# Friesen Field Install

ALTONA, MANITOBA

By: JEREMIAS RARAMA

July 5, 2005

# Day 1- Surveying The Floor Plans




**Monday June 20**

# Rolling In The MCU And The Base





Even with Plenum removed, MCU barely fits through the door

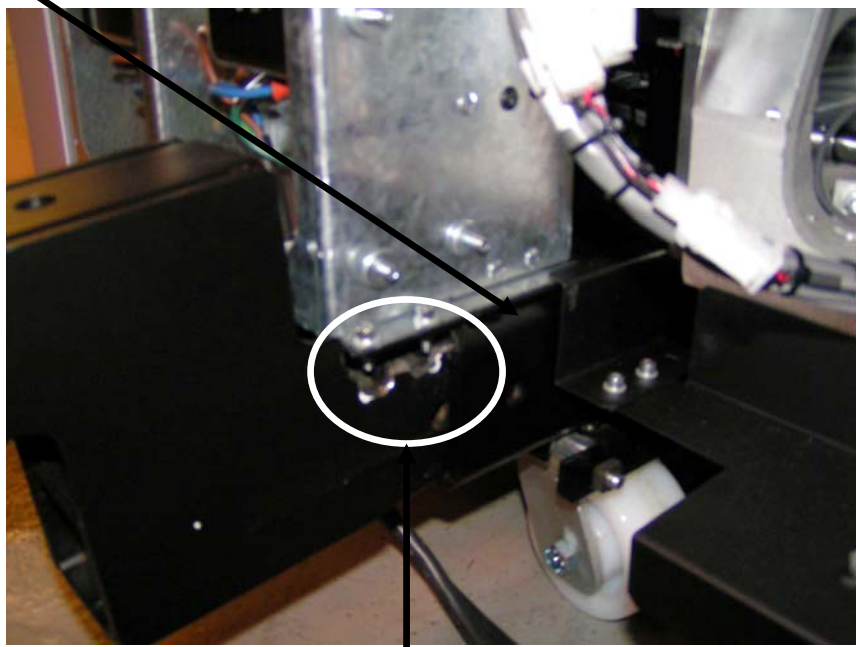


**Monday June 20**

# Lifting Jacks Re-Works

Phil grinded the top of the lifting jacks to fit through the slots.
I am told that this happens all the time.

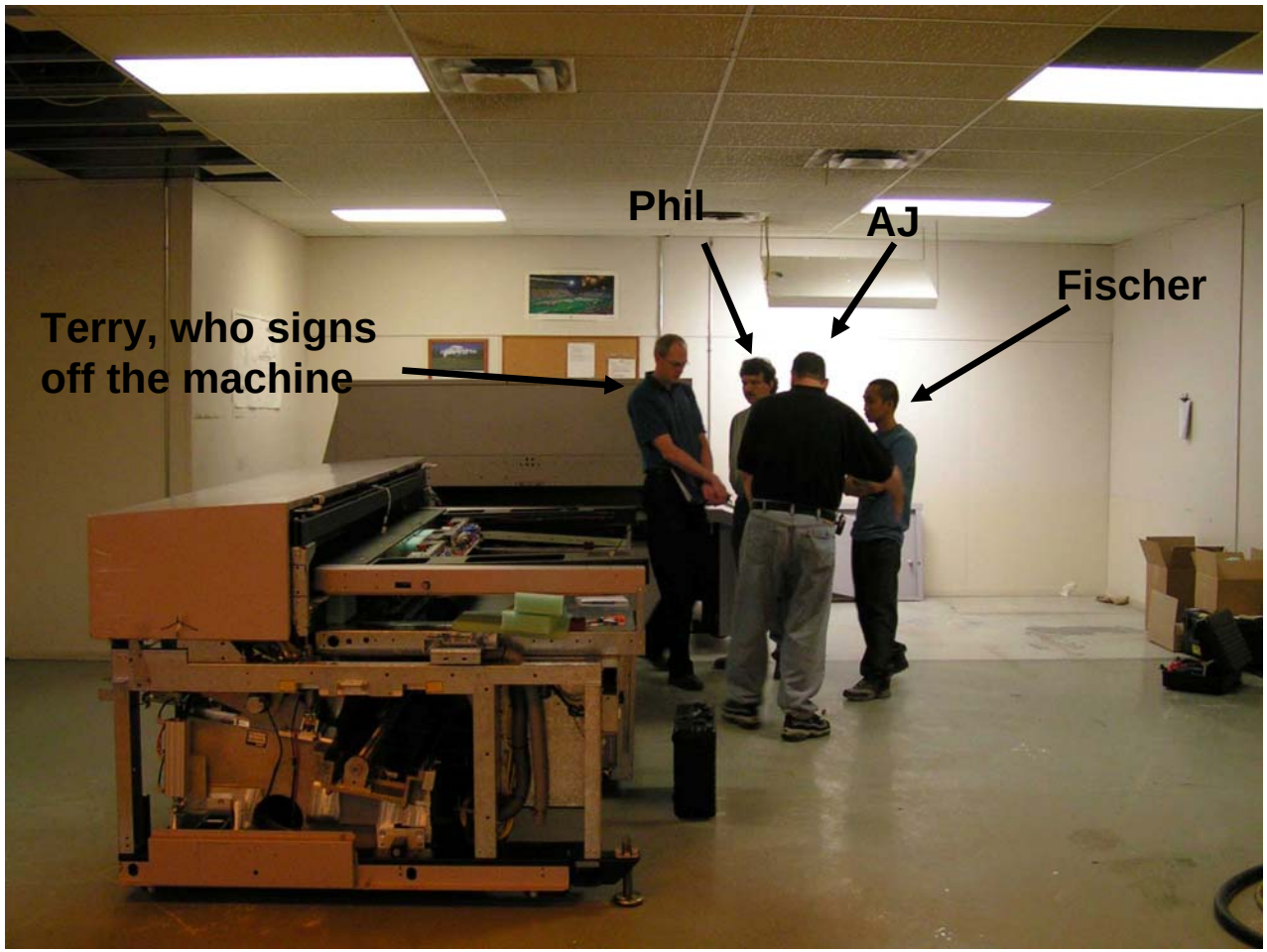




Added slots for the screw of the PEB.
Very important for panel alignment

**Monday June 20**

# Leveling The Base




The end day 1.

**Monday June 20**

# Day 2 - Unpacking The Crates








Due to limited floor space, all the crates were unpacked. The parts were piled in a corner. If all of our time were added looking for parts, at least a day was wasted.

**Tuesday June 21**

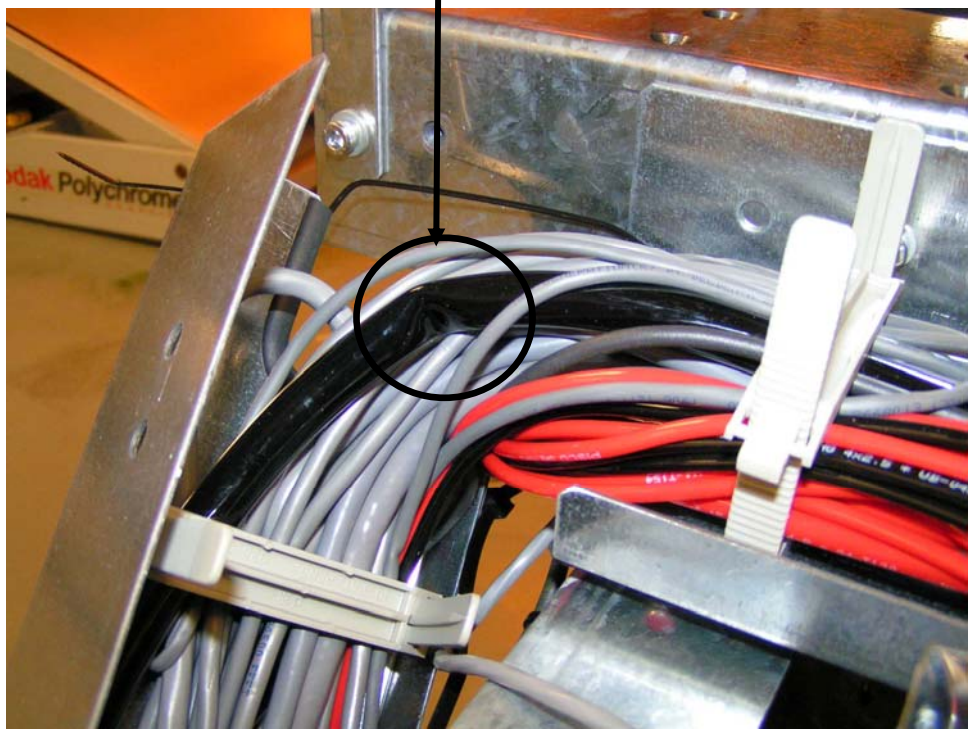
# Assembling the base machine

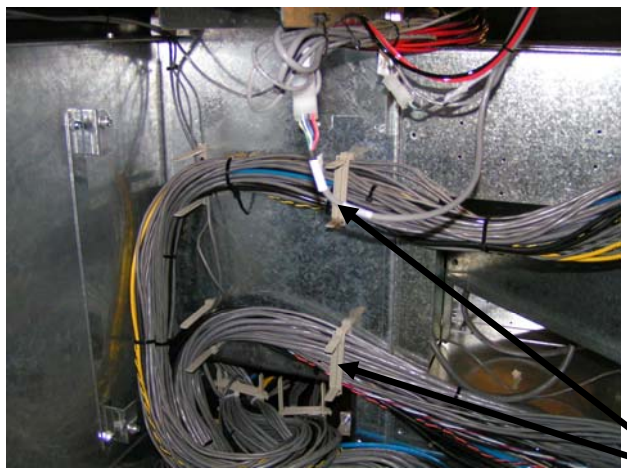
Installing the MABS.

Added foam for support.



Kinked tubing. May need to coil tubing separately.



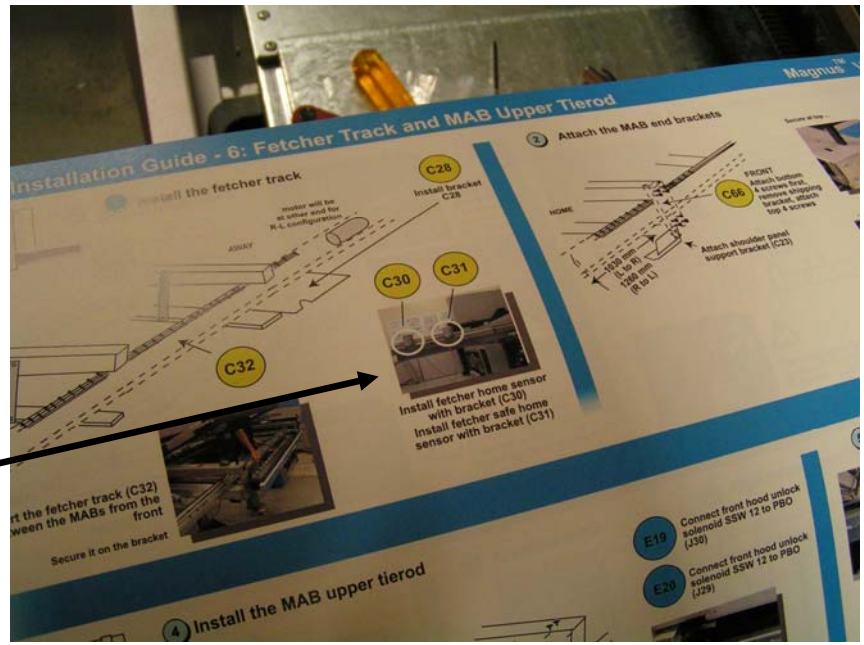


Securing the bundles of cables. May need to add to the installation procedure.

**Tuesday June 21**



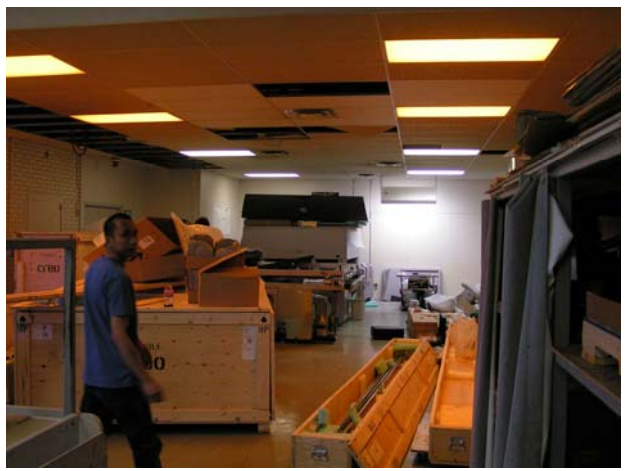
Hot air exhaust shipping box was labeled as panels. Suggest renaming the label to prevent confusion.




I was asked why the pictures in the Installation procedure does not correspond to the orientation of the machine being built. The pictures represent a L-R configuration yet the machine being built is a R-L configuration.

**Tuesday June 21**







The installation progressing well.
The end of day 2.

**Tuesday June 21**

# Day 3 – Aligning base with MCU



Bridge front panel was disassembled, which shouldn't have. Time was spent searching the installation guide.



Base machine is done except for panels, ejector, fetcher and head.

**Wednesday June 22**

# Assembling the MCU

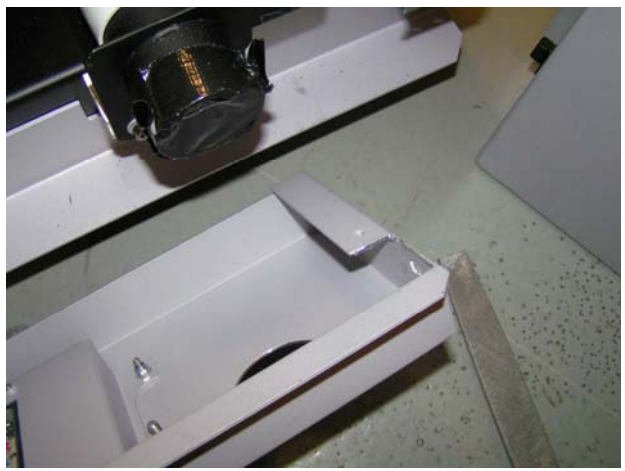
Fischer assembling the MCU.



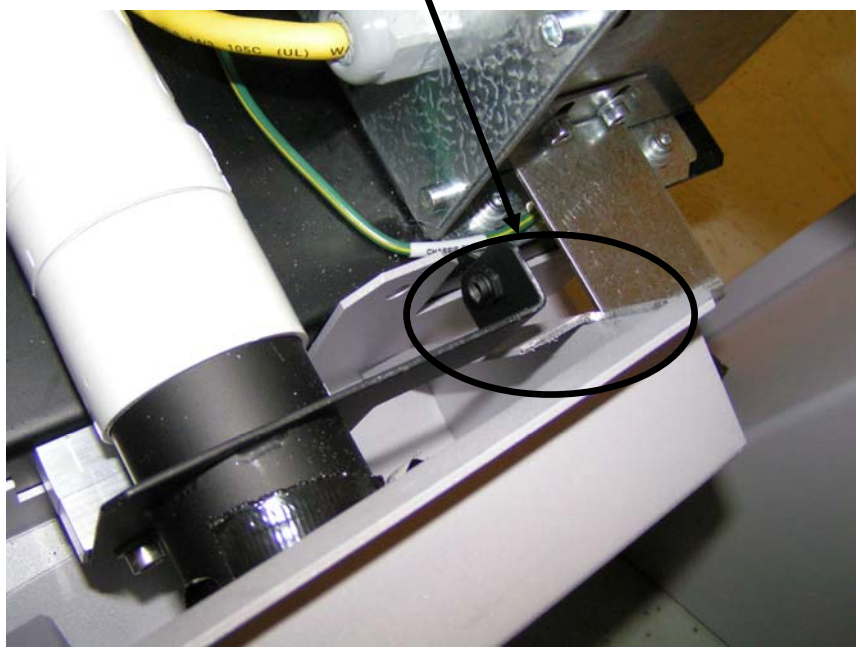
**Wednesday June 22**

# Preparing To Align MCU To Base



Rear right lower panel catches on the drum vac inlet.

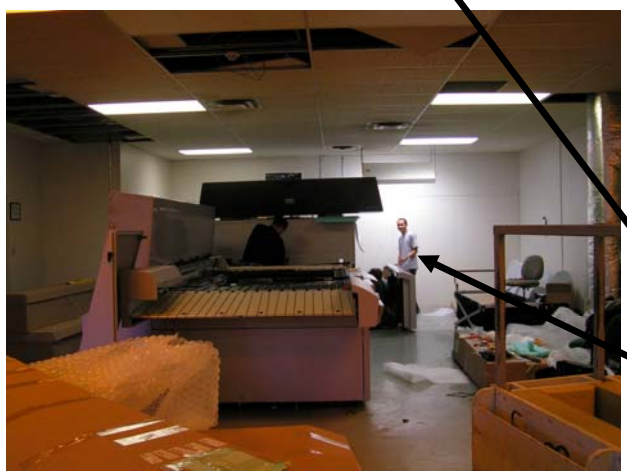


**Wednesday June 22**

# SSR And MCU Alignment

AJ and Phil working on the SSR





Phil aligning the MCU chariot

AJ adding picker cover



Fischer aligning panels

**Wednesday June 22**

# SSR Rear Door And Cover Alignment



Rear SSR door hits the top cover.



Re-worked the rear right panels to lower SSR door.

**Wednesday June 22**

# Magnus







**Wednesday June 22**

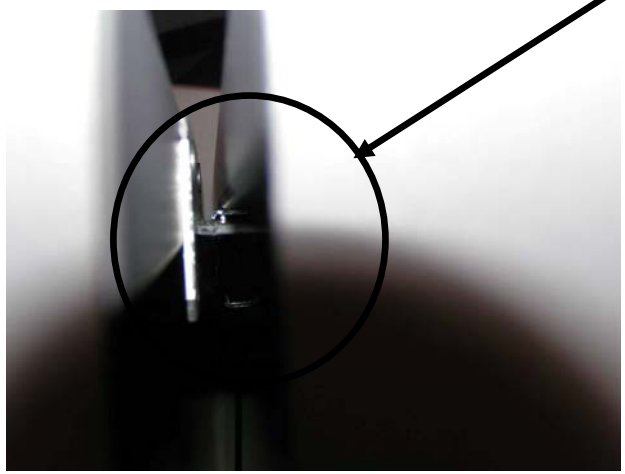
The front hood, bridge cover,
and the cassettes
still need to be installed.
The end of day 3.

# Day 4 - Installing the bridge cover



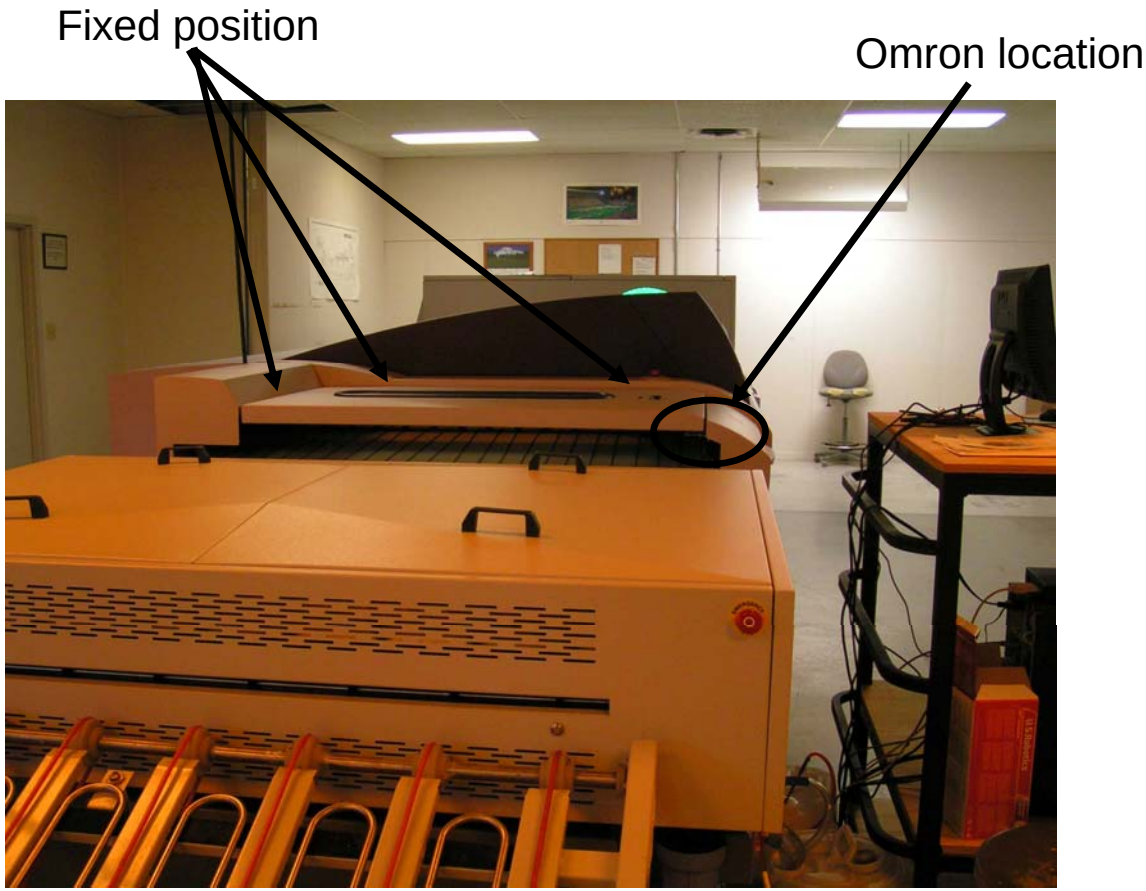
Bridge cover rest on the strut.





**Thursday June 23**

# Bridge cover



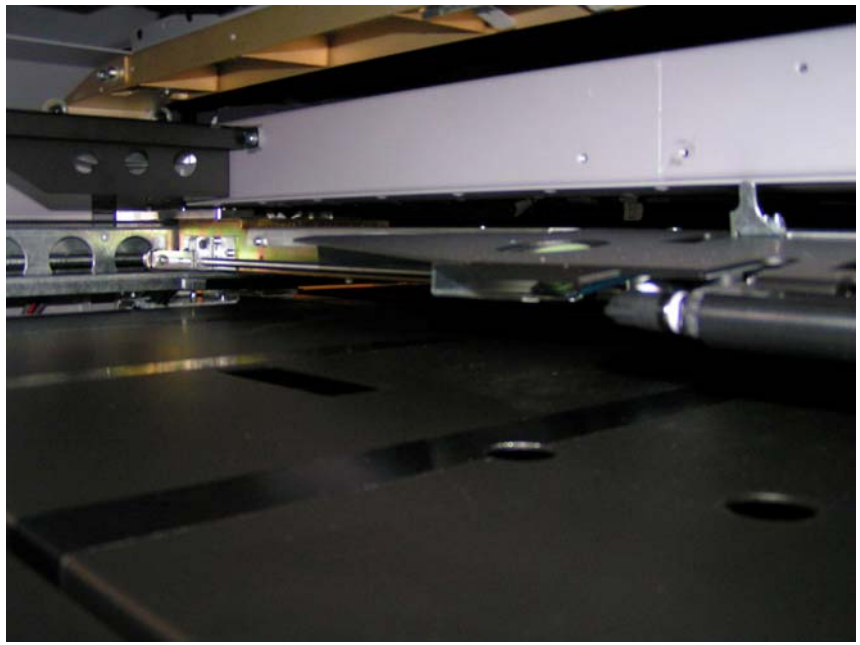

Bridge cover rests on four corners. When the bridge is leaned on, the bridge cover stays stationary therefore breaking the safety loop.

**Thursday June 23**

# Fetcher

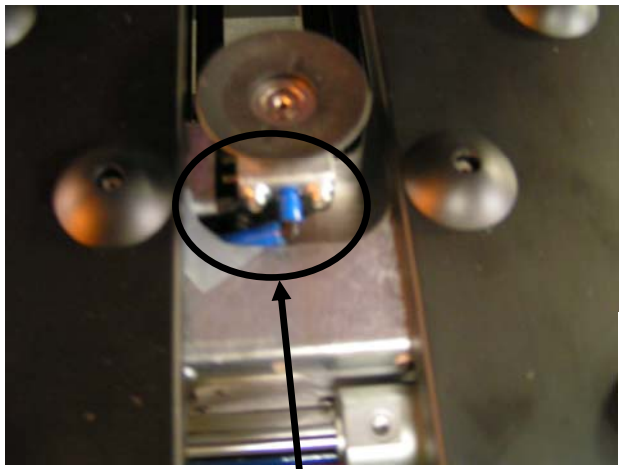


The wings of the fetcher does not fall freely  when leaving the SSR area.  Bent one of the L bracket slightly to free the wings to fall.

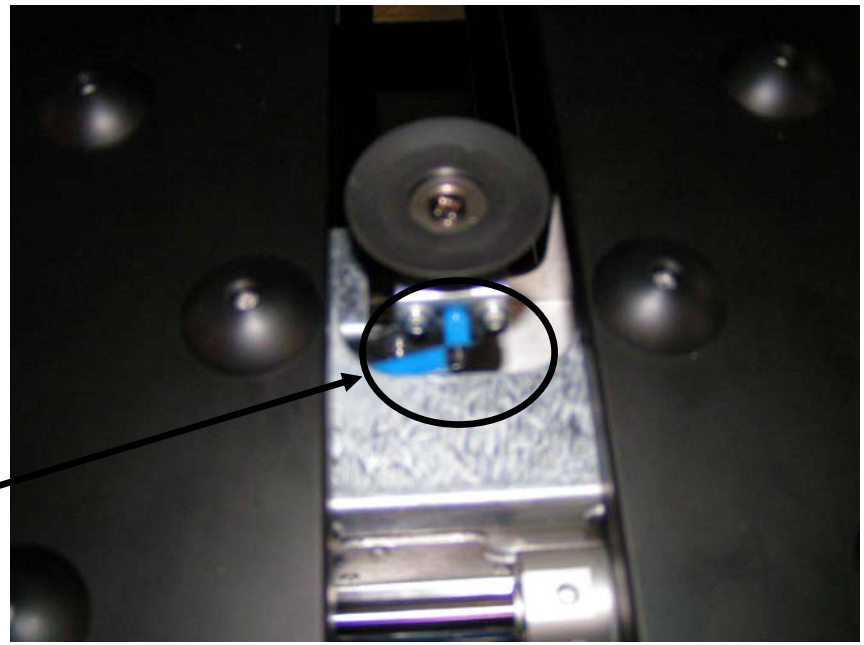


**Thursday June 23**

# Unload Table Cups



Tubing of the cups were rubbing considerably to the metal sheet. Plan is for Fischer to obtain additional tubing and change routing.



**Thursday June 23**

# Labels

Missing Warning Labels on the SSR top cover and rear door.






**Thursday June 23**

The end of the day 4. We had a hail storm the size of a fist and power outage throughout the afternoon.

# Day 5 - Setting up the Workstation

Adjust for image quality, set up workstation and workflow. The end of day 5.

**Friday June 24**

# Day 6 - Cycling the Magnus

Ran the first batch of jobs.  Around 80 plates with no error.  Only intervention was when the Production Manager leaned on the bridge causing safety loop error.  The end of day 6.

**Saturday June 25**

# Day 7 - Sunday Day Off

# Day 8 – Operator Training

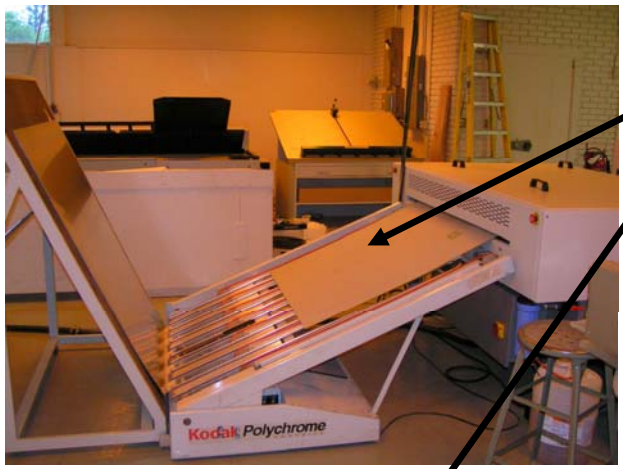


AJ training the operators.



**Monday June 27**

# Running Magnus MT096






Started the first batch of jobs also called Signatures at noon.



At the same time, operator was running the VLF Trendsetter. End of day 8.

**Monday June 27**

# Day 9 – Last Day Of An Install



Operator loaded the bays before midnight and morning operator spent a good portion of the morning punching plates. The machine ran 24 hours without intervention. Over 400 plates were imaged.

# Observations

- Hot air exhaust assembly packaging was labeled panels on the shipping box.
- Pictures on the procedure does not correspond to the configuration for orientation of the machine.
- The lifting jacks needed rework.
- Fetcher pneumatic tubing panel needed rework for the door to fit.
- Fetcher wing does not fall after leaving the SSR area.
- Unloadtable cups tubing rub against the sheet metal.
- Rear right lower panel needed rework.
- The SSR top cover and rear door need warning labels.

# Conclusion

The install of Magnus MT096 went well.  However, I believe future field installations will be more effective and efficient if the following recommendations are implemented:

- changes to the sequence of the Installation Procedure
- making labels accurate
- adding more pictures for different configurations
- pasting a list of parts on the shipping crates