Beta FPL MCU Cassette Latch Upgrade

This document describes the procedure for installing the cassette latches on the Beta Flush Plate Loading MCU's. Some tools are included in the tool kit, the required tools not included in the kit are:
Electric Variable Speed Drill
Tap Oil (tap oil is best, but any lubricant can be used)
Hex Key Set (need 3mm and 4mm)
Safety Glasses (for drilling operations)
Center Punch

Upgrade Procedure

This procedure will take 1 person most of one day to complete. The cassettes must be removed from the MCU, this will require the help of at least 1 (preferably 3) other people. The device can be run normally throughout most of the procedure with the following exceptions:
a) While the cart is being upgraded cassettes cannot be reloaded.
b) While the cassettes are being reworked, at least one cassette will be offline.

1. Rework Cassettes

i. Remove the cassettes, one at a time, from the MCU. This will require a minimum of 2 people, 4 people is best. To remove a cassette, with the cart in the home (fully in) position type:
>>cassette unload <cassette number>
ii. Stack each cassette on a sturdy table, upside down with access to the front edge the cassette (this is where the cassette rework is required).
iii. Place the jig (690-00483A) on the cassette and align the 5/8" hole in the cassette with the 5/8" hole in the jig. Use the pem nuts as guides to locate and drill four 4.2mm holes in the bottom of the cassette. Do not drill the holes through the top sheet.
iv. Use the M5 tap to tap all five 4.2mm holes to M5. Use oil on the tap and be careful not to go to fast or to go too deep in the four bottom holes. Tap through on the front hole.
v. Clean all of the debris and oil from the cassettes and work area.
vi. Attach 2 cassette latch catches (252-08338A) to the bottom of each cassette. Use the provided M5 Bellville washers and M5x12 screws. Apply Loctite 242 to the Screws.
vii. Reload the cassette. If the cart is in the home position type:
>>cassette cartpin up
>>cassette door open
pull the cassette to the park position then type:
>>cassette door close
>>cassette cartpin down
The cart is now in the park position (if it is already there start here). Place the cassette on the cart and type:
>>cassette load <cassette number>
viii. Repeat this with the remaining cassettes.

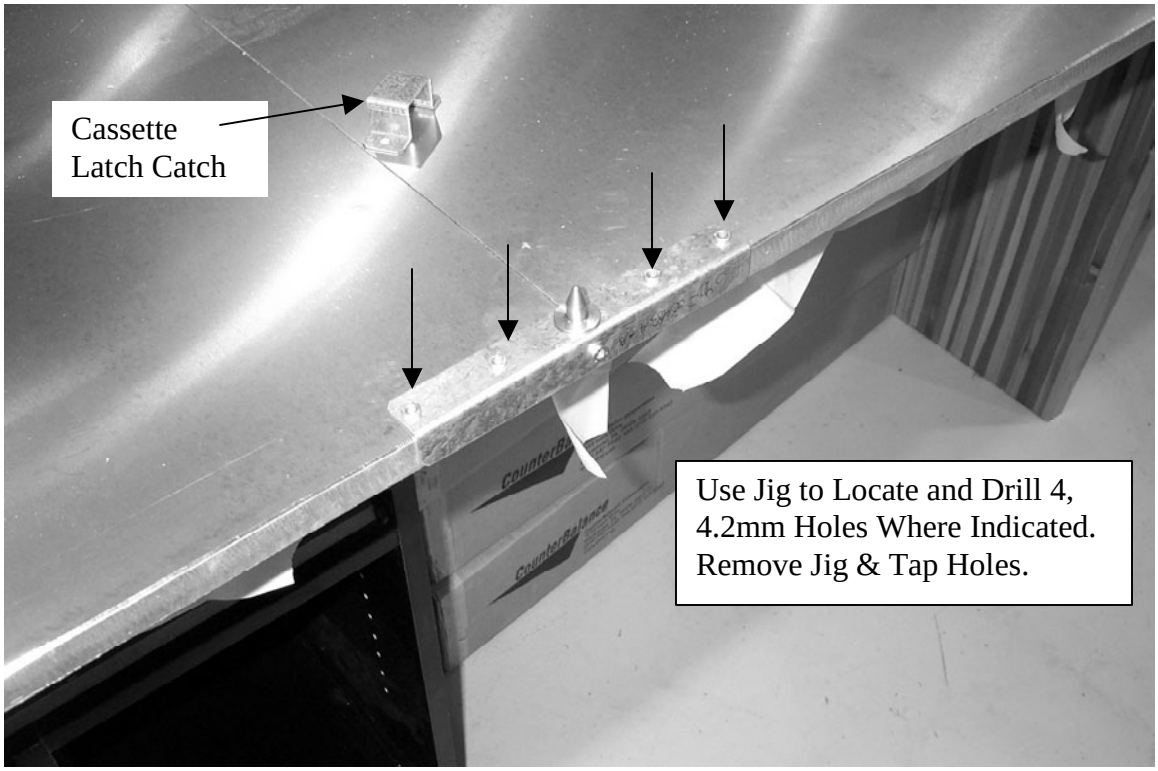


Figure 1 Rework Cassettes

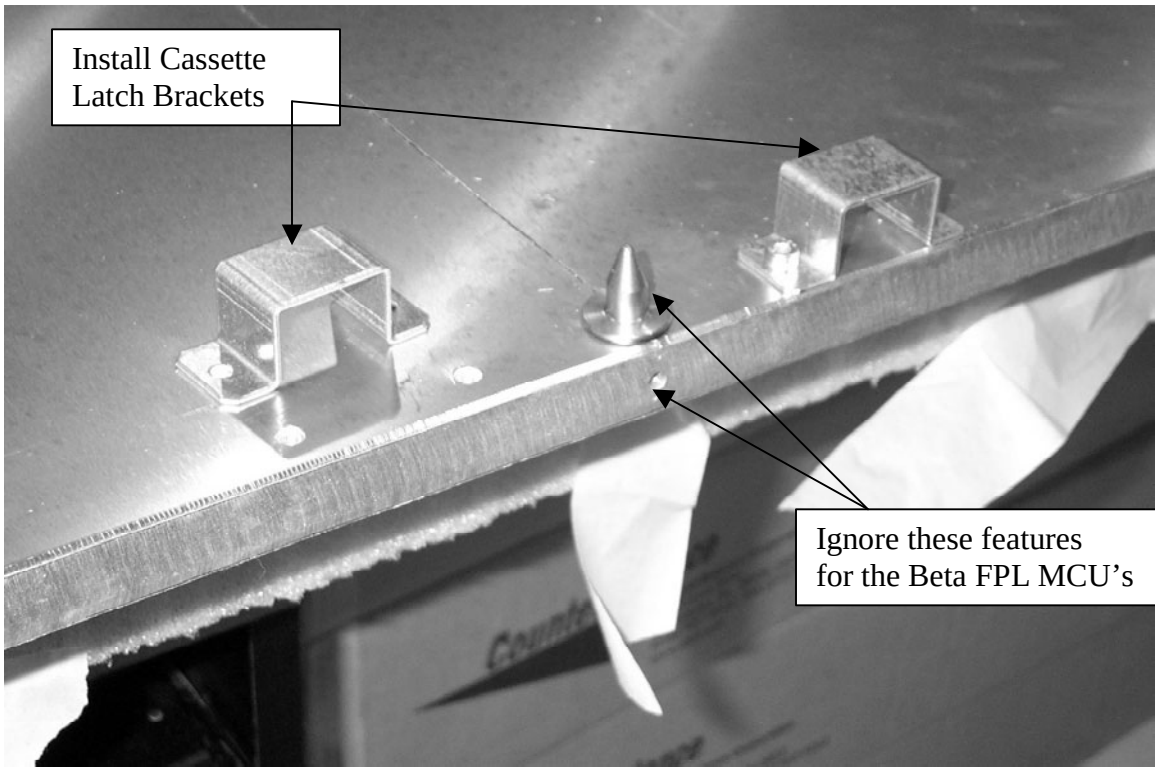


Figure 2 Install New Cassette Components

2. Rework Cart.

i. Use the ¼" drill bit to drill 8 holes in the under side of the cart frame near the cart damper. See the drawings and pictures attached to the Agile part.
ii. Insert the nut plates, shims and latches as shown in the attached pictures.

3. Rework Frame

i. Drill and tap 2 holes in the front of the MCU as shown in the attached pictures and drawings.
ii. Install the cassette latch actuator assembly as shown.

Tip: use the double sided tape to place the cassette latch actuator in place, then use the actuator assembly to locate and drill the holes used to mount the assembly.

4. Check Alignment

i. Unload a cassette and check that the cassette latch engages with the brackets on the cassette. You may need to adjust the tabs on the cassette latch actuator assembly to ensure the latches fully open.
ii. Check the alignments as per the MCU set up procedure found at: http://techplanet.creo.com/output/computer_to_plate/magnus_vlf_al/content/docs/agile/719-00357B-A.pdf