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Internal: 734-00337A-EN Rev B
Release date: 24 October 2005

Procedure

Converting Debris Removal Cabinets to Use UDRC Filters

Background

Because replacement filters (Creo part number 55-0692) for debris removal cabinets are no longer available, the cabinets must be converted to allow the use of the filters used in the newer Universal Debris Removal Cabinets (UDRC).

Note: The debris removal cabinet should not be used for a minimum of 12 hours after applying the adhesive used in this procedure. It is important to schedule adequate down time for the cabinet before starting the conversion.

Requirements

Creo part number 512-00305A – Filter upgrade kit including:

- 252-09425A – large spacer ring
- 252-09426A – small sealing disk
- 252-09436A – ring seal
- 318-00013 – spring
- 312-00128 – M8 dowel pin
- 74-3400B – label
- 59-3829 – O-ring
- 57-8679B – filter spacer
- 50-2315C – chemical filter
- 252-01131B – particulate filter
- 89-0074 – silicon adhesive
- 653-01132A – upgrade procedure

Other tools and consumables needed:

- Utility knife
- Clean wipes (clean rags or paper towels are OK)
- Isopropyl alcohol

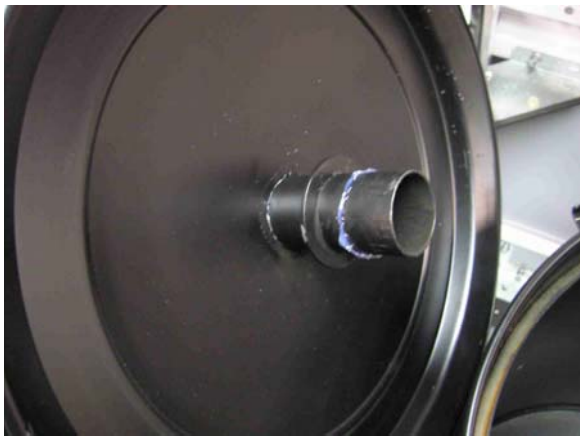
Procedure

All parts and adhesives used in this procedure are included in the conversion kit.

1. Open the debris removal cabinet lid and the canister lid.
2. Remove the old filter from the canister.
3. Remove the foam gasket from the inlet tube flange—use a utility knife if necessary.

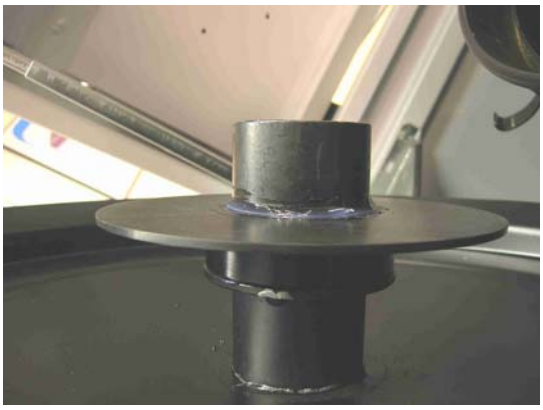


4. Using wipes and isopropyl alcohol, clean the inlet tube up to the flange and clean the flange on the inlet tube in the lid of the canister.
5. Place a small bead of adhesive around the inlet tube about one inch below the flange.

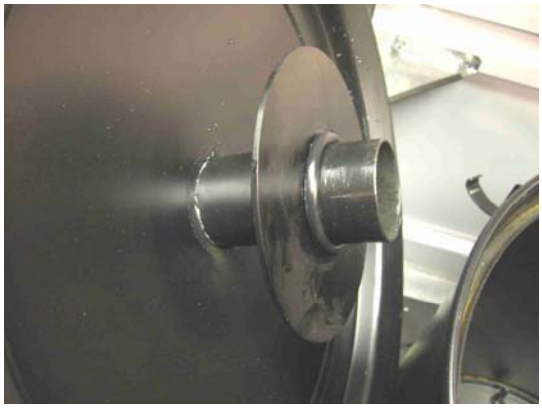


6. Slide the small disk and space ring over the inlet tube with the disk facing away from the flange. Rotate the disk while pushing it on until it contacts the flange.

7. Apply a small, continuous bead of adhesive around the inlet tube where it meets the disk.



8. Push the O-ring over the inlet tube until it contacts the disk and holds the disk in place. Wipe away any excess adhesive.



9. Locate the spring in the kit and push it over top of the filter presence switch so that the spring is approximately vertical. Lightly pull up on the spring. If it comes off, push it on further and wiggle it from side to side while pushing so that it stays in place when you gently pull it upwards.
10. Place the dowel pin into the spring.



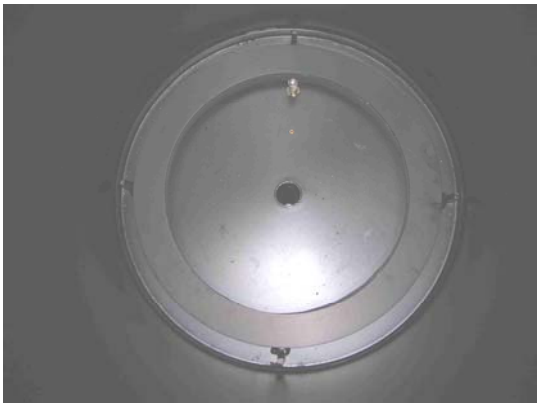
11. Clean the bottom of the canister with wipes and isopropyl alcohol. Clean particularly well in the spot where the foam gasket will be glued in step 15.
12. Apply a bead of adhesive to one side of the foam gasket. The bead should in the center of the width of the gasket and be about 1.5 mm (1/16 in.) thick and 6.5 mm (1/4 in.) wide.



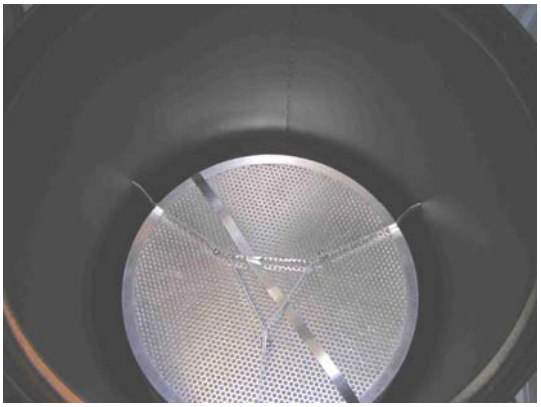
13. Align the inside of the gasket with the inside of the large disk and press the foam gasket onto it all of the way around.
14. Apply a similar bead of adhesive to the other side of the foam gasket.



15. Center the large disk inside the canister, with the adhesive side down and stick it to the bottom of the canister.



16. Place the chemical filter, identified by its short height, into the canister with the seal facing down. Make sure that you hear the switch click indicating that the presence of the filter has been detected. If it does not, adjust the spring and pin until you hear the click when the filter is placed into the canister.
17. Insert the filter spacer into the canister with the outer tabs facing upwards.



18. Insert the particulate filter into the canister with the foam gasket facing up.



19. Allow the adhesive to dry for at least 12 hours.
20. Close and lock the canister.
21. Close the debris removal cabinet.

22. Stick the label over top of the existing replacement filter label.



23. After the conversion is done to the debris removal cabinet, use the following Creo part numbers when re-ordering filters:
    - Particulate filter – 252-01131B
    - Chemical filter – 50-2315C

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