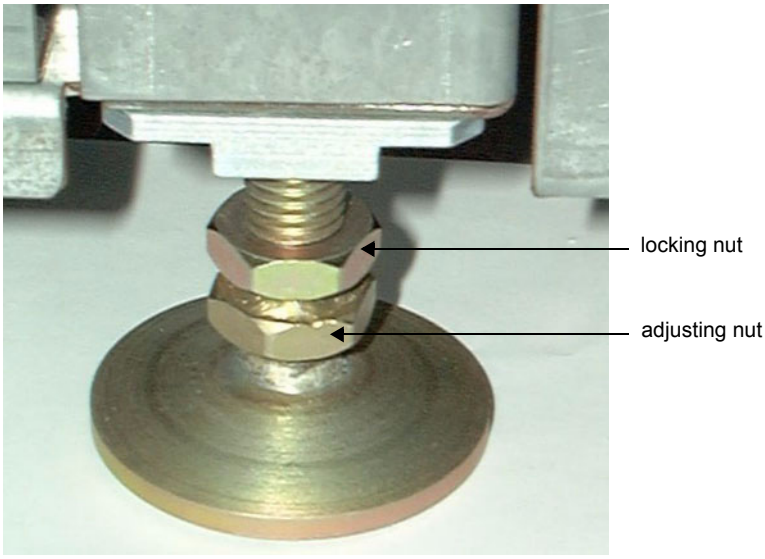


Figure 16: Adjusting leg height

3. After the platesetter is properly leveled, tighten the locking nut on all four legs.

Adding Magnetic Drum Configuration Components

Note: If your configuration does not include the magnetic drum option, proceed to Connecting the External Components and Power on page 13.

If your configuration includes the magnetic drum option, you must add the following two components to the exterior of the device:

- Scrubber pouch—holds the plate scrubbers
- Wide plate stoppage—aligns the plate along the magnetic drum

To add the scrubber pouch:

➢ Place the scrubber pouch on the front panel of the device and insert the scrubbers. The magnetic field holds the scrubber pouch in place.



Figure 17: Magnetic scrubber pouch and scrubbers.

To add the wide stoppage:

➢ On the right side of the loading table, place the wide stoppage along the guide, as shown following, and press down.

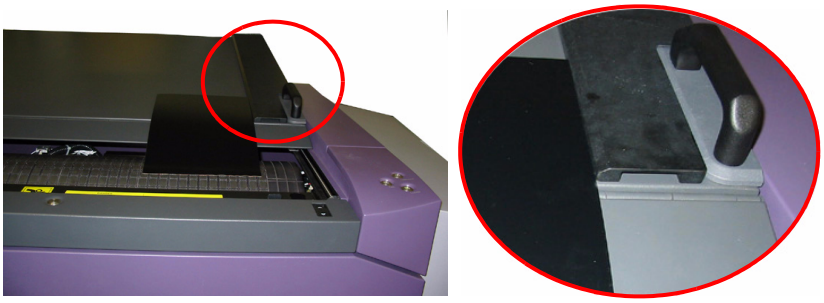


Figure 18: Wide stoppage

Connecting the External Components and Power

Requirements

Before connecting the platesetter to its external components and to the power supply, ensure that your site meets the electrical requirements described in this section, and verify that all voltage settings, fuses and cords fully comply with local standards.

Device voltage	Power supply voltage	Phases	Source	Transformer required
110	110/120	3	device	no
	220/230			yes

Two configurations are available for the ThermoFlex Mid II Hybrid platesetter:

- **60 Hz power output:** Rated voltage must be 3x120 V AC (-6%/+10%) 60 Hz 1.5%
- **50 Hz power output:** Rated voltage must be 3x230 V AC (10%) 50 Hz 1.5%

  Note: To transform the voltage to 3x120 V AC, a transformer is added to the configuration (supplied by Kodak).

The plug on the power cord of the ThermoFlex Mid II Hybrid output device (supplied with the device) is a NEMA 3 pole + N + PE, 5-wire, 250 V, 30 A plug.



Figure 19: NEMA, 3pole + N + PE, 5-wire, 120/208 V, 30 A



Figure 20: IEC-309, 3 pole + N + PE, 5-wire, 400 V, 16 A, 6 o'clock connector (6 o'clock refers to the orientation of the ground connection)

Note: For more information, see the *ThermoFlex Mid II Site Preparation Guide*.

Connecting the Monitor, Mouse, and Keyboard

1. Place the ThermoFlex Controller monitor, keyboard, and mouse on the designated monitor table.

   Note: The connections described following are shown in Figure 21 on page 14. The red lines indicate the connections that are performed during this installation.

2. Connect the keyboard and mouse to the split connector, and then connect the split connector to the E-box.
3. Connect the ThermoFlex monitor to the E-box.
4. Connect the main power cable of the ThermoFlex Controller monitor to the wall socket.

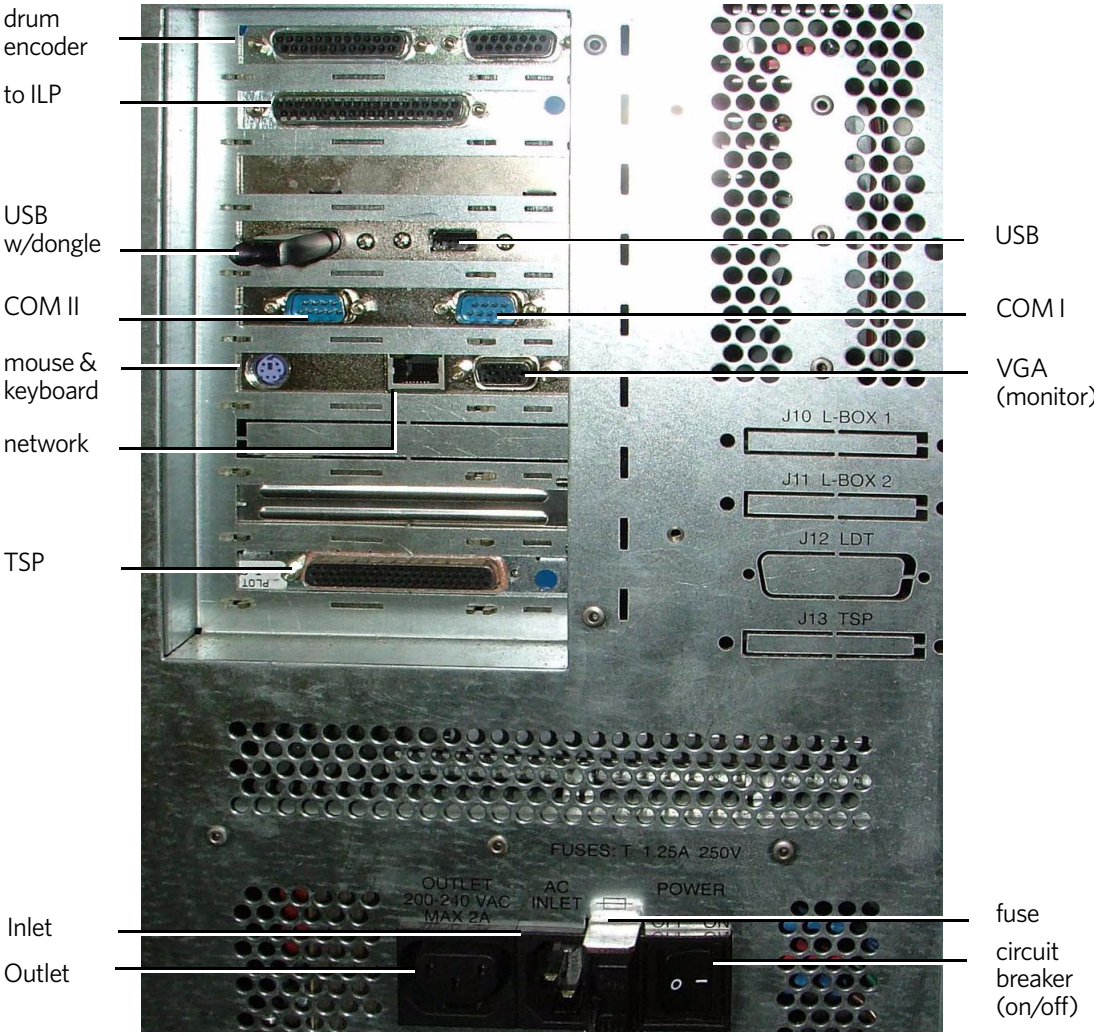


Figure 21: E-box connections

Note: The TSP connection is relevant only when TIFF Front End workflow is installed on the platesetter E-box, and not on an external computer.

Connecting the Universal Debris Removal Cabinet

The ThermoFlex Mid II platesetter is connected to one of the following universal debris removal cabinet (UDRC) options:

- UDRC BF—particulate and chemical filters
- UDRC BP—particulate filter

Note: The UDRC BP must have external venting. See Step 4, following.

To connect the UDRC to the platesetter

1. Position the UDRC as close to the rear of the platesetter as possible.
2. Connect one end of the vacuum hose to the adaptor, and connect the other end of the vacuum hose to the hose extension on the back of the UDRC.

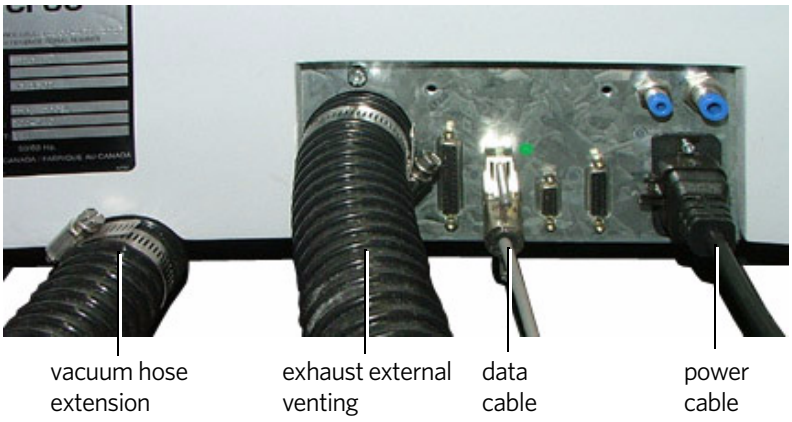


Figure 22: UDRC connection

3. Connect one end of the data cable to the platesetter, and connect the other end of the data cable to the port on the back of the UDRC.
4. If the configuration is UDRC BP, connect the exhaust tube from the UDRC to the exhaust system. (For more information, see the *UDRC Site Preparation Guide*.)
5. Connect the power cable from the socket on the UDRC to the power socket on the wall.

Connecting the Power

Note: If your configuration includes external TIFF FE (TIFF FE software installed on the workflow work station and not on the platesetter computer), proceed to step 2.

1. If yourconfiguration includes internal TIFF FE, connect the dongle, as shown in Figure 21 on page 14.
2. From the back of the platesetter, on the distribution box, locate the main power cable and pull it out through the cable opening on the rear floor of the platesetter.

   Note: You may need to remove the rear trapeze.

3. Connect the platesetter to the power:
   - 110 V power supply: Plug the power cable directly into the wall socket.
   - 220 V power supply: You must connect the power cable to a transformer.
     a. Connect the main power cable to the male 5-pin, 3-phase, neutral and ground cable connector.
     b. Plug the power cable connector into the transformer.
     c. Plug the transformer into the wall socket

Setting Up Data Connectivity

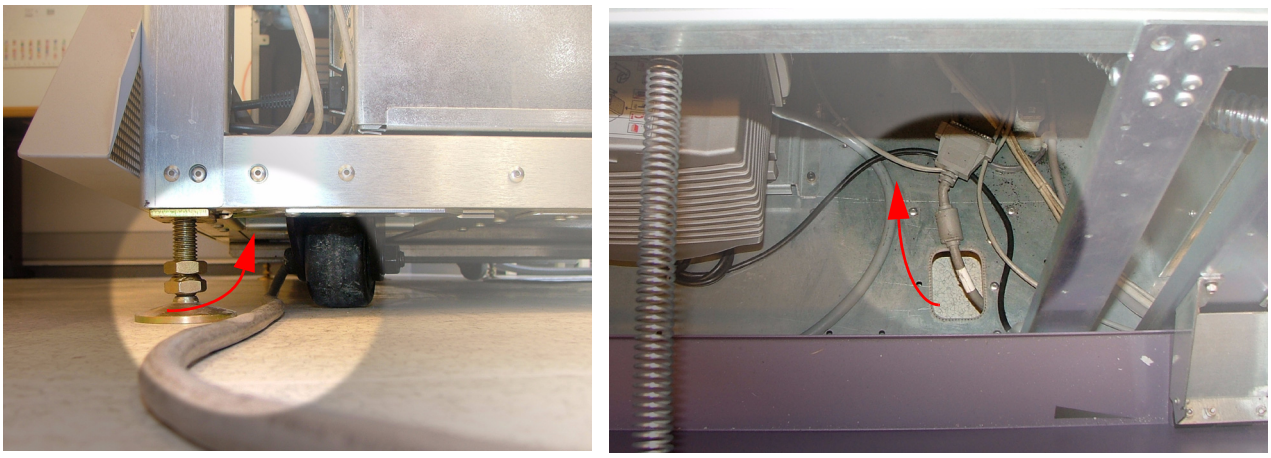
To ensure that the platesetter can communicate with the workflow system, you must take the following steps, described in this section:

- Connect the TSP cable for data transfer
- Set up the TCP/IP link for communication between the ThermoFlex Controller and the workflow solution workstation

To connect the TSP cable:

Note: If your configuration includes internal TIFF FE, connect the TSP cable to the TSP board in the lowest slot in the E-box, and procede to Setting Up the TCP/IP Connection on page 20.

1. Connect one end of the TSP cable to the TSP board on the workstation.
2. Route the TSP cable along the floor and up into the floor of the platesetter on the right front side.



Side view Front view

Figure 23: TSP cable routed into the platesetter

3. Open the rear upper and lower panels and remove the trapeze.

4. To move the distribution box to enable routing the TSP cable:
   a. Open the two hex screws on the top of the distribution box.
   b. Open the two crosshead screws on the side of the distribution box.
   c. Open the distribution box door and remove the two hex screws on the base.

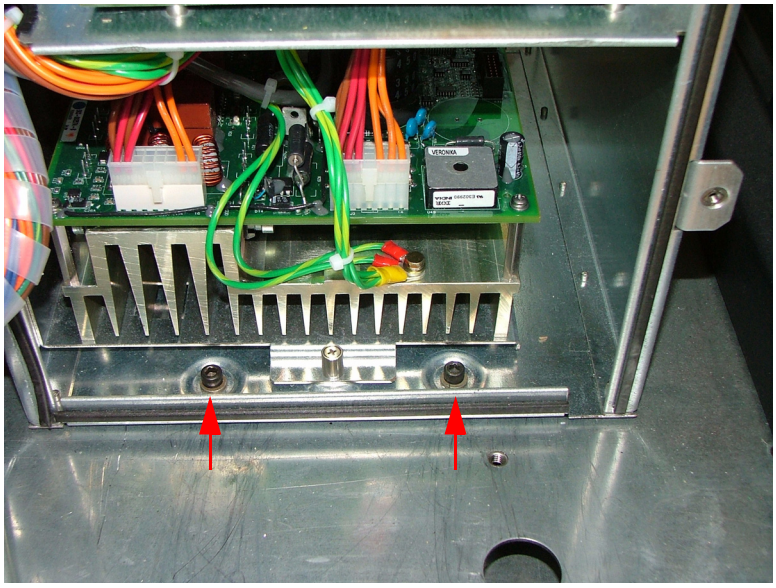


Figure 24: Screws on the distribution box base

   d. Pull the distribution box slightly outward.
5. Route the TSP cable over the distribution box.

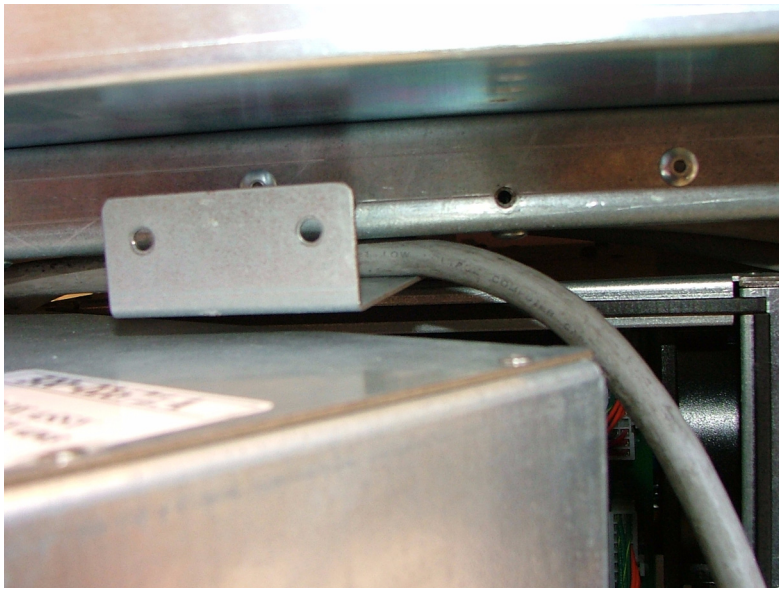


Figure 25: TSP cable routed over the distribution box

6. Open the left side door and left side panel of the platesetter, release the two hex screws that secure the L-box, and then open the L-box.

7. From the rear of the platesetter, check if the TSP cable head fits smoothly through the opening between the black partition and the mainframe. If it cannot fit, remove one of the screws that secures the partition to the mainframe, and push the partition until you can route the TSP cable through.

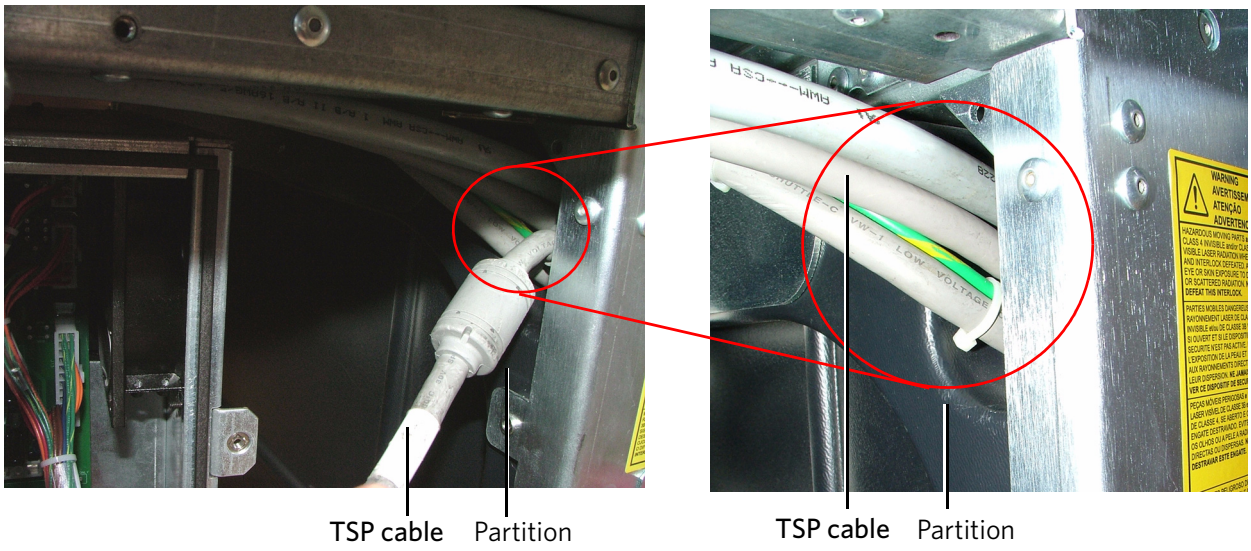


Figure 26: TSP cable routed through the partition

8. On the L-box, cut the cable ties, route the TSP cable together with the main power cable, and secure the two cables with new cable ties.

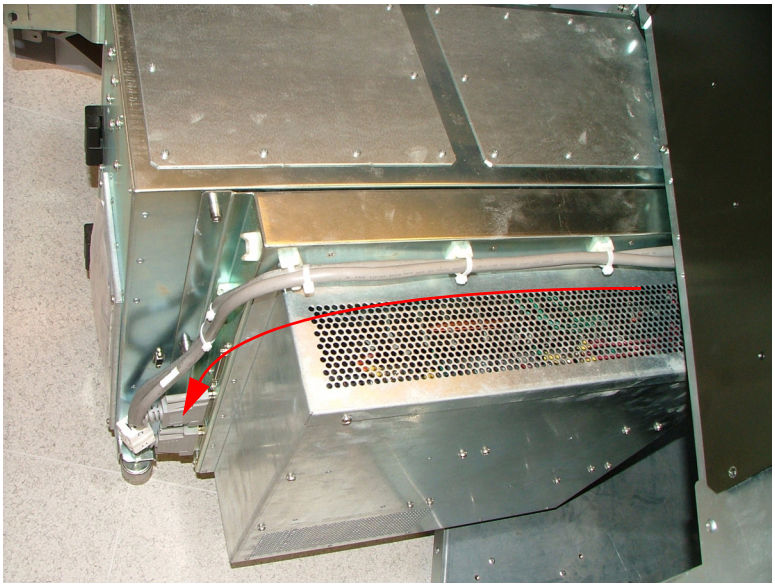


Figure 27: TSP cable routed along the L-box

9. Plug the TSP cable into the E-box, as shown:

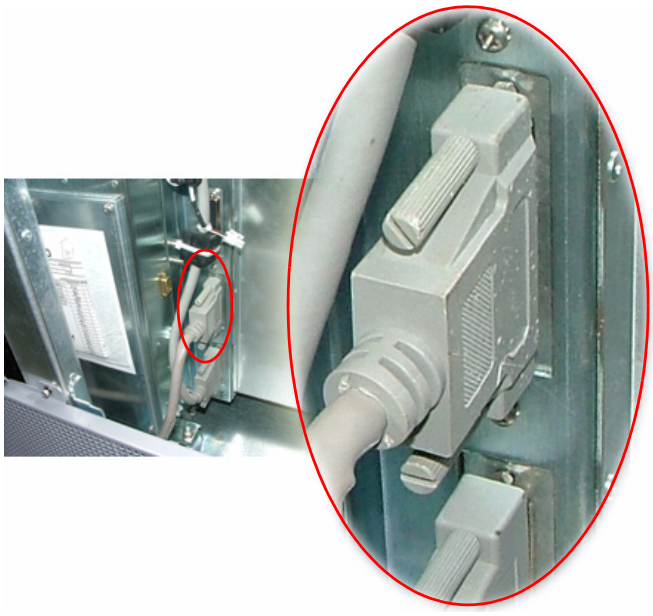


Figure 28: TSP cable connector on E-box

10. Close all open platesetter doors and panels.
11. Turn on the platesetter and confirm that the TIFF Front End software recognizes the platesetter.

Setting Up the TCP/IP Connection

➢ Connect both the workflow solution workstation and the platesetter to the site's network infrastructure.

- ❒ Verify that the workflow solution workstation is connected to the network via the fast ethernet board in slot 2.
- ❒ Connect the network port in the E-box to the communication network switching hub.

Note: Do not to use the point-to-point connection method (connecting the workflow solution workstation directly to the ThermoFlex platesetter) because it does not enable remote support.

Checking the Installation

After installing the platesetter, perform the following tests to confirm that the platesetter is installed properly:

- Confirm that the lens protector is clean. You may need to use a mirror and flashlight to check the lens protector.
- Confirm that the felt in the v-groove is lubricated.
- Confirm that the on/off buttons operate.
- Confirm that the drum vacuum is sucking and not blowing. If the air is blowing, shut down the platesetter, open the transformer, and reset the switch on one of the output phases. Then recheck the vacuum.
- Using a DVM, check the 5 V, -5 V, and 12 V voltages on the E-box.

Setting Customer-specific Parameters

After the platesetter is assembled, you must do the following:

- Check that the focus stopper is properly located
- Confirm that all media-related parameters are correct

  Note: If the device is not the first one installed at the customer site, you must also adjust parameters

- Set media definitions for each media

  Important: Set the proper focus for the thickness of each media that will be used.



WARNING: Before you can set the proper focus for each media thickness, you must move the nozzle as far away from the drum as possible. Failure to move the nozzle as far away from the drum as possible before setting the thickness of each media may cause irrepairable damage to the platesetter!

- Perform ITP testing
- Calculate scale factors

Checking the Focus Stopper Location

The focus stopper must be located so that the optic

To move the focus stopper to the proper location:

1. Move the carriage to any location along the drum.
2. Move the focus motor to the maximum location.
   - For wide focus range, move the focus motor to 5000.
   - For earlier versions, move the focus motor to 2800.

3. On the optic tube stopper, loosen the two hex screws and then move the stopper until the optic tube bracket touches the optic tube.

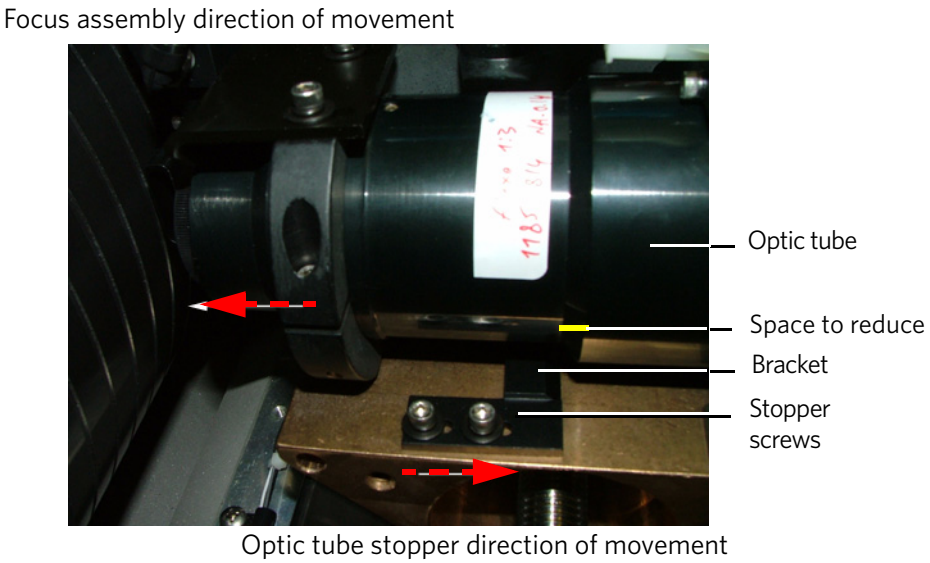


Figure 29: Focus stopper

Note: The red arrows in Figure 29 show the direction of movement.

4. Lock the stopper in place by tightening the two hex screws.

Confirming Database Parameters

During production in the factory, database parameters are set and tested for each type of media that the customer plans to use. A list of these parameters (the Database Parameters document) is included in the installation kit. Check and confirm that the platesetter database parameters match the parameters on the Database Parameters document.

If the focus and drum speed parameter values for each media do not appear on the Database Parameters document, you must perform the focus calibration test for that media.

If the customer plans to use a new type of media that was not included in the list, you must define the media with an estimated focus value, and then perform the focus, drum speed, and coarse and fine resolution calibration tests

Note: These calibration procedures are explained in detail on TechPlanet on the procedures page.

Setting Customer Media Definitions

After the platesetter is assembled, you must set the customer media definitions in the software for each media that the customer plans to use.

To set media definitions:

1. Confirm that the media with which the customer plans to work is approved by Kodak.
2. In ThermoFlex Controller, select **Settings > Media Definitions**.
3. In the Media Definitions dialog box, click **New** to clear the media definitions boxes.

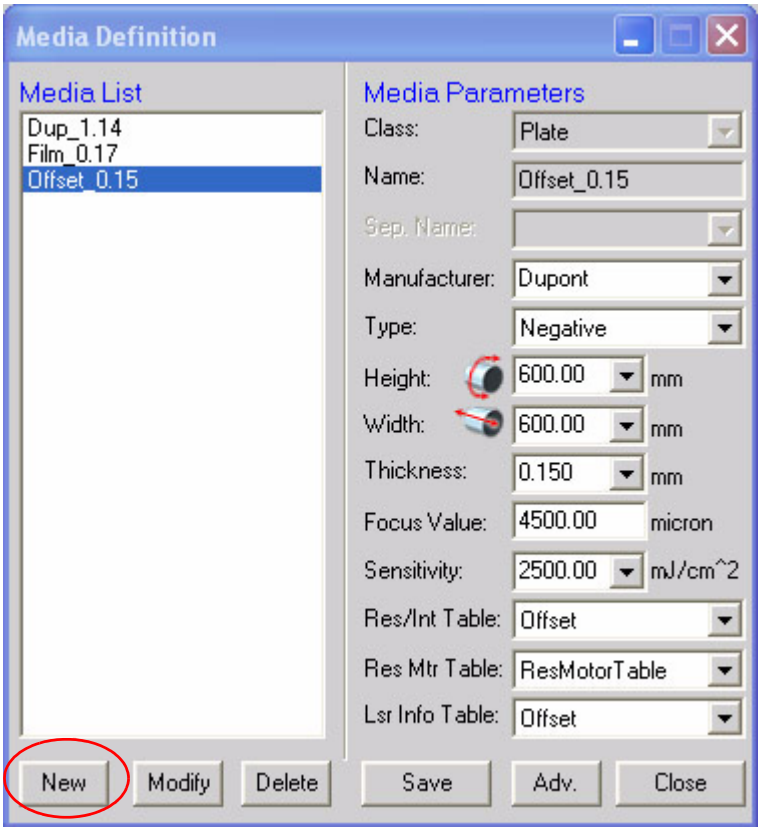


Figure 30: Media Definitions dialog box

4. In the Media Definitions dialog box, set the relevant definitions for the customer's media.

Parameter	Setting
Class	Plate
Name	Media name
Manufacturer	Media manufacturer
Type	Negative
Height	Plate height
Width	Plate width
Focus Value	In the Database Parameters document included in the installation kit, find the correct focus value according to the media type. If required, calibrate the focus value as described in the Focus Calibration Test procedure in TechPlanet.
Sensitivity	2500.00
Res/Int Table	Resolution intensity table according to the type of media used
Res Mtr Table	Resolution motor table
Lsr Info Table	Laser information table

5. Access the Media Advanced Properties dialog box:

   a. Click the background of the ThermoFlex Controller software's main window, and press <CTRL>+<U>.

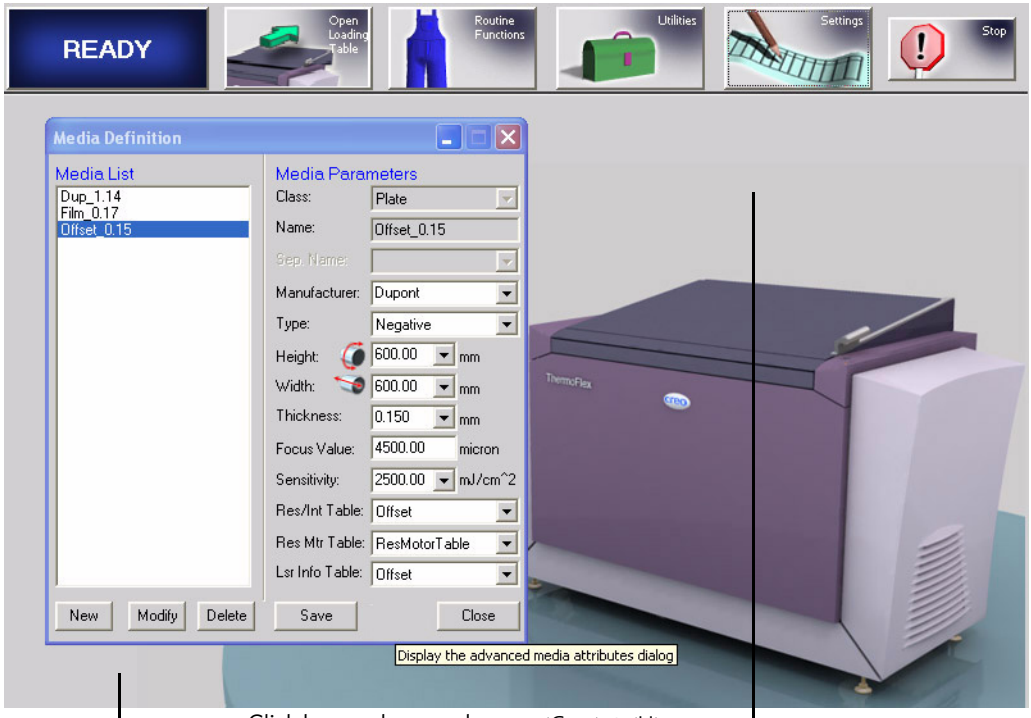


Figure 31: Accessing the Media Advanced Properties dialog box

   b. Click the **Adv.** (advanced) button.



Figure 32: Adv. (advanced) button

6. In the dialog box, set the relevant settings for the customer's media (as described in the table on page 27), and then click **Save**.

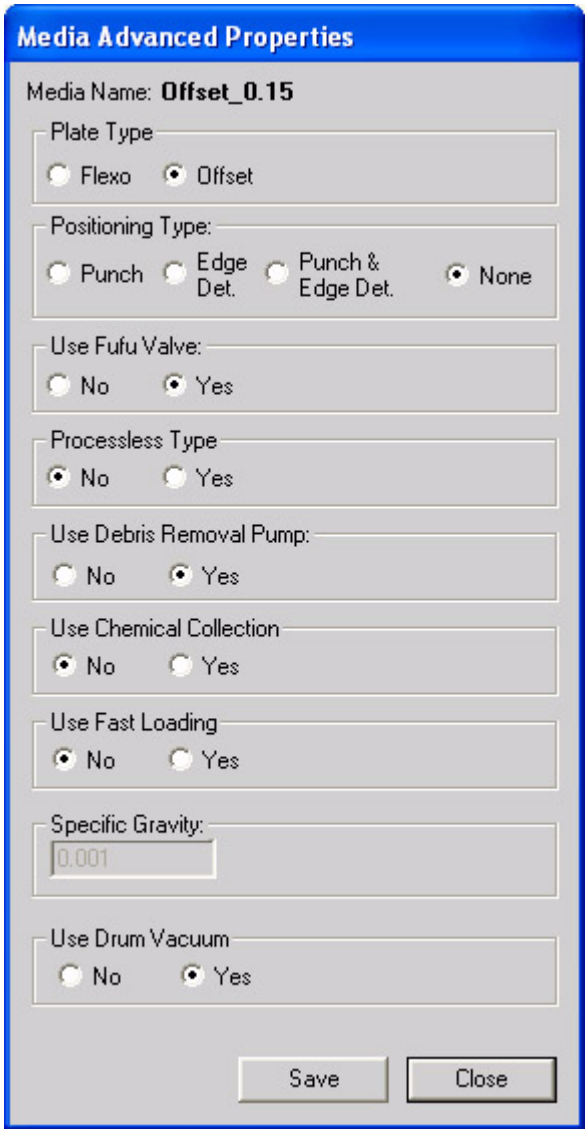


Figure 33: Media Advanced Properties dialog box, showing settings for an Offset plate

Table 3: Media Advanced Properties parameter settings

Parameter	Setting	
Plate Type	Flexo	Offset
Positioning Type	None	None
Use Fufu Value	None	Per media type
Processless Type	None	Per media type
Use Debris Removal Pump	Yes	Yes
Use Chemical Collection	Per UDRC type: BP = no, BF = yes	
Use Fast Loading	No	No
Use Drum Vacuum	Yes[a]	Yes

a. For steel-backed flexo plates, select **No**.

Performing the Installation Testing Procedure Testing

Perform the Installation Testing Procedure (ITP) and have the customer sign the Installation Testing Procedure Checklist (ITPC). If the ITP is not successful, you may need to perform the calibration tests, as described on TechPlanet on the Procedures page.

Calculating Scale Factors

Flexo plates are composed of a polyester base layer that is 0.005" (0.127 mm) thick, and a polymer layer of varying thickness.

Note: Letterpress plates are 0.010" (0.25 mm) thick.

When a flexo plate is loaded onto the drum, the polyester layer retains its original size while the polymer layer stretches around the drum. There is no stretching along the width of the drum. The thicker the plate, the greater the diameter of the exposed area.

- A thin flexo plate wrapped around the drum has a smaller circumference than that of a thick plate.
- A thick flexo plate wrapped around the drum has a larger circumference than that of a thin plate.

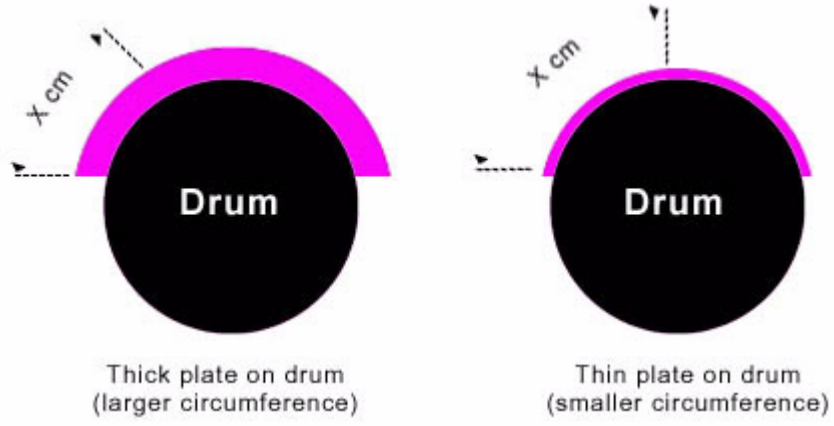


Figure 34: Difference in circumference of thick and thin plates wrapped around the drum

The different circumferences can lead to image distortion in which an exposed image is smaller than the expected outcome.

When the plate is removed and placed upon a flat surface, the exposed area shrinks to its original size, which is smaller than the exposed area on the drum. However, the ThermoFlex Controller software takes into account the plate thickness measurements and the drum diameter to calculate the scale factor (SF). The result provides you with a very precise file size in relation to the exposed area.

Note: The LD factor is calibrated on the production line. The value should appear as **Width Factor** in the ThermoFlex Controller registry.

To ensure that the exposed image is the same size as the expected outcome, calculate the scale factor corresponding to the plate thickness using the scale factor formula, and enter the scale factor into the workflow software.

$$\text{Scale Factor} = \frac{(\text{expose diameter} \times 100)}{(\text{expose diameter} - 2\text{x soft thickness})}$$

- Scale factor = The figure entered into the workstation in order to compensate for image distortions. Accuracy is to the nearest thousandth decimal place.
- Expose diameter = Drum diameter + (2x plate thickness)

  Note: On the ThermoFlex Mid flexograph, the drum diameter will remain constant at 328 (mm).

- Soft thickness = Plate thickness subtracted from the polyester base thickness

  Note: On the ThermoFlex Mid flexograph, the polyester base thickness will remain constant at 0.127 (mm).

Example:

$$\text{Scale Factor} = \frac{100\ (328^{1} + 2\text{x}1.7^{2})}{(328 + 2\text{x}1.7) - 2(1.7 - 0.127^{3})}$$

$$\text{Scale Factor} = 100.959$$

[1] drum diameter, [2] plate thickness, [3] polyester base

Note: An automatic scale factor calculation tool can be found on TechPlanet.

Appendix A: Parts and Tools List

Part no.	Description	Qty
344F10120	Black plastic hose	5
620B00104	Safety filter bag	2
620B00105	Preliminary filter bag	2
620B00106	High eff filter submicron	1
388B2800	Clamp STST 2"x.56"	2
374A8L079	Label: Do not lift from here	2
399Z1P411D	Lotem 800 parameters	1
518-01413A	Flex mid accessories kit	1

Table 4: Parts list

Tools:

- Light table
- Plate measuring device such as FAG Vipflex or X-RiteDot®
- Film densitometer
- Calliper to measure plate thickness
- Flexographic plates
- Tape (recommended by Creo: 3M®-471 or tesa® 60760)
- Cutting table

Appendix B: Customer Onsite Training Checklist

Before leaving the site, verify that the customer uderstands and can perform the following basic operations:

- Observing safety precautions
- Operating the device application (GUI)
- Loading, unloading, and media handling
- Exposing and media definition setup
- Performing basic maintenance (PM)
- Troubleshooting common customer-level problems
- Verify that customer has, or is aware of the equipment required in *Appendix C: Equipment Supplied By Customer* on page 32.

Appendix C: Equipment Supplied By Customer

- Light table
- Plate measuring device (such as FAG Vipflex or X-RiteDot)
- Film densitometer
- Calliper to measure plate thickness
- Flexographic plates
- Cutting table
- Gloves for plate handling
- **Tape**:
  - For flexo plates: PVC tape 1 in. black—3M #471 or tesa 60760 tape recommended
  - For offset (metal) plates: Aluminum foil tape W=1.5—3M #425 Aluminum Foil Tape (No. 427 linered version, part number 401C10010) recommended

Appendix D: Packing the Platesetter for Shipment

A minimum of two people and a forklift are required to pack the platesetter and place it on the shipping pallet. See Figure 35 on page 34. The numbers in the instructions below refer to the item numbers shown in the figure.

1. Disconnect all the electrical cables from the platesetter and remove the skirting boards from the front, rear, and sides.
2. Disassemble the loading tray and brackets [2].
3. If the forklift cannot be moved to the platesetter location, roll the platesetter to the shipping pallet. To do so, on each leg, turn the nut counterclockwise to its maximum position until the wheels touch the floor and then roll the platesetter to the shipping pallet.
4. Place the two lower shipping beams [6] on the shipping pallet [7] above the main shock-absorbing beams.
5. Using the forklift, lift the machine and place it on the shipping beams, aligned according to the securing bracket holes.
6. Secure the machine to the shipping pallet using the four brackets, screws, and washers [8].
7. After confirming that the platesetter is positioned and secured properly, cover the platesetter with nylon wrapping.
8. Pack the skirting boards in bubbled nylon and place them behind the platesetter. Secure them with plastic tape [1].
9. Staple the side wooden struts [5] to the shipping beams [6].
10. Staple the top wooden struts [3] to the side wooden struts [5].
11. Place an outer carton container [2] on the platesetter. Use staples to secure the outer carton to the shipping pallet [7] and side wooden struts.
12. Close the top flaps of the outer carton.
13. Close the outer carton with plastic tape and with two steel bands.

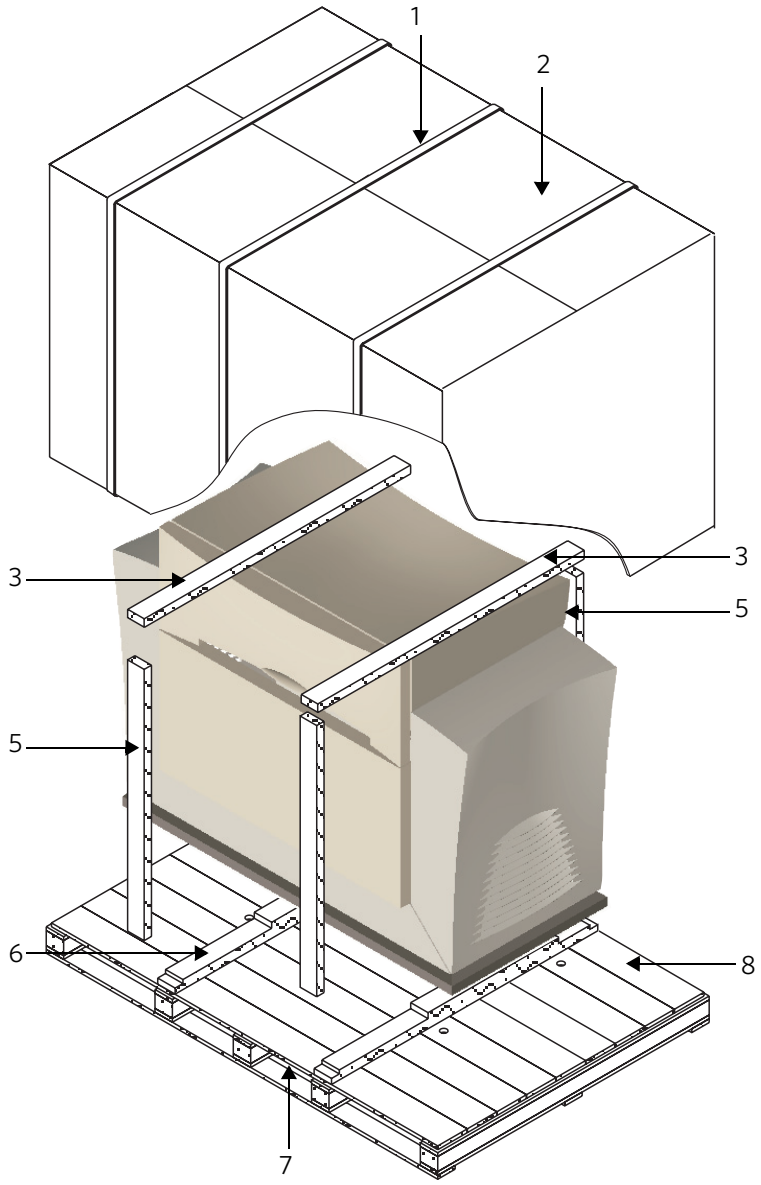


Figure 35: Packing the platesetter for shipment