Picker/Fetcher upgrade

Product	FCO priority
Magnus VLF MCU	Next failure

Machines affected MT001 to MT083 (MT009 may have been upgraded in production).

Background

The picker and fetcher do not engage correctly at the fetcher park position or the picker pick position. This leads to the fetcher either pushing the picker into the MCU prematurely, or to far, or not at all. These errors can be fatal to the picker and the fetcher.

Solution

Implement FCO CA05234.

Parts required

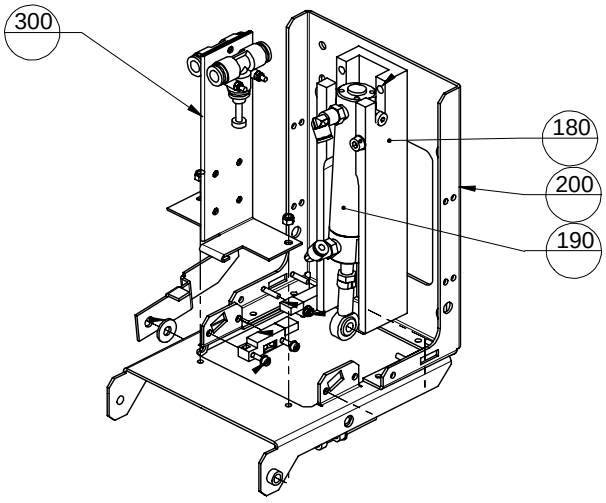
Part Number	Part Name	Quantity
512-00196A	FCO kit for picker/fetcher	1

Tools required

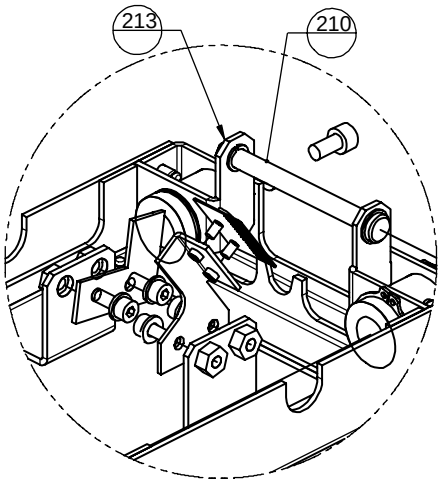
- Drill and 1/8 in. drill bit
- Small digital level – 150 mm (6 in.)
- Pneumatic tube cutters
- Hex keys

Procedure

1. Turn off the air supply to the device.
2. Open the Slipsheet Removal (SSR) top cover and back access door.
3. Move the fetcher over the load table and lower the SSR bin service access panel.
4. Remove the up/down cylinder mounting block (500-00446B item 180) from the P-cup mounting bracket (500-00446B item 200).



5. Remove the rod end clevis pin and spacer from the picker up/down cylinder (500-00446B item 190).
6. Attach the new clevis pin (500-00446B item 210) with fasteners (do not tighten) to the mounting block and attach the new clevis pin and cotter pin (500-00446B item 213) to the cylinder (the new parts may be the same as the parts removed).



7. Turn on the air pressure to the picker up/down cylinder to retract the cylinder and tighten the fasteners on the cylinder mounting block.
8. Attach the cylinder mounting block to the picker.
9. Attach the picker P-cup tube bracket (500-00446B item 300) to the picker.
10. Apply UHMW tape to the picker tray to ensure that the tubes do not rub on the metal of the picker slider.
11. Route the tubes from the manifold to the fittings on the picker P-cup tube bracket and cut them to length. Ensure there is no interference with other tubes or cylinder motion and secure the tubes with cable ties.
12. Install the new picker fetcher interface plate (500-02468A) on the fetcher—the foam must be facing the picker.
13. Using a small digital level, check the level of the picker (right and left direction). If it is not level within 0.2º, install shims to rotate the picker down or up relative to the MCU side panel.
14. Drill 1/8 in. holes in the panel through the holes in the shims and use self tapping screws to hold the shims in place.
15. Raise the SSR bin service access panel and move the fetcher until it trips the safe home sensor.
16. Close the SSR bin access door and top cover.

See also	500-00446B picker assembly drawing
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