Unload Table Extension Beam Change

Document number: 719-00634A

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 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 unload table 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

1. Replace the extension arms with modified ones.

Time required Approximately 1.5 hours for changing the extension beams for the unload table.

Parts required

Part Number	Part Name	Quantity
512-00346A	Kit extension beam change mut mta	1 pc

Tools required

- Hex keys
- Nut driver set [metric]
- Side cutters
- Helper

Procedure

1) Open the hood.
2) Remove all the unload table panels and load table rails.
3) Disassemble the unload traveler wheel guides from the extension.
4) Disconnect the sensors and motor wires to the extension.
5) Prop the unload table in a partially tilted position to be able to access the screws for disassembly.
6) Remove the screws holding the arms [aluminum tubing] to the extension on each side.

7) Remove the screws from the connection of the arms to the unload table frame.
    - See procedure 719-00631A for locations of fasteners.
8) Replace the arms:
    - 252-10430A goes on the LHS.
    - 252-10435A goes on the RHS.
9) Install is the reverse of removal with the notes from procedure 719-00631A.
10) Check the results with procedure 719-00634A.

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