FCO KIT 512-00145A used for ECO CA04549

MACHINES AFFECTED:

applies to automatic machines only: MT006 to MT013. MT014 + to MT019 should have had reworks done already in production.

PROBLEM/SOLUTION:
The unload table pivot shaft is sliding out of the bushings in the unload table frame even though there are 3 setscrews per shaft holding it in position. Therefore 3/4" collar clamps will be added to the assemblies to ensure that the shaft cannot slide out as well as reference to the setscrews that already exist.

TOOLS:
allen key set metric and imperial
support blocks for the unload table during the rework process.

PROCESS:
1) remove table rails and unload table panels
2) release set screws that hold the shaft 2 per shaft accessible from the top of the unload table frame through 1/4" holes above the shaft.
2b) also release the setscrews in the pillowblocks installed in the MAB otherwise the shaft will not slide out.
3) slide the pin out !! ensure you support the unload table when you slide the pin out (toward outboard side)!!
4) slide the shaft out only enough to assemble the collar.
5) reinsert the shaft into the hole. Ensure the shaft is is bottomed out of the sheetmetal surface at the end o fth ehole.
6) slide the collar to the outboard side of the shaft and tighten the collar.
7) remove the setscrews from the pin guide on the outboard side of the unload table frame only. One per side.
8) tighten the setscrews on the inboard side of the unload table frame. 2 places 2mm allen key.
9) adjust the unload table center position. Thsi usually ensures that the unlaoad table is centered between the MAB's.
10) tighten the setscrews on the pillow block bearings in the MAB's (they are accesible from the underside of the MAB)
11) reassemble table panels and check operation of the unload table tilt.