Kodak

Automatic Pallet Loader

Installing a Table Lift Cylinder Weight Compensation Bracket

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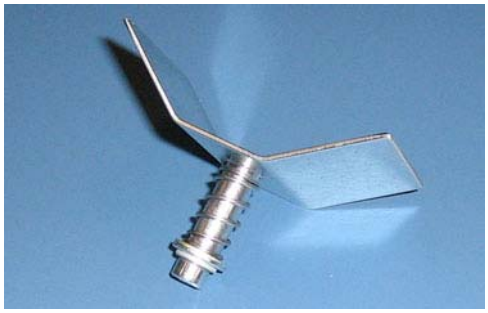
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1. OVERVIEW

This procedure describes how to install the table lift cylinder weight compensation bracket. The purpose of the bracket is to provide support for the weight of the cylinder body so that the cylinder's seals and bushings do not wear prematurely during operation.



2. PARTS/TOOLS NEEDED

- Weight compensation bracket with the spring (252-14202A & 59-3251)
- M4x16 socket head cap screw (52-4460)
- M4 heavy washer (52-3247)
- M4 Belleville washer (52-4261)
- Drill and a 7.3 mm drill bit
- Metric tape measure
- Automatic center punch

3. INSTALLING THE CYLINDER WEIGHT COMPENSATION BRACKET

1. Initialize the APL:
   Type `<<init`
2. Move the table stop to its mid-position:
   Type `<<apl table z move 400`
3. Lower the table:
   Type `<<apl table down`
4. Push one of the E-stop buttons. This moves the cylinder solenoid to the center position and shuts off the air supply to the cylinder ports.

5. Measure 1013 mm from the end of the sheet metal crossbar (cylinder side) and make a mark in the center of the width of the crossbar.



6. Use a center punch to punch your mark and drill a 7.3 mm hole. Clean up the metal filings after drilling the hole.



7. Disconnect the tubes at cylinder fittings.
8. Remove the M6 screw at the rod end of the cylinder to remove the rod end.
9. Retract the cylinder rod by hand.

10. Lift the cylinder at the rod end and slide the bracket with the spring (252-14202A & 59-3251) under the cylinder into the drilled hole.



11. Secure the bracket from the bottom with a M4 screw, heavy washer, and Belleville washer.



12. Attach the cylinder rod end with the M6 screw.
13. Connect the cylinder tubes.
14. Release the E-stop switch and initialize the APL:
    Type `>>init`