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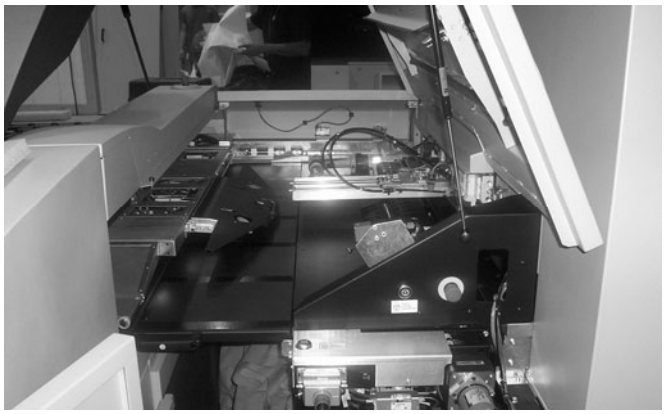
719-00384A-A
Procedure, SSbin Roller Gap Adjustment, Mta

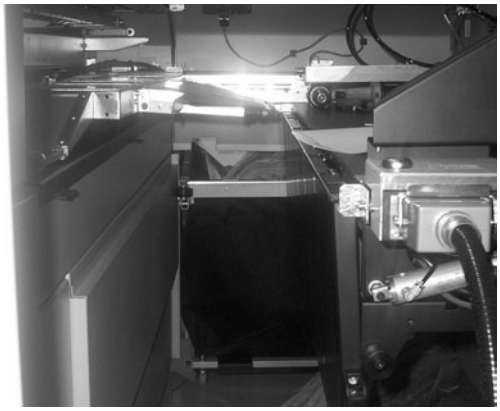
1. TOOLS REQUIRED:

Allen key set, small adjustable or open end wrench,

2. PROCEDURE:

2.1 Open the SS bin panels, remove the SS bin, move the fetcher away from the mcu over the load table, and lower the SS bin top fold down panel.



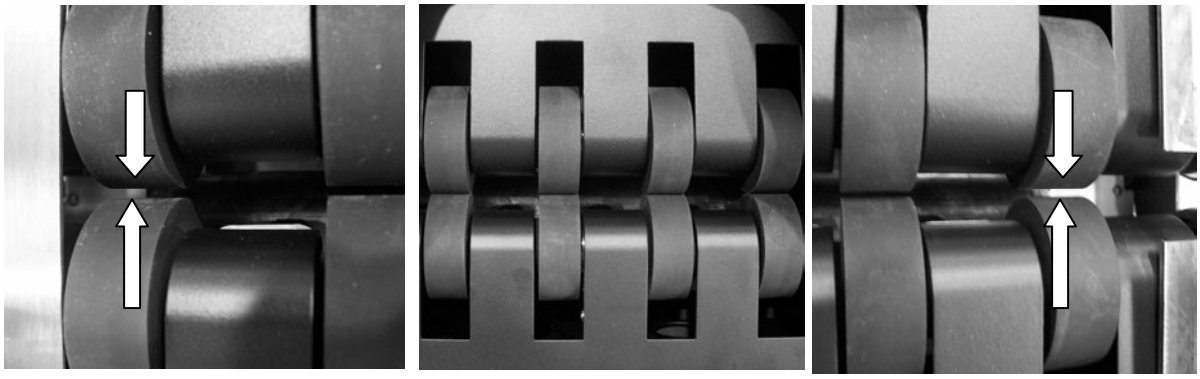


2.2 Turn off air supply to device.

2.3 Move the movable SS bin roller [table side] into contact with the fixed SS bin roller [mcu side] and squeeze gently together. The picker may interfere with the visibility where the center rollers are touching.

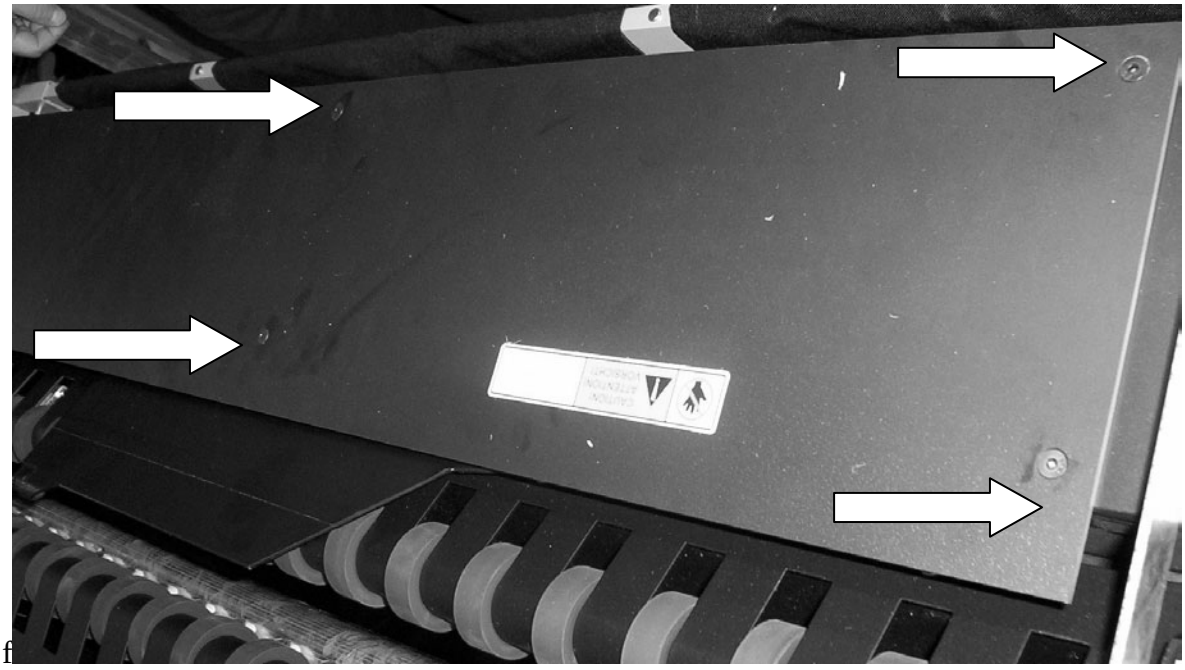


2.4 Check the gap at the ends of the rollers; the gap should be 3mm [+0.5,-0]. A 3mm allen key should slide freely between the end rollers but a 4mm allen key should not slide freely between the end rollers. Notice that the roller shafts are curved slightly for this nip to occur.



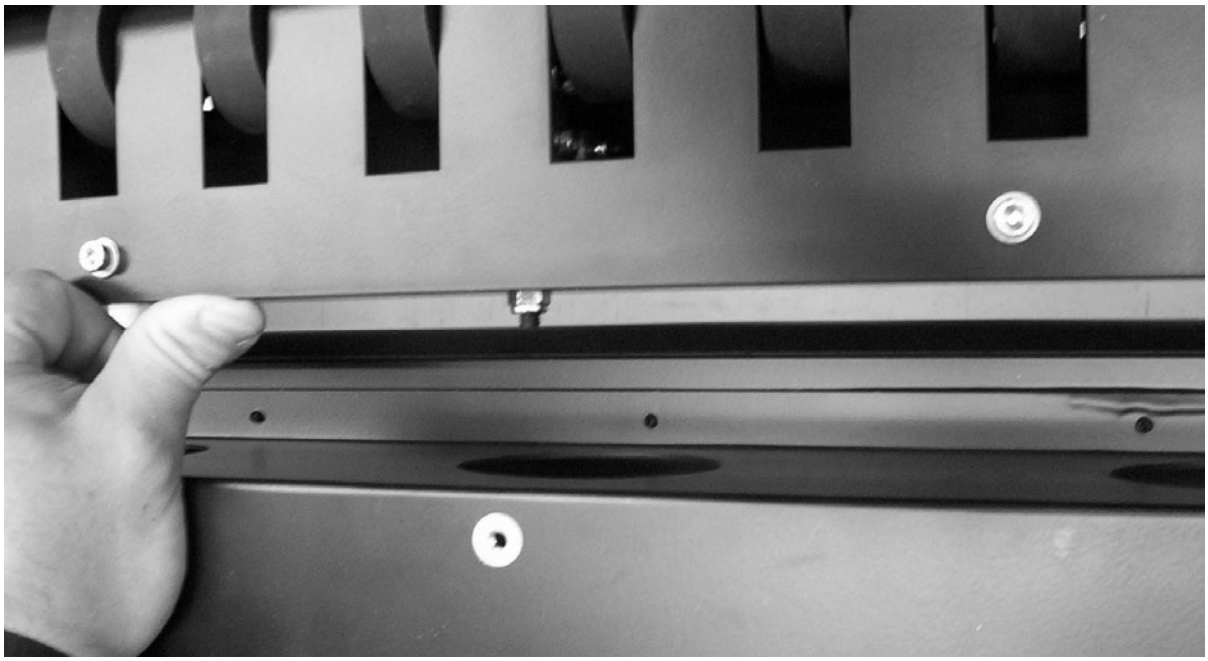
END [gap 3mm] CENTER [touching] END [gap 3mm]

2.5 If the gap is not correct then remove the black laminate top sheet from the SS bin. [remove 8 screws first]



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2.6 Loosen the nut on the preload adjustment set screw found at the mid point of the movable roller frame. Turn the set screw in to increase the gap at the ends of the rollers. Once the gap is set re-tighten the nut. You may need to hold the set screw while loosening and tightening the nylock nut. Also, the pitch of the set screw thread is 1mm per turn; thus turning the set screw 1 turn is equal to a 1mm gap increase.



2.7 Check to see that the movable rollers turn without rubbing on the sheet metal frame. If the roller rubs on the sheet metal frame then the rollers are likely worn to the point that the fixed roller needs adjustment [see separate procedure] or the SS rollers need to be replaced [see separate procedure].

2.8 Re-install the black laminate top. Ensure that the screws are tightened carefully because the laminate is brittle and could break.

2.9 Turn the air pressure back on.

2.10 Raise the fetcher deck extension, move the fetcher back to the home park position, close the SS bin panels, and re-insert the SS bin.

2.11 Initialize the Fetcher and then test with a pick.