Unload Table Panel Hold Down Kit Mta

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Product

- Magnus VLF MCU
- Magnus VLF CL

FCO priority

As required by the site and PSS.

Machines affected Possibly all MCU and CL devices.

Background

The Unload table panels on the left and right side of the table have been seen to twist slightly causing the outside corner on the operator side of the far left and right panel to rise up above the rest of the unload table surface. Also seen is the midpoint of the panel on the far left or right edge of the respective panel to be pushed up by the unload table frame. Both of these lead to side ejector and unload table panel interference problems.

The main possibility noticed on the devices is that the tolerance stack-up of the assembly for the frame and extension allows the extension to drop below [up to 4mm] the parallel reference of the arms on the frame. This allows part of the side panel to rest on the extension but the other part forced up by the interference with the arm pushing the mid point of the panel up.

Solution

Install the panel hold down screws.

Time required Approximately 30 min for the installation.

Parts required

Part Number	Part Name	Quantity
512-00346A	Kit Panel Hold Down Mut Mt	1 pc

Tools required

- Drill & 3.3 mm drill bit & M4 tap
- Hex keys
- Loctite 222 or equivalent non permanent

Procedure

1. Open the hood.
2. Remove the left and right side unload table panels and load table rails.
3. Set the first panel in place.
4. Drill [3.3 mm] through panel and aluminum frame tube.
    - Pick the location of the 2 holes for each panel to ensure the screw is not going to interfere with the ejector fingers or plate motion and will hold the panel down to the aluminum arm appropriately.

5. Tap [m4] the drilled hole through the panel and the aluminum frame tube.
6. Insert the washer[s] between the panel and frame tube
7. Insert the m3 screw into the hole in the panel, through the washer, and then thread into the aluminum frame.
8. Tap the head of the m3 screw with hammer to start setting the shape of the conical hole in the panel.
9. Remove the m3 screw.
10. Insert the m4screw into the hole in the panel, through the washer, and then thread into the aluminum frame.
11. Try to make the washer concentric with the screw.
12. Tighten the screw until the head of the screw is nearly flush with the panel top.
13. Do not tighten too much as the aluminum threads may strip.
14. Remove the M4 screw and apply loctite and then reinsert into panel.
15. Repeat once for this panel and then but not too many times as every screw added will need to be removed for future service access to that area.
16. Confirm that the ejector is adjusted correctly to be able to take a plate out of the device and have clearance over a plate when returning to home.

Technical contact	Gordon Andrew
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