Kodak

Automatic Pallet Loader

Replacing a Pusher Carrier Z-Belt

15 Jan 2008

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Revision History

Revision	Date	Author	Comments
1	03 Jan 2008	A.Blignaut	First draft release
2	15 Jan 2008	A.Blignaut/ J.Hogewoning	Edits and corrections from Jeff applied.

1. OVERVIEW

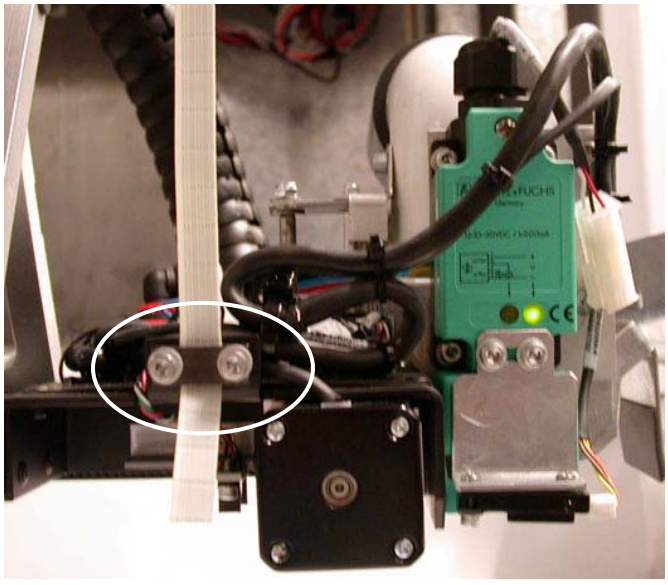
The pusher Z-belts must be inspected during the preventive maintenance procedure. If a belt is worn or damaged, then it must be replaced. This procedure describes how to replace and adjust a pusher Z-belt. The procedure is identical for both pushers.

2. PARTS/TOOLS NEEDED

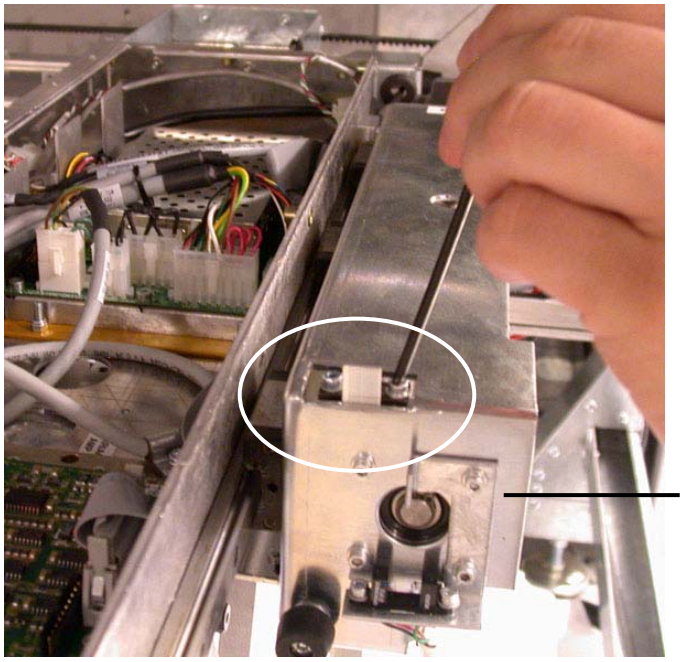
- Replacement belt (346-00053)
  The replacement belt should be approximately 1100 mm (43.3 in.) long.

3. REPLACING A PUSHER Z-BELT

1. Unclamp the picker from the Y-belt. Type `>>apl picker belt off .`
2. Fully extend the pusher. Type `>>apl pusher z move 1000` - the pusher moves down until the away sensor trips.
   Note: If the Z-belt is broken, you will not be able to issue this command.
3. Idle the pusher. Type `>>apl pusher y idle .`
4. Unlock the APL doors. Type `>>apl unlock .`
5. Open the rear doors to get access to the pusher carrier.
6. For easier access to the pusher, move the pusher to the rear of the APL by hand.
   If a belt is broken, hold that pusher carrier up while moving the pusher to the rear.
7. Release the two bottom screws that secure the lower end of the belt to the pusher.

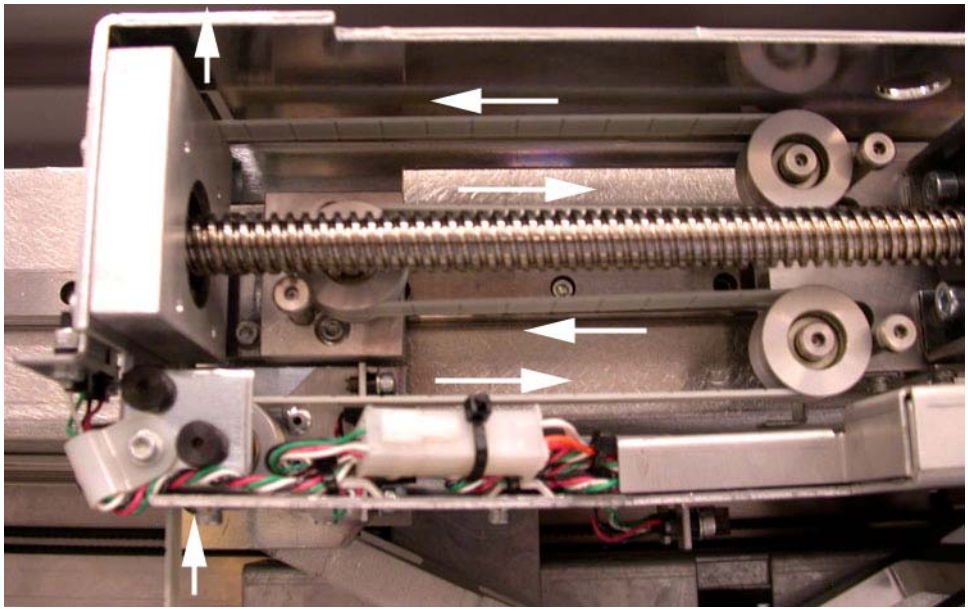


8. Release the two top screws that secure the other end of the belt on the top of the Z-motor assembly.



9. Take note of the belt routing and pull the belt out of the Z-motor assembly.

10. Starting at the underside of the Z-motor assembly, feed the new belt up into the Z-motor assembly with the grooved side facing the other side Z-motor assembly. Route the belt around the pulleys as shown below and out the top of the Z-motor assembly through the belt slot.



11. With approximately 10 mm of the belt protruding from the belt clamp, ensure that the belt is not pinched in the clamp—it should lay nicely in the slot— and tighten the two top screws.

12. Feed the other end of the belt through the bottom belt clamp on the pusher and allow approximately 10 mm to protrude from the clamp.

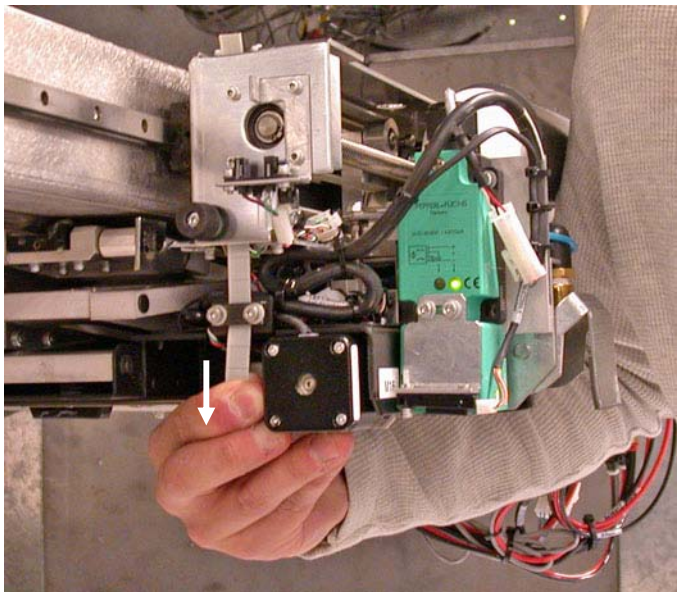
13. Ensure that the belt is not pinched in the clamp and tighten the two bottom screws.

3.1 Adjusting the Z-belt length

To ensure that the pusher has full limit of travel, the belt length must be adjusted with the pusher fully up. To do this:

1. Move the pusher to its highest position.
   Type `>>apl pusher z home` and `>>apl pusher z jog -50` .

2. Using your arm, push the pusher upwards as far as it will go, loosen the two screws on the lower belt clamp and pull the belt until it is tight. Tighten the two belt clamp screws.



3. Leaving approximately 25 mm (1 in.) of the belt protruding from the clamp, cut off the excess belt so that it will not interfere with any other moving components.

