Unload Table Extension Arm Adjustment Mta

Document number: 719-00631A-A

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.

There are two potential causes:

The first 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 [approx 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.

The second possibility is incorrectly placed Velcro which is placed on the arm of the frame not the aluminum extension piece and also forces the mid point of the panel up and thus creating more interference.

Solution

1. Inspect to find if the Velcro is located incorrectly.
2. Check using a long [4ft or 1m] straightedge to see if the extension is sagging when the table is horizontal.

Time required Approximately 30 min for the inspection and adjustment.

Parts required

Part Number	Part Name	Quantity
N/a	Undefined at this time	0 pc

Tools required

- Hex keys
- Nut driver set [metric]
- Side cutters
- Helper
- Straightedge at least 1.2 m long

Procedure

1. Open the hood.
2. Remove the left and right side unload table panels.
3. Inspect to see if the Velcro is placed properly.

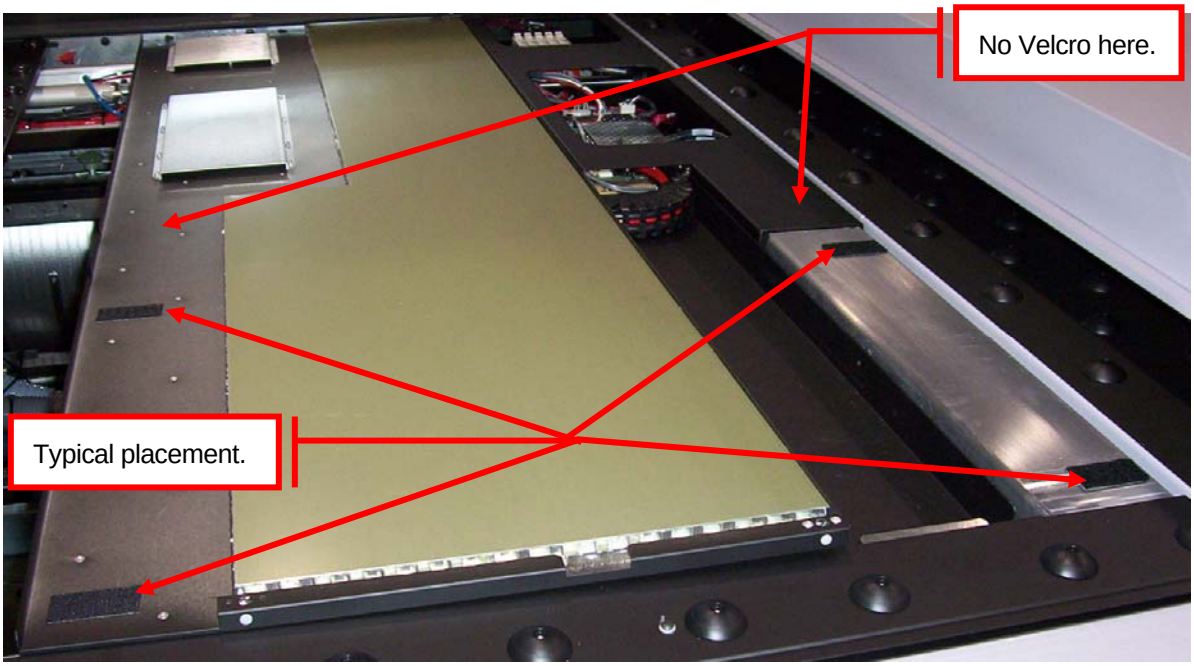


Figure 1: Good Panel and Frame extension Velcro placement.

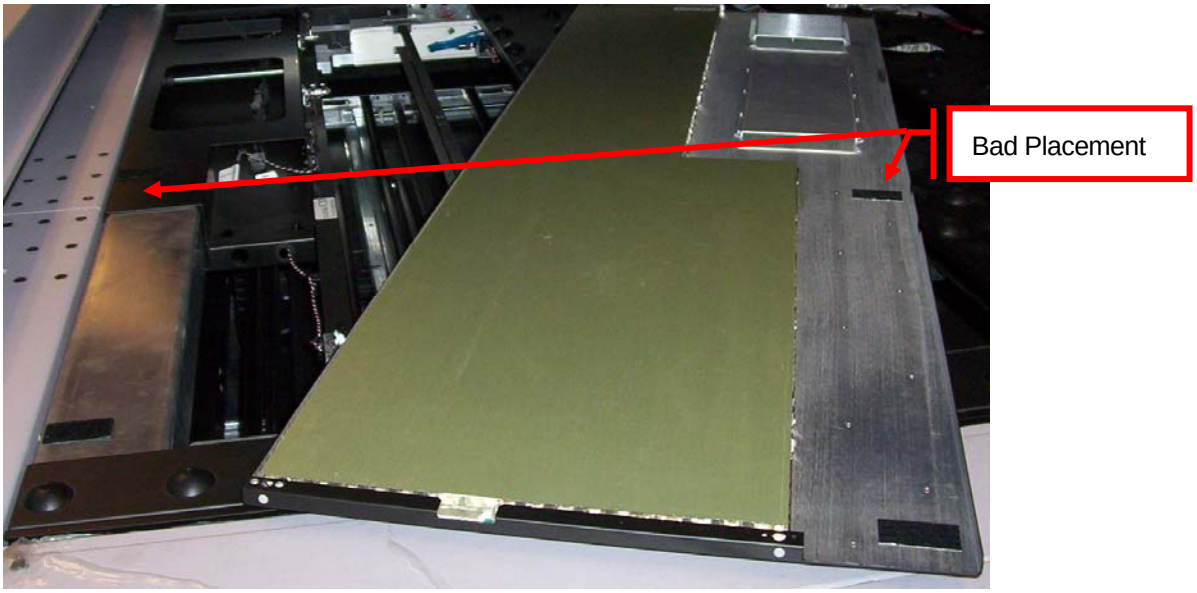


Figure 2: Bad Panel and Frame extension Velcro placement.

4. If there is Velcro on the Frame arm remove it and the corresponding Velcro on the panel because they will make a problem.
5. Now use the straightedge to find if the frame extension is parallel to the top surface of the Arm of the Unload table frame.

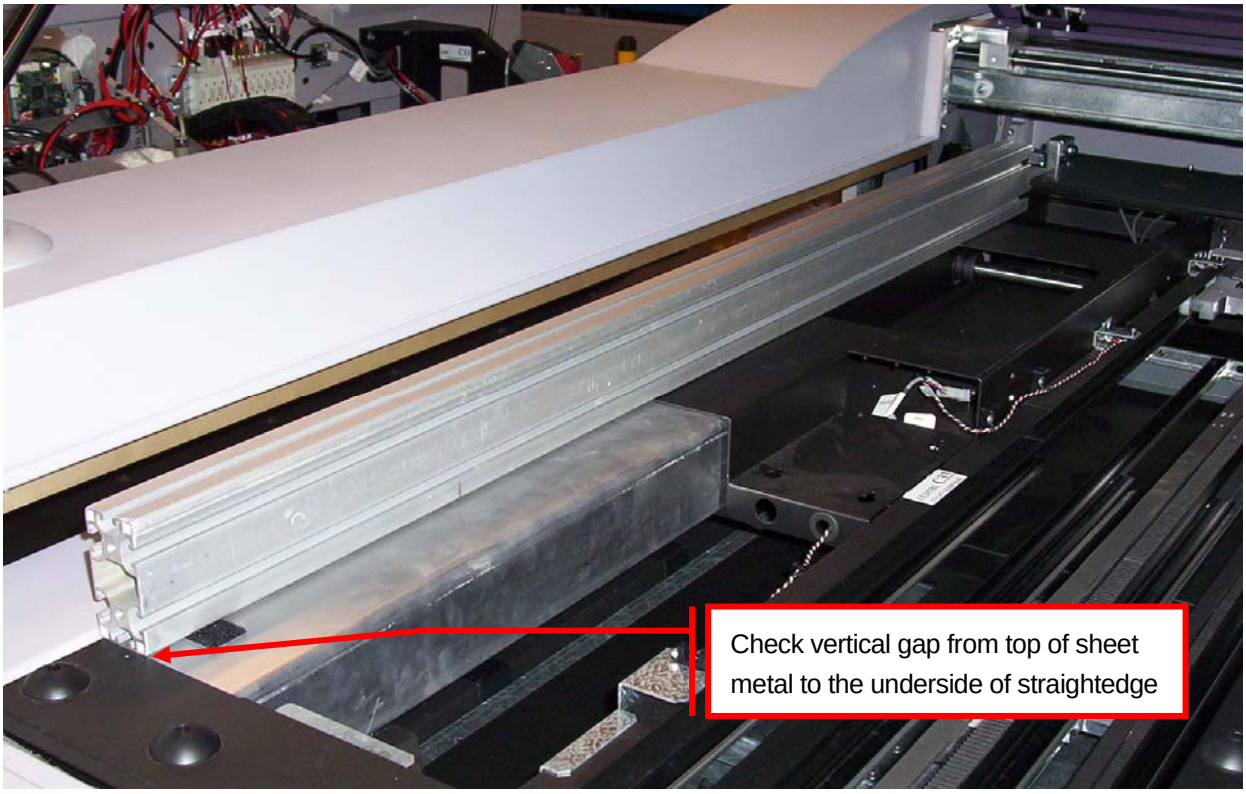


Figure 3: Straightedge placed on unload table frame extending out to next panel.

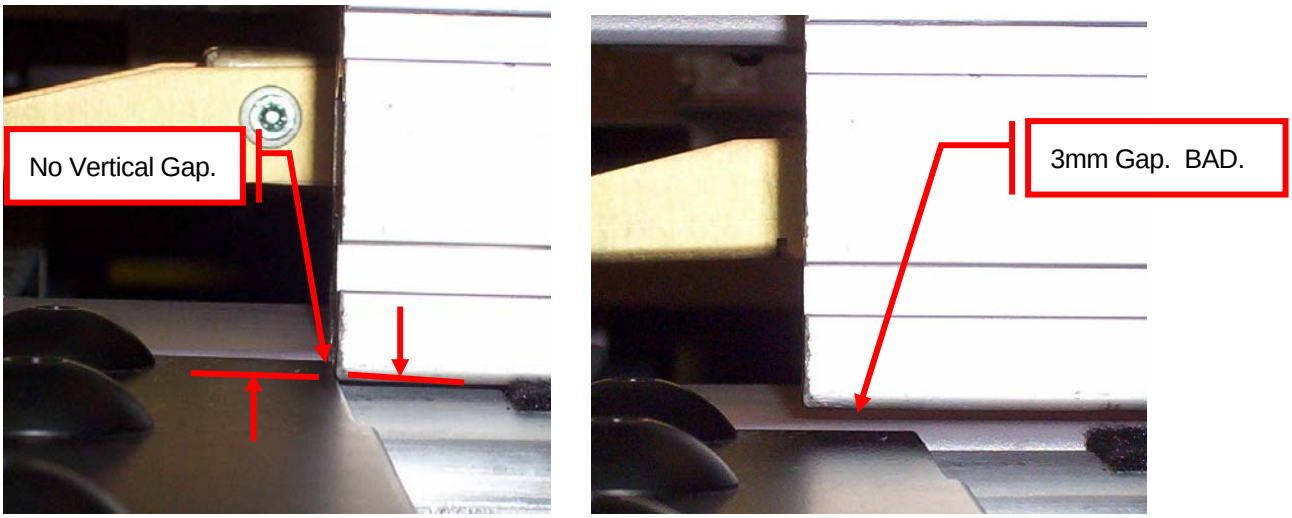


Figure 3 & 4: Vertical Gap between straightedge and extension.

6. If the extension is more than 2mm below parallel from the frame arm then you will need to adjust the mounting of the aluminum extension to the arm of the unload table frame or change the extensions to a modified design.
7. This requires tilting the unload table to loosen the screws found on the underside and outside of the unload table frame arm on both the left and the right.
8. Ensure you make the tilted table “safe” to ensure you or someone else cannot be uninjured by the table falling.
9. Only loosen the screws on the side of the table with the problem. [left or right] There should be to 6 to 8 screws per side.

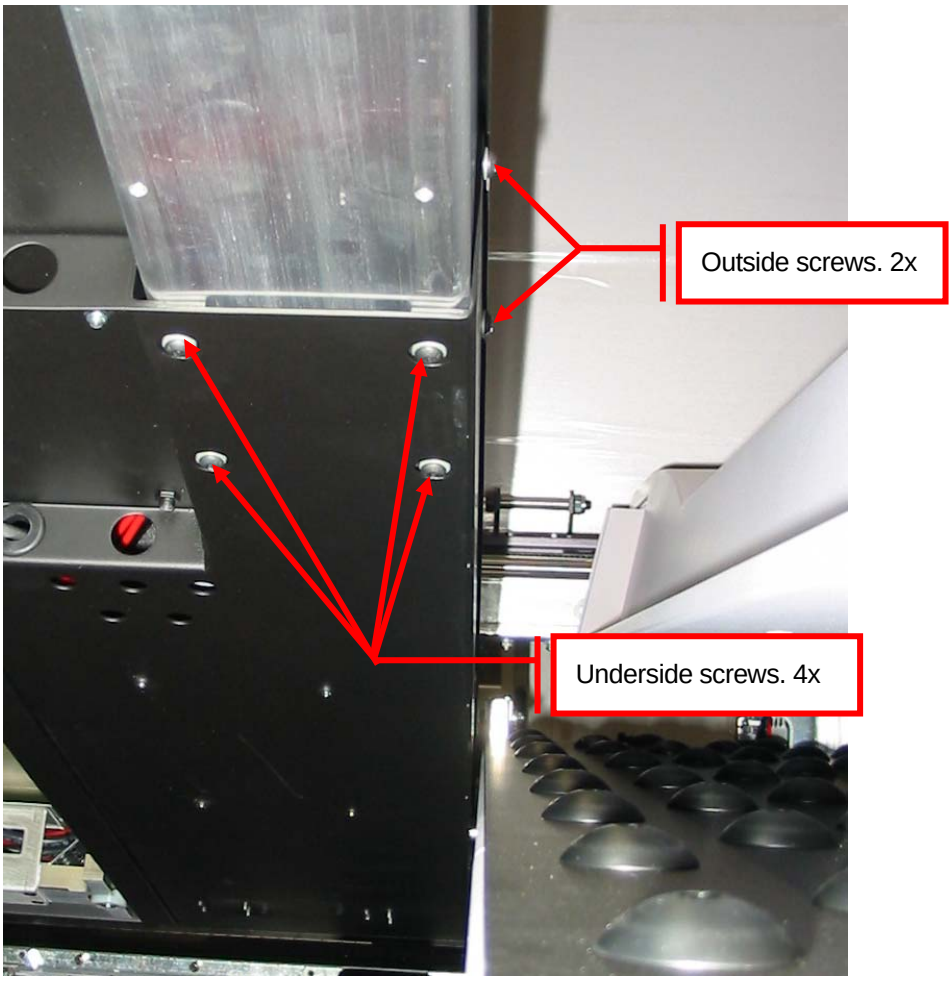


Figure 5: Location of fasteners for extension tubes to frame arm.

10. Lift up on the table extension to preload the joint between the aluminum tube and the sheet metal frame.

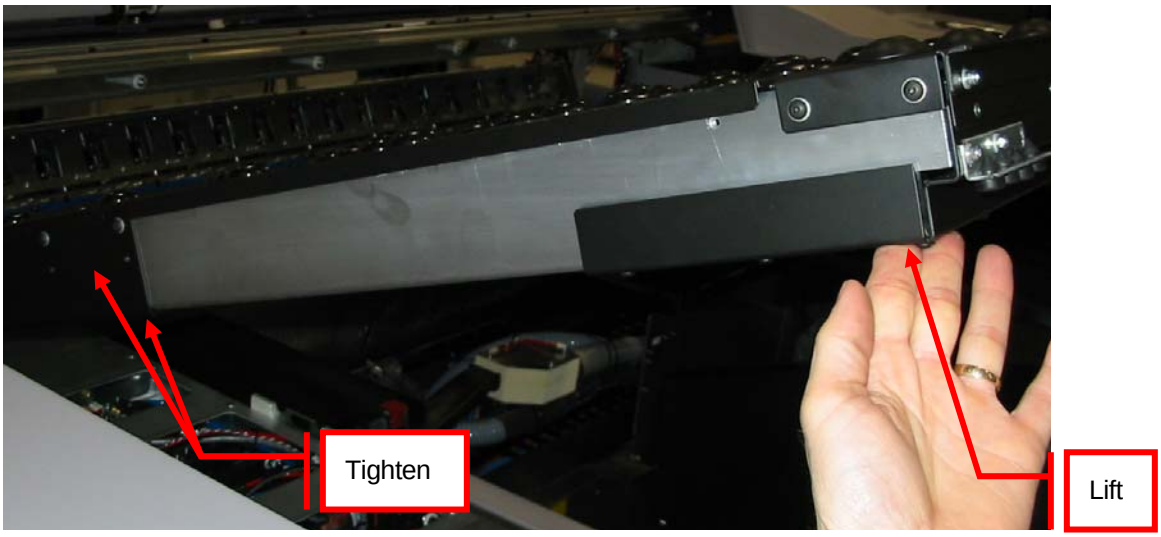


Figure 6: Lift on the extension as shown.

11. Tighten the screws lightly on the bottom of the unload table frame.
12. Next, lightly tighten the screws on the outside of the unload table frame.
13. Next, fully tighten the screws on the bottom of the frame.
14. Finally tighten the screws on the outside of the frame.
15. Lower [untilt] the unload table.
16. Check again using the straightedge to find if the frame extension is parallel to the top surface of the Arm of the Unload table frame.
17. If the extension is still more than 1.5 mm below parallel from the frame arm then order a set of aluminum extensions for the unload table that can correct for this. The modified extension parts should raise the extension by 1.5mm and thus correct for most of the problem. If the error is more then another cause may be at work here.
18. If the extension arms were required for replacement then install the extension arms when they arrive.

    The process for disassembly is not defined here.
19. Confirm that the unload table extension bumpers are still supporting the extension when the table is horizontal. Adjust to ensure they act as supports but not pushing the unload table up and out of level.
20. 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.

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