CREO

Creo Products Inc.

Engineering Change Order

ECO#: C444

Originator: SMON **Page:** 1

Department: ENG **Date: 10/6/98**

Engineering Changes

Part #	Rev/Status From	To	Description	Product	ECRs	Back Comp?	Reason for chg.	Serv. Class	Prod. Class
50-1550A	F	G	Kit mech hook up	Ta-auto			1		4
57-5523A	PRE	A	Brkt, picker u-track	Ts-auto		N	1	F	4
50-1448A	N	P	Picker Assembly	Ts-auto		Y	1	F	4
57-4640A	F	G	Picker Track-right	Ts-auto		Y	1	F	4
57-4760A	F	G	Picker track-left	Ts-auto		Y	1	F	4
57-4805B	A	B	Cable track mounting brkt	Ts-auto		Y	1	F	4
57-4878A	J	K	Picker cross bar	Ts-auto		Y	1	F	4
57-4879A	F	G	Picker suction bar	Ts-auto		Y	1	F	4
57-4877A	F	G	Picker pad	Ts-auto		Y	1	F	4
57-4849A	J	K	Bridge picker suction bar	Ts-auto		Y	1	F	4
72-0026A	D	E	TRACK AS #8 ON 100 LABEL	Ts-auto					

Copies To:	Title:	Signature:	Date:	Code Descriptions			
	Design Eng.	Scott Montague	18/August/29	Status	Service	Production	Reason
	Production Eng.			AC - ACTIVE IN - INACTIVE OB - OBSOLETE PR - PREREL.	R-RETROFIT S-NEXT CALL F-NEXT FAIL T-THEIR COST N-NOT UP-GRADABLE NA-NOT APPL.	1-RETROFIT ALL UNITS 2-FINISHED GOODS 3-WIP 4-FUTURE 5-DOCUMENT ONLY	1-DESIGN 2-MANUFACT 3-ASSEMBLY 4-DOCUMENT 5-COST 6-MAINT. 7-RELAIBIL. 8-SOFTWARE 9-OTHER
	Field Service Eng.						
	Project Eng.						
	Project Manager						
	Product Manager						

Details of Problem and the Changes

The picker has tight tolerances in its setup procedure for correct operation. These changes greatly improve this by mounting the top of the picker u-tracks directly to the load table. Greater clearances between the picker and the load ramp are also achieved for manual bypass. Contingency was left to mount the rails exactly as they were before incase unforeseen problems occur.

Track this change with #8 on the 100 label

Documentation Changes

Part #	Rev/Status		Documents							
	From	To	Type	Status/Resp.	Type	Status/Resp	Type	Status/Resp	Type	Status/Resp
72-0026A	D	E								
50-1448A	N	P	Ad	Up/smon						
57-4849A	K	J	DD	Up/smon						
57-4879A	F	G	DD	Up/smon						
57-4878A	J	K	DD	At/smon						
57-4805B	A	B	DD	At/smon						
57-4640A	F	G	DD	At/smon						
57-4760A	F	G	DD	At/smon						
57-5523A	Pre	A	DD	At/smon						
57-4877A	F	G	DD	At/smon						

Status Codes: AT- Udated document is attached RL- Redlined document is attached UP- No document attached, update will follow NC- No changes required to document
Resp.: NAME-four letter Creo employee who is/was responsible for updating the document

Field Upgrade Intructions:

On recent machines the picker is simply bolted in place using eight M5x12 sock caps and washers. For earlier machines the 2 mounting pems in the load table are missing. Attach the picker using the very bottom hole in the u-track and the lower hole in the engine frame. Mark where the u-track brackets land on the load table and drill M5 clearance holes. Secure the picker in place with M5 nylock nuts. Adjust the load table so that the plate ledge is inline with the load ramp within 0.5 mm using a straight edge. Adjust the picker jack screws to ensure that the plate does not catch the plate ledge on the load table and at the same time does not scrape down the trailing edge clamps on the back bone. Remove the roller and observe the plate entering the leading edge clamps. The plate should strike the drum at least 5mm above the clamps.