P-cup and swivel assembly upgrade

Document number: 709-00225A-A

Product	FCO priority
Magnus VLF with Autoloader.	Next Failure

Machines affected Upgrade machines MT030 and before.

Background

The P-cups do not have enough lift capacity to lift all plates. Also, the P-cup swivel bar is not manufactured to drawing, so it reduces the swivel capability of the P-cups.

Solution

Change the P-cups to more powerful ones and replace the swivel bar with a new version to ensure the parts meet specifications.

Parts required

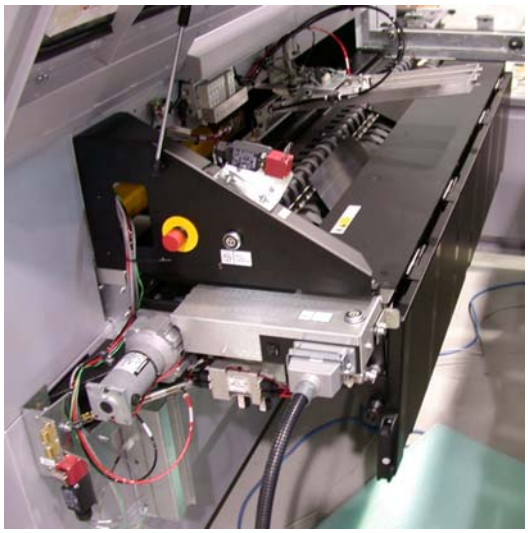
Part Number	Part Name	Quantity
512-00190A	P-cup and swivel assembly upgrade kit	1

Tools required

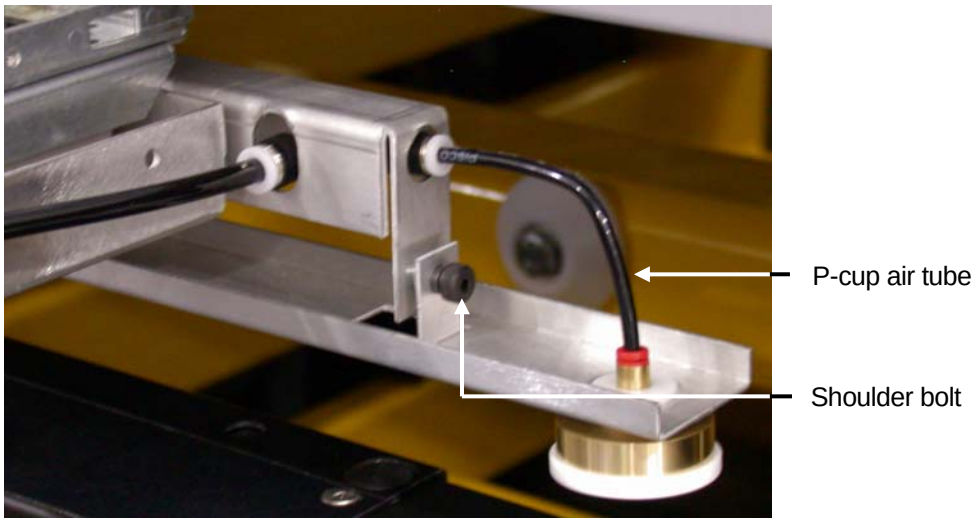
- Hex keys

Procedure

1. To access the P-cup and swivel bar assembly:
   a. Open the SSR bin area cover and the SSR bin area back panel.
   b. Move the fetcher into the load table area.
   c. Open the SSR bin deck panel.



2. Disconnect the air tube from each P-cup fitting. Remember to depress the plastic ring on the tube fitting to release the connection to the tube.



3. Remove the two shoulder bolts by holding the nut and turning the shoulder bolt with a hex key.
4. Replace the picker swivel bar and P-cup assembly.
5. Re-attach the shoulder bolts and P-cup tubes. Ensure that the tubes are pushed all the way into the fittings.
6. Check that the P-cups move freely and that the P-cup swivel bar moves freely.

See also	Assembly drawing 500-00446A-A
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