Kodak

Magnus VLF

Leading Edge Clamp Funnel Upgrade

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Revision History

Revision	Date	Author	Comments
1	05 Jul 2006	Julian Chia	Draft version
2	06 Dec 2006	A.Blignaut	Edited and formatted
B	13 November 2007	J. Chia	Corrected part numbers for the Engine Manifold upgrade.
C	03 Jul 2008	A.Blignaut	Corrections from Al Edge – kit numbers and part numbers updated or corrected.

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1. OVERVIEW

The Leading Edge Clamp (LEC) Funnel upgrade is to improve plate loading of large wavy plates. It will also address the variability of the LEC opening.

The LEC Funnel assembly actuates on the Trailing Edge Clamp (TEC) backbone during loading. The funnel helps to guide plates with waves that are greater than 3 mm at the leading edge.

2. PREREQUISITES

- MDRC/Funnel wiring upgrade (kit 518-02044A as per FCO CA10199). Refer to document 719-00917A on TechPlanet.
  This upgrade is factory installed on MT242 and later.

3. PARTS/TOOLS

Parts:

- Upgrade kit – 512-00406A (includes some tools/jigs)
- Loctite 242

Tools:

- Metric and imperial hex key sets
- Adjustable wrench

4. INSTALLING THE LEC FUNNEL

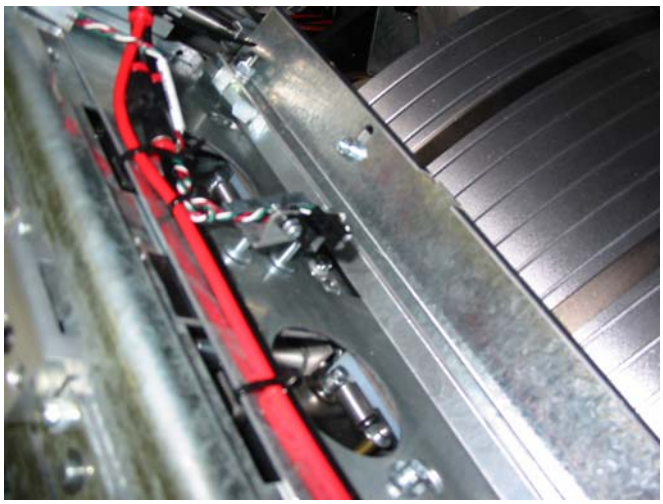
1. Partly thread in two M5 screws into the front face of the backbone, close to either ends.
2. Position the LEC funnel assembly onto the backbone by lining up the key slot holes to the M5 screws.
3. Install the remaining four M4 screws with heavy washers—do not tighten them yet.
4. Remove and reinstall the two M5 screws with Bellville washers. Tighten the screws with the assembly at the highest position.
5. Adjusting the funnel to drum gap.

6. Position the drum and backbone to the loaded position:
   Type `>>hwconfig lecfunnel enable`
   Type `>>drum move 97.002`
   Type `>>backbone horizontalload`
   Type `>>LEC ON`
   Type `>>lecfunnel dn`

Note: On devices with the punch option installed, move the backbone to the tilted unload position and raise the punch assembly to the service position.

7. Place the 3.2 mm thickness gauge spacer under the funnel at the middle of the drum.

8. Place a 4.0 mm thickness gauge spacer under the funnel in front of LEC number 1 and the other in front of LEC number 10.



9. Tighten all six mounting screws.

4.1 Adjusting the Funnel to LEC Gap

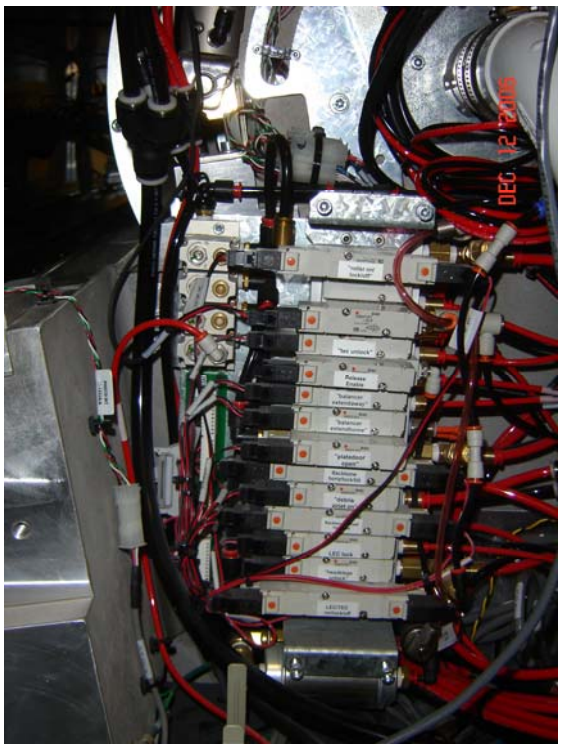
1. Loosen the funnel mounting screws and slide the funnel up against the LECs.
2. Back the funnel away from the clamps approximately 0.3 mm or just until the funnel is clear from the LECs.
3. Tighten the screws



5. UPGRADING THE ENGINE MANIFOLD

1. Remove the panels to access the main engine manifold.
2. Remove the blanking cover for **head air**. Also remove the two way splitter.
3. Attach the new modified header manifold (252-13308A) to the engine manifold, at the location where the head air cover was removed.
4. Attach the valve (55-0771) on the modified header.
5. Connect the air splitter (55-0391) to the 1/8” npt port on the modified header.
6. Reconnect all the air supply lines to the header and plug the remaining unused ports.
7. Connect a male adaptor (55-0084) to the manifold using a 7/64 in. hex key. Be careful to fully insert the hex key.

8. Attach Funnel up down to the controlled ports on the engine manifold. The completed modification should look as follows:



Upgrade complete

9. Ensure that the MDRC/Funnel wiring upgrade has been done and connect the LEC funnel sensor.

6. UPGRADING THE WORKSTATION

1. Upgrade to controlled release 4.0 or later.
2. Type >>`hwconfig lecfunnel enable` to enable the LEC funnel.

7. REPLACING THE LEADING EDGE CLAMPS

Note: Use a piece of foam and a piece of wood to jam the drum so it stays in a comfortable position during this operation. Engage he safety stop so that it is not possible for the device to move.

1. Remove the old clamps being careful not to strip the socket.
2. Install the new clamps
3. Reset the gaps using the tools provided.