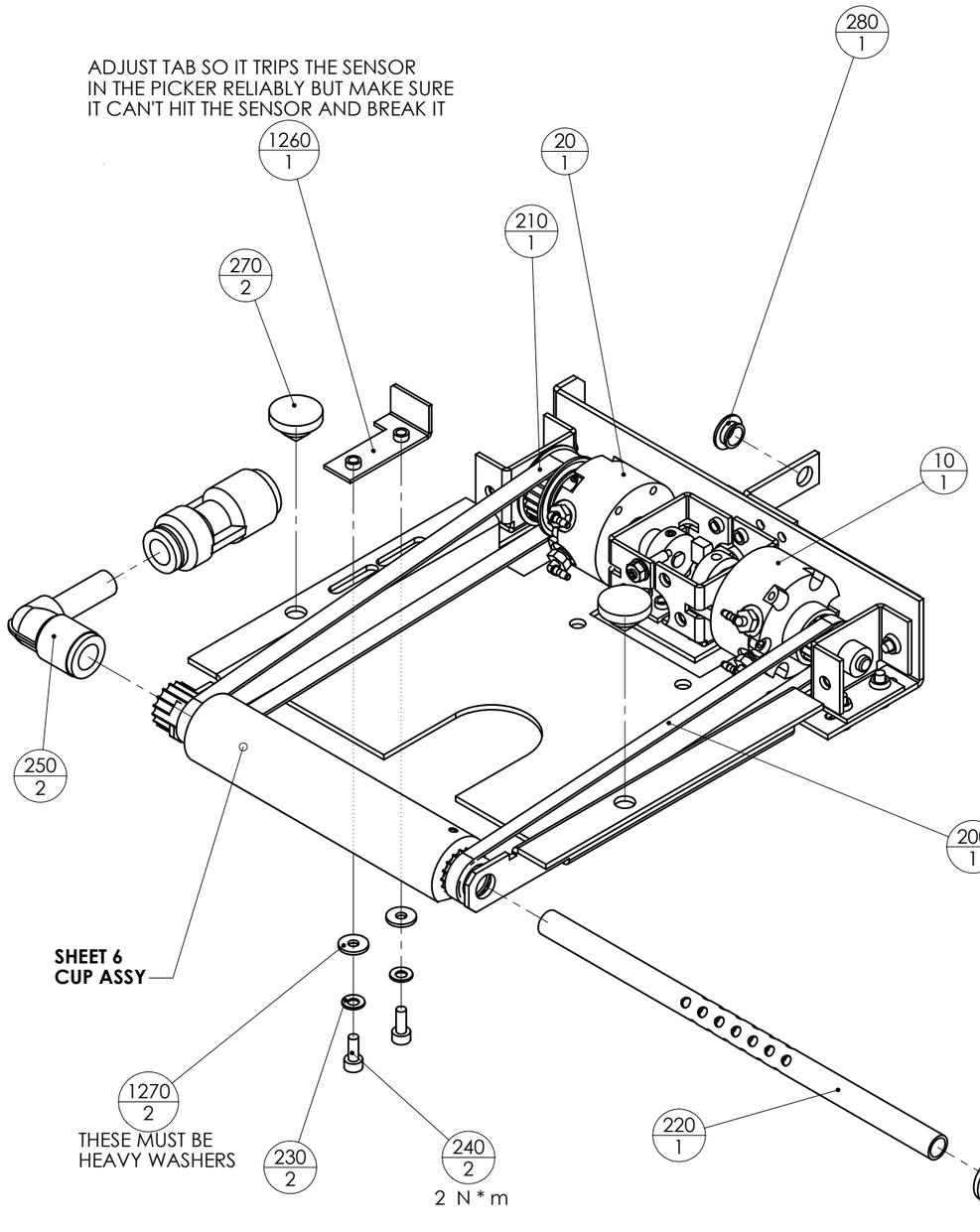
REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY
-	-	-	-	-
A	E628	2002:MAY:16	I.PRESS	D.MAKCAY

NOTES:

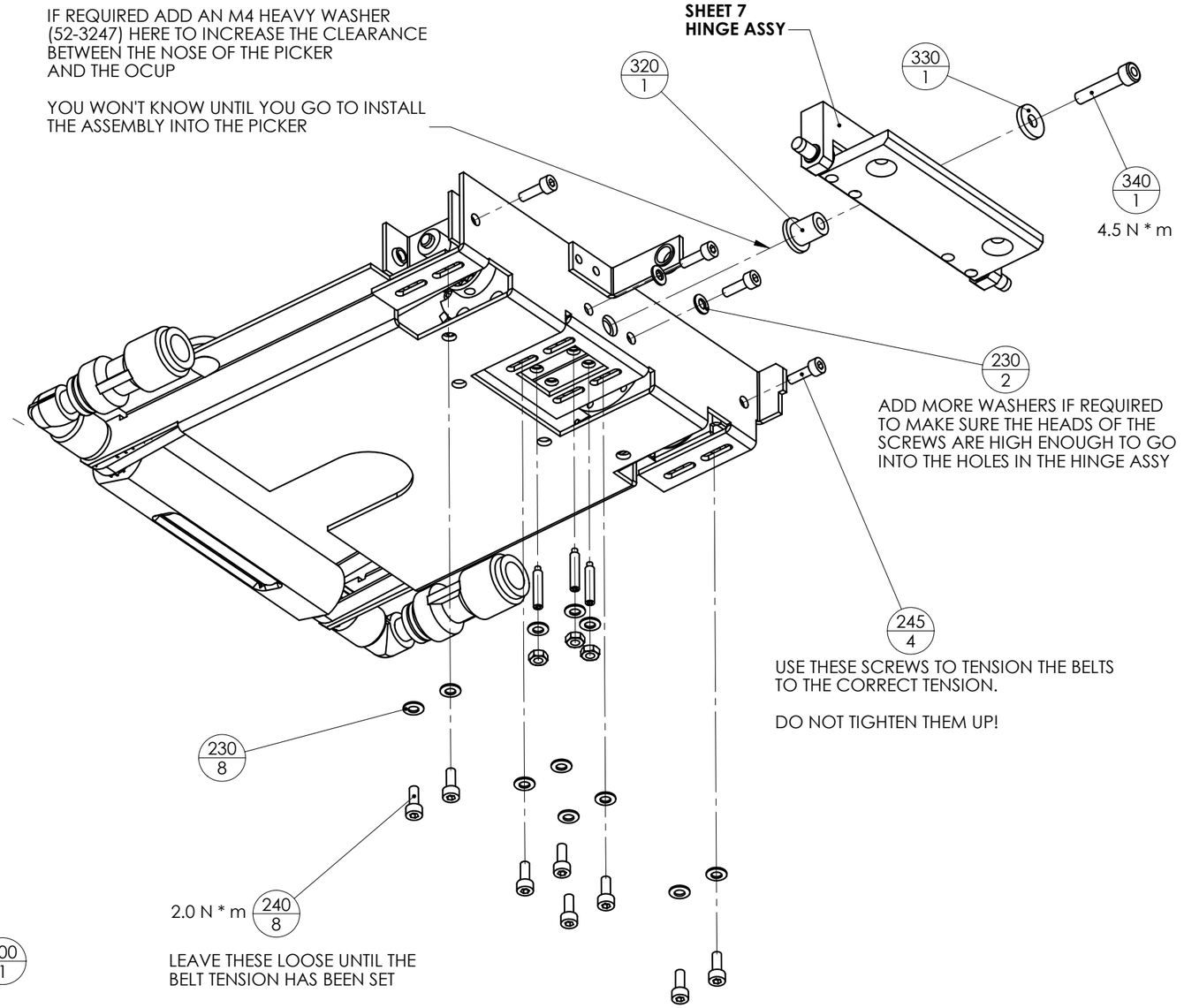
1) THE ONLY CHANGE IN VERSION D IS THE ADDITION OF THE SENSOR TAB (ITEM 1260)

ADJUST TAB SO IT TRIPS THE SENSOR IN THE PICKER RELIABLY BUT MAKE SURE IT CAN'T HIT THE SENSOR AND BREAK IT



IF REQUIRED ADD AN M4 HEAVY WASHER (52-3247) HERE TO INCREASE THE CLEARANCE BETWEEN THE NOSE OF THE PICKER AND THE OCUP

YOU WON'T KNOW UNTIL YOU GO TO INSTALL THE ASSEMBLY INTO THE PICKER



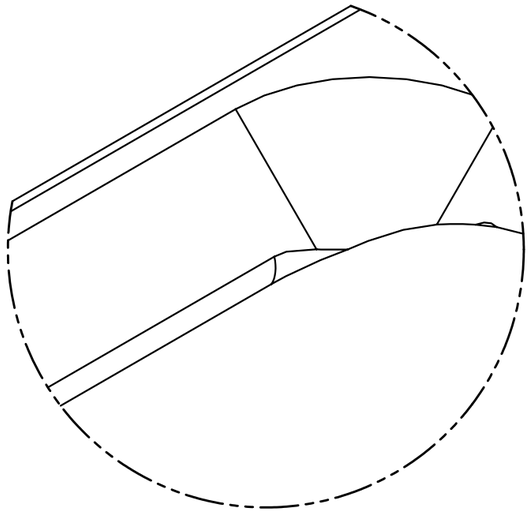
**** USE NO LOC-TITE ON THIS ASSEMBLY UNLESS NOTED**

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ASSY,MECH, SLIPSHEET PICKER, VAL

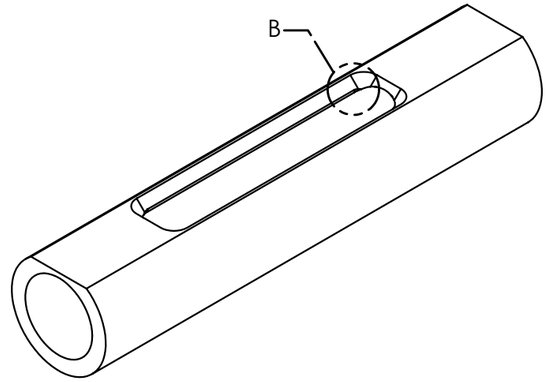
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J DAHLGREN	D WOODBURN		
MILLIMETERS UNLESS SPECIFIED	DATE: 2001:JAN:15	SIZE B	SCALE 1:1.75

PART NO.	REV	DOC	SHEET	OF
50-1743D	A	AD	1	8



DETAIL B
SCALE 10 : 1

BEFORE DEBURRING

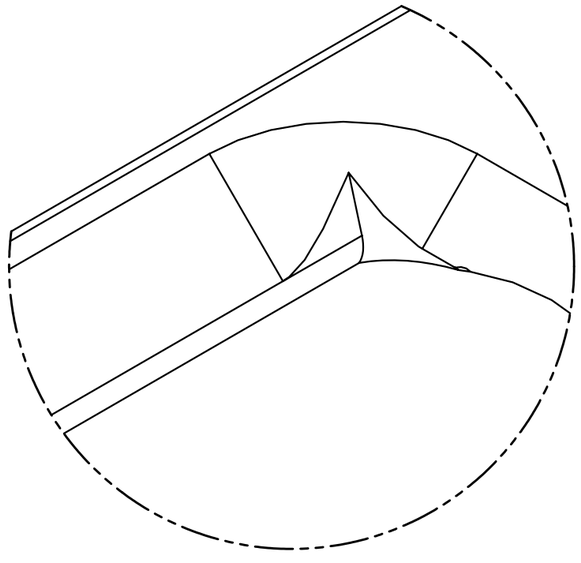


DEBURRING INSTRUCTIONS:

ALL 4 CORNERS OF THE PART MUST BE SQUARED OFF

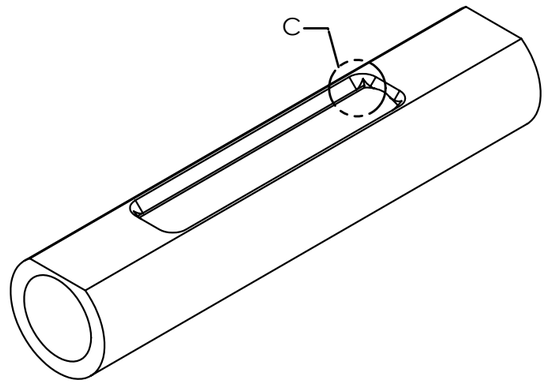
STEP 1) USE THE CHISEL AS SHOWN IN PHOTOS #1 AND #2 TO MAKE
THE FIRST CUTS
KEEP THE BACK OF THE CHISEL FLAT ON THE SIDE
OF THE ORIFICE AS SHOWN IN PHOTO #2.
PHOTO #3 SHOWS WHAT THE PART SHOULD LOOK LIKE

STEP 2) USING A SHARP EXACTO KNIFE, SQUARE OFF THE CORNERS
AS SHOWN IN PHOTO #4.
TRY TO GET THE PART TO LOOK EXACTLY LIKE DETAIL 'C'



DETAIL C
SCALE 10 : 1

AFTER DEBURRING



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OCUP CUTTING

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PART NO.	REV	DOC	SHEET	OF
50-1743D	A	AD	2	8



PHOTO #1

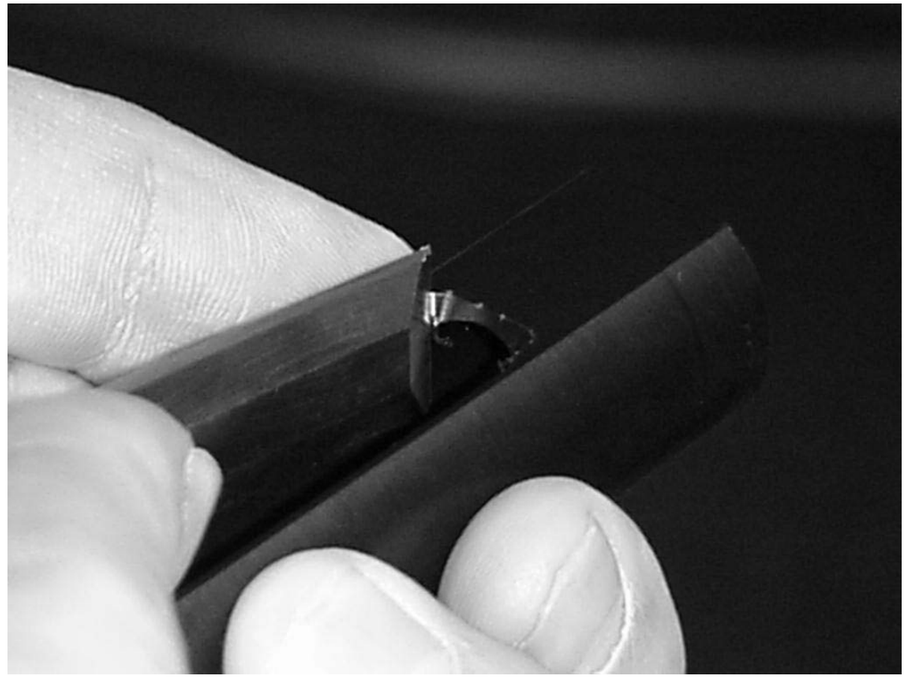


PHOTO #2

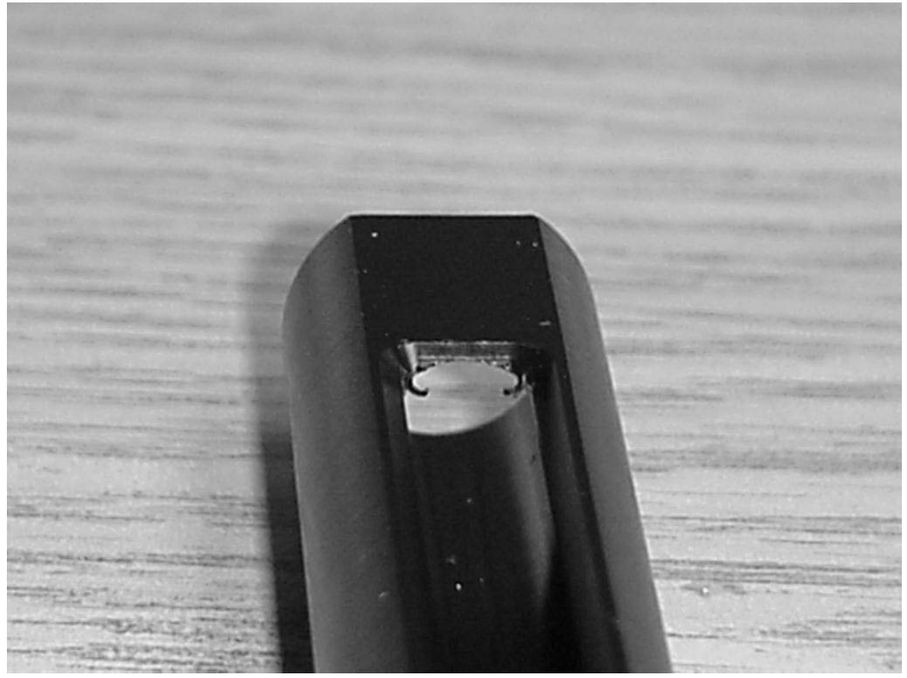
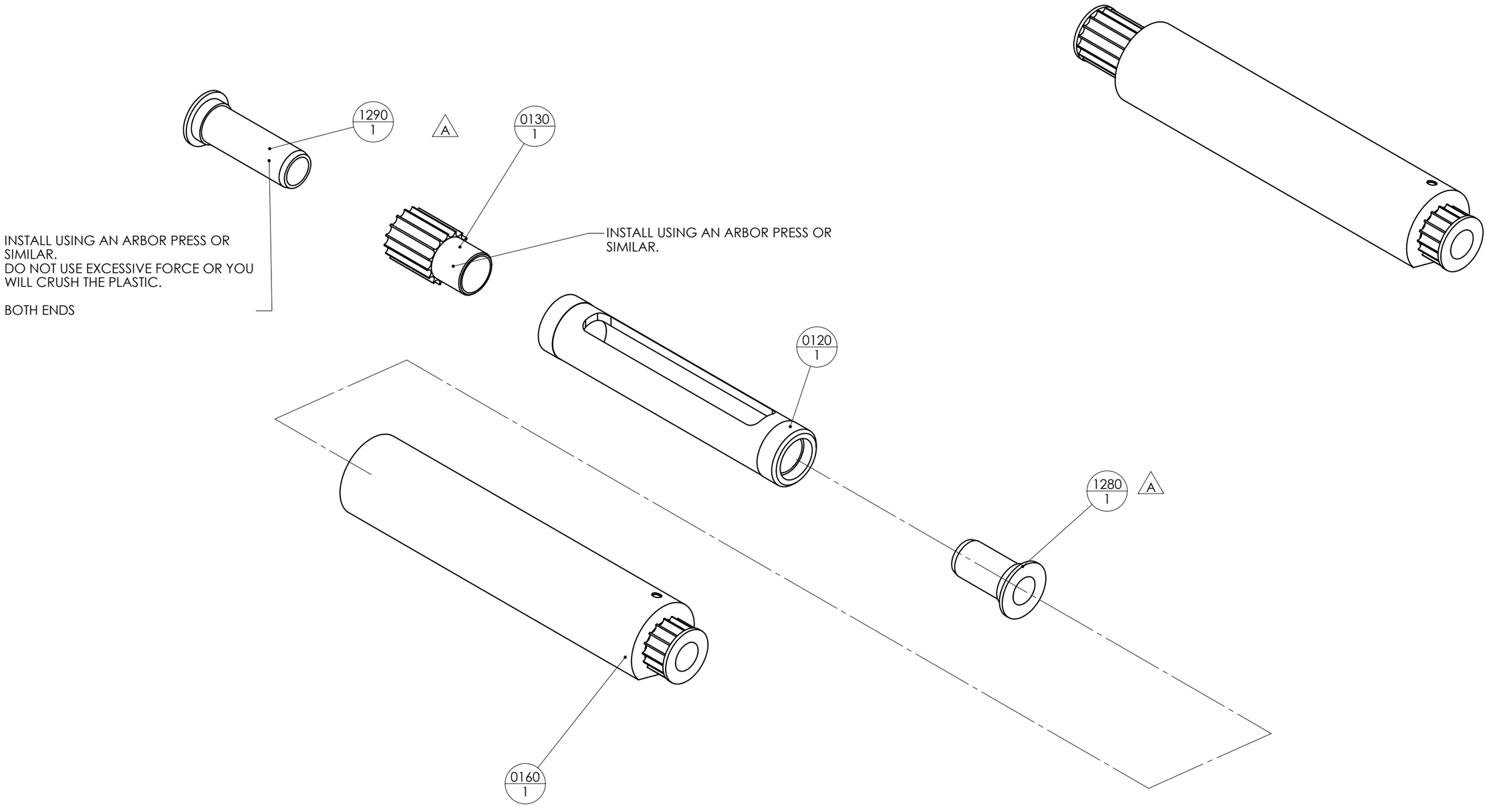


PHOTO #3



PHOTO #4



A NOTE:
REAM BUSHING WITH 8.0mm REAMER AFTER INSTALLATION.
WHEN HELD VERTICALY,FRICTION SHOULD BE JUST SUFFICIENT
TO HOLD THE INNER BEARING TUBE (57-7639B-C) FROM FALLING THOUGH.

A DELETED : ITEM #0140 AND #0150 ;
ADDED : ITEM #1280 AND #1290

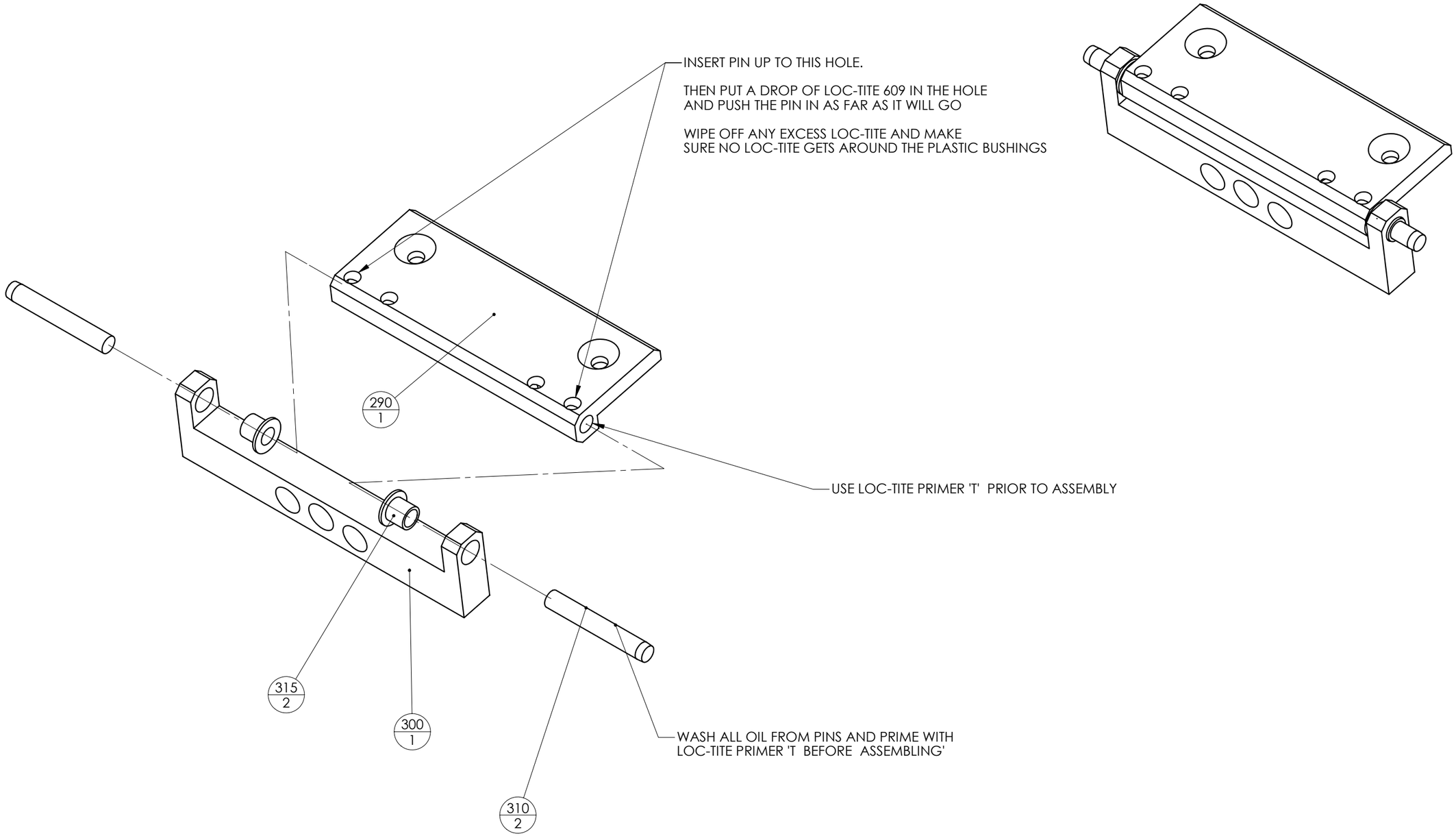
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CUP ASSY

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PART NO.	REV	DOC	SHEET	OF
50-1743D	A	AD	4	8

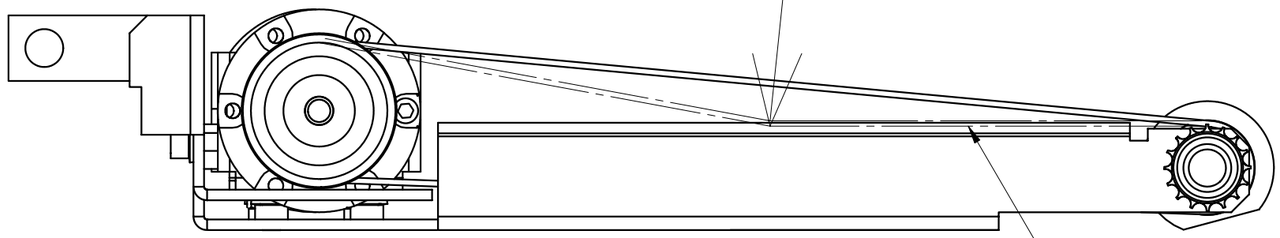


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HINGE ASSY

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PART NO. 50-1743D	REV A	DOC AD	SHEET 5	OF 8

△A 0.3 POUNDS

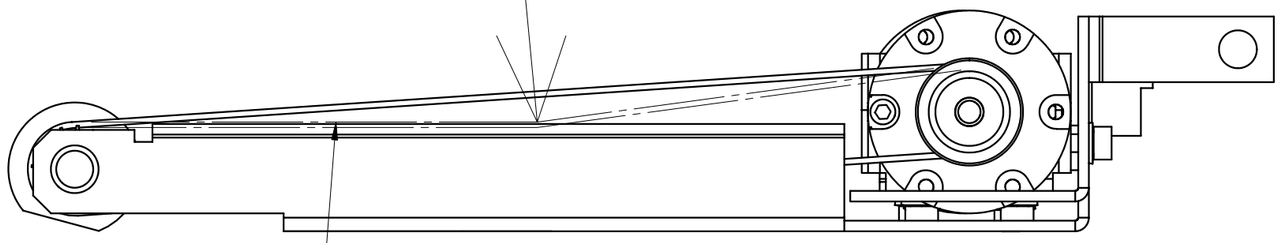


OCUP BELT TENSION

TENSION IS CORRECT WHEN BELT IS HORIZONTAL UNDER THE SPECIFIED FORCE

USE SIDE OF THE FRAME AS A REFERNECE FOR HORIZONTAL

△A 0.3 POUNDS



TENSION IS CORRECT WHEN BELT IS HORIZONTAL UNDER THE SPECIFIED FORCE

USE SIDE OF THE FRAME AS A REFERNECE FOR HORIZONTAL

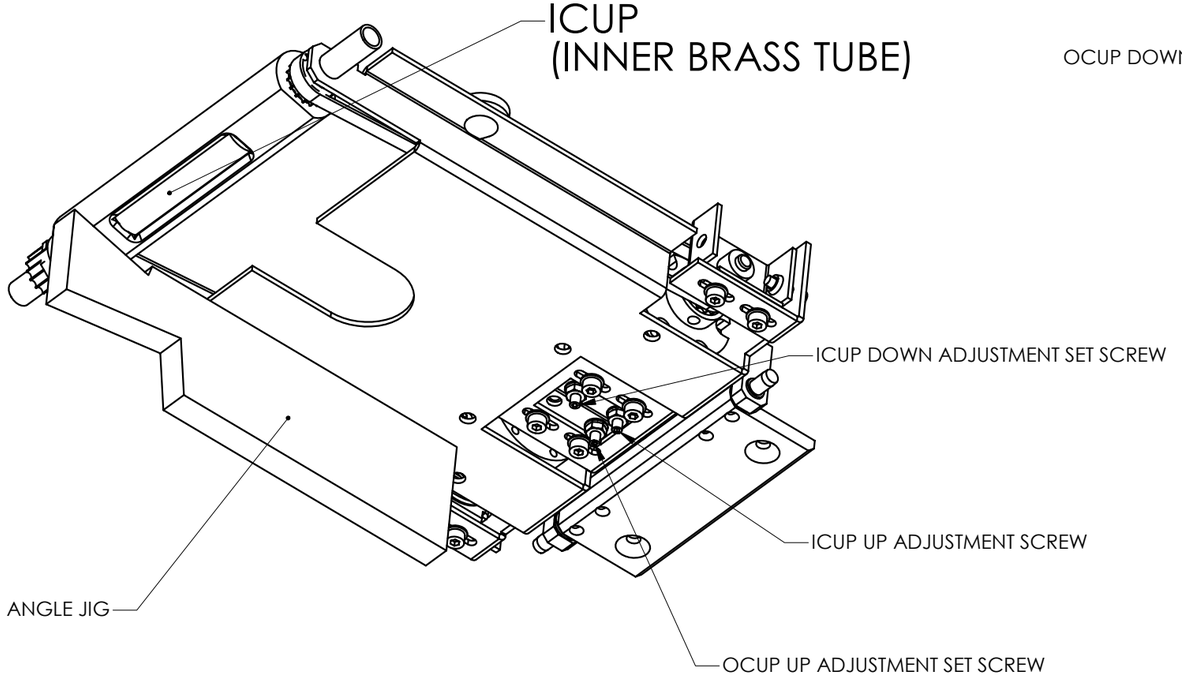
ICUP BELT TENSION

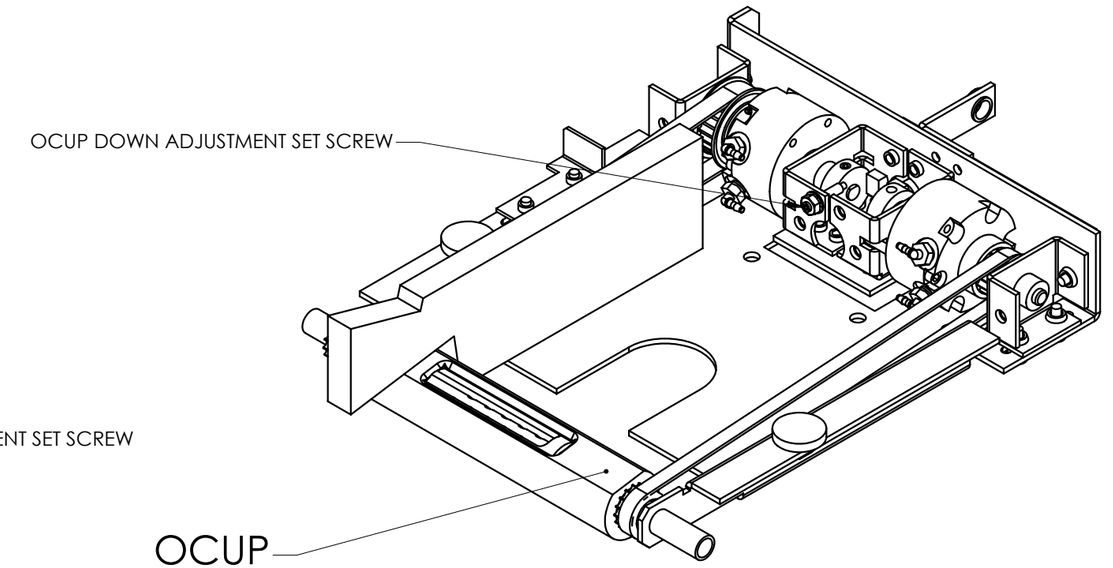
CREO

BELT TENSIONING

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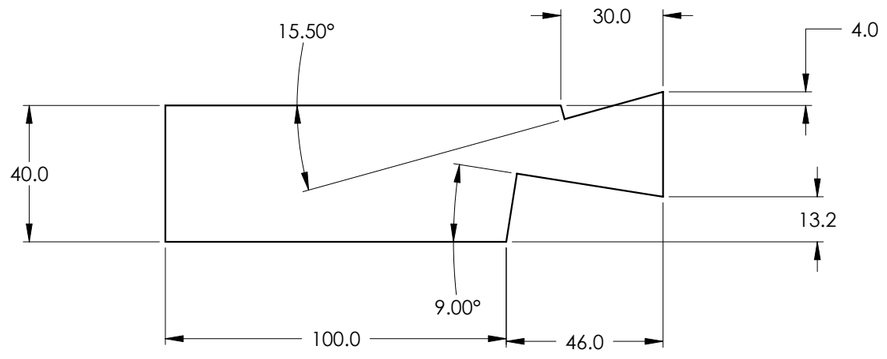
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PART NO. 50-1743D	REV A	DOC AD	SHEET 6	OF 8





SETTING OCUP UP POSITION

SETTING OCUP DOWN POSITION



ANGLE JIG

PROCEDURE:

1) ADJUST THE ANGLES OF THE OCUP FIRST. USE THE ANGLE JIG AS SHOWN AND USE THE ADJUSTMENT SCREWS TO GET THE ANGLES CORRECT. THIS ADJUSTMENT MUST BE DONE WITH THE CYLINDER UNDER REGULAR 80 PSI PRESSURE!!

2) WHEN SATISFIED, TIGHTEN UP THE M3 JAM NUTS FOR THE OCUP AND THEN RE-CHECK THE ANGLES. THE TIGHENING ACTION CAN CAUSE THE SET SCREWS TO ROTATE THROWING THE ADJUSTMENT OUT. DO NOT OVERTIGHTEN THE NUTS OR THEY WILL BREAK THE SET SCREWS!

3) NOW ADJUST THE ICUP IN THE SAME MANNER. NO ANGLE JIG IS REQUIRED FOR THIS. JUST MAKE SURE THE OPENING OF THE ICUP LINES UP WITH THE OPENING IN THE OCUP IN BOTH THE UP AND DOWN POSITIONS.

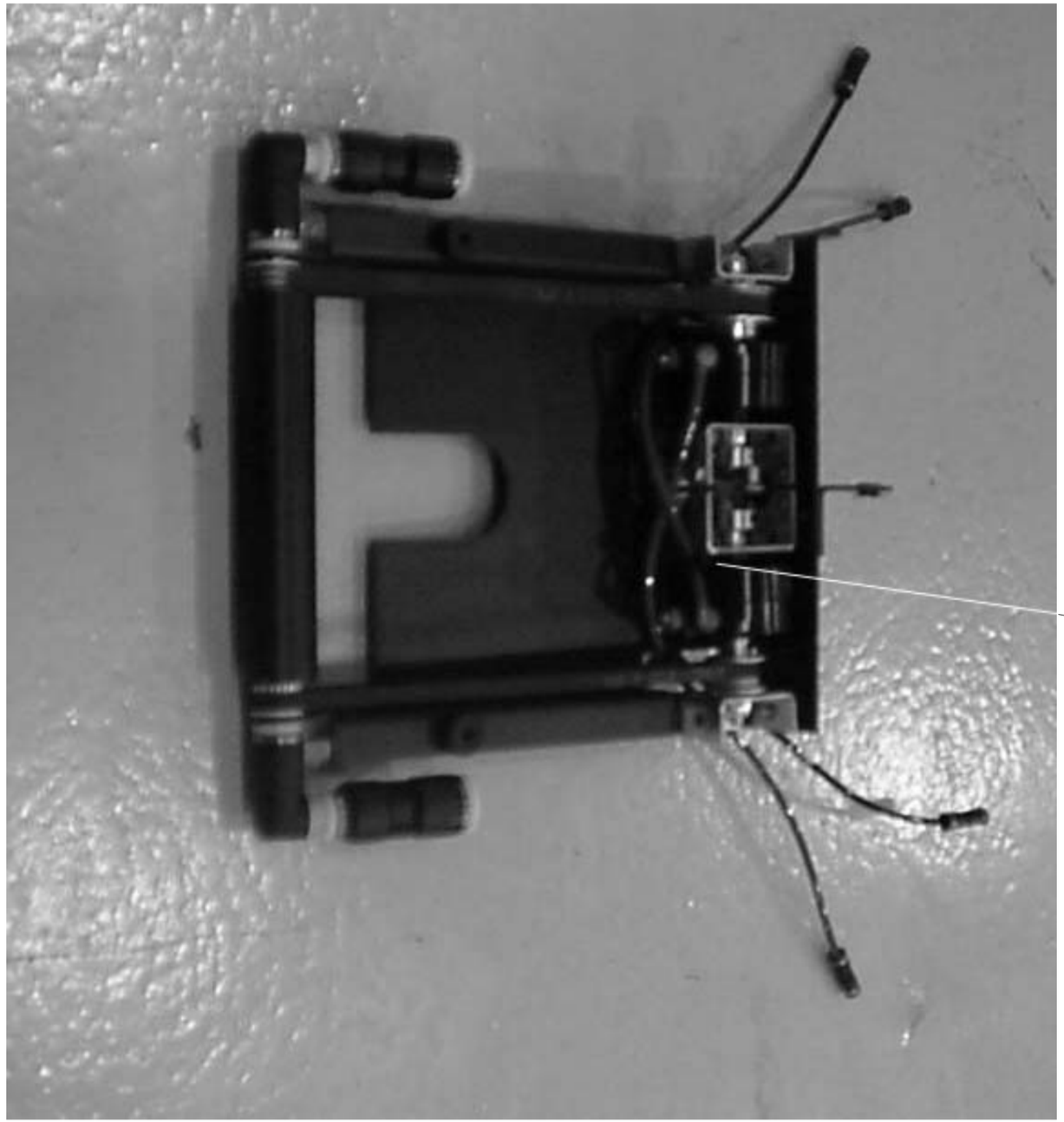
4) TIGHTEN UP THE M3 JAM NUTS AGAIN CHECKING THE ANGLES TO MAKE SURE THEY ARE CORRECT AFTER TIGHTENING. DO NOT OVERTIGHTEN THE NUTS OR THEY WILL BREAK THE SET SCREWS!

CREO

CUP ADJUSTMENT

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PART NO. 50-1743D	REV A	DOC AD	SHEET 7	OF 8



INSTALL 3MM HOSES AND UNIONS AS SHOWN.

TIE WRAP HOSES AS SHOWN AND LEAVE ENOUGH LENGTH ON THE HOSES SO THEY CAN BE TRIMMED AFTER THE ASSEMBLY IS PUT IN THE PICKER

NOTE:

1) THE SENSOR TAB (ITEM 1260) IS NOT SHOWN IN THIS PHOTOGRAPH AS IT IS AN OLD PICTURE

USE SMALL TIE WRAP TO PREVENT THIS HOSE FROM HITTING THE LASER SENSOR IN THE PICKER

CREO

HOSE ROUTING DETAIL

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