Upgrading unload table pulley and adding belt guide (FCO CA02183)

Applies to

☑ Trendsetter AL – MCE
☑ Trendsetter NEWS – MCE

Background

24-tooth pulley on unload table to be replaced by 16-tooth pulley. Belt guide added to reduce wear on non-rotator AL and NEWS.

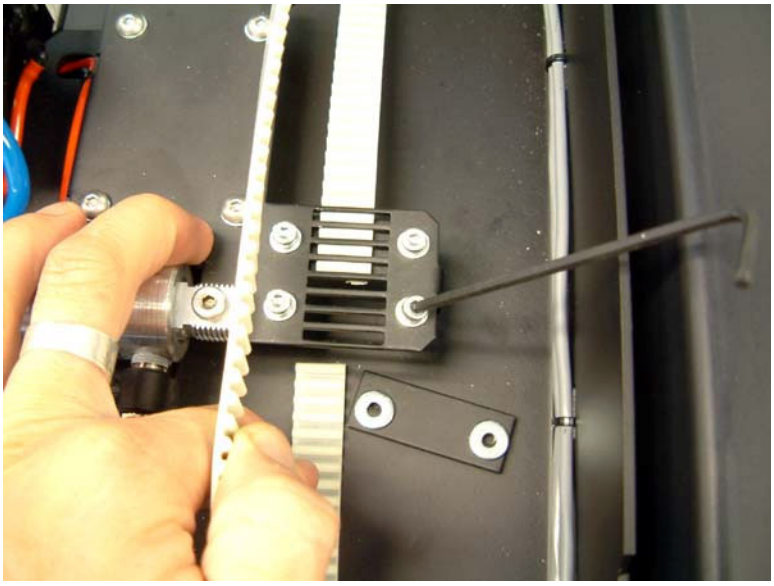
Tools and parts

- Hex keys
- Kit # 512-00072A for non-rotator
- Kit # 512-00073A for rotator

Steps

To replace the small, unload table pulley:

1. Remove the unload pan covers.
2. Loosen two M5 screws on the belt clamp bracket. Make sure to save the washers for reassembling the bracket.

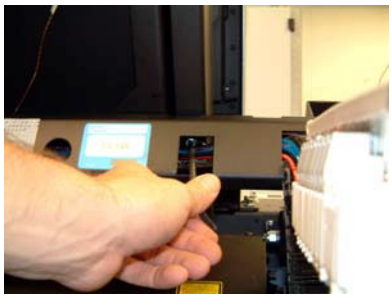


3. Remove the plate and the belt will fall off.
4. Raise the unload table to access the unload stepper motor assembly.

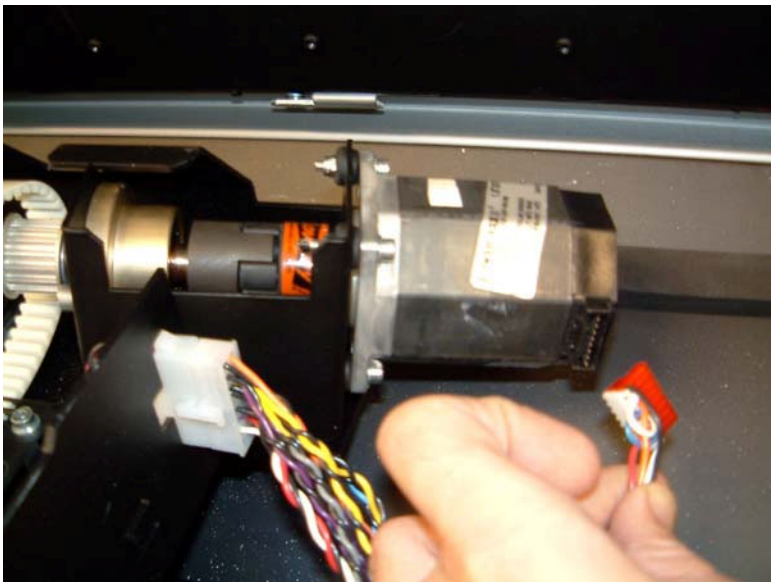


5. Loosen the four screws on the panel shown in photos.

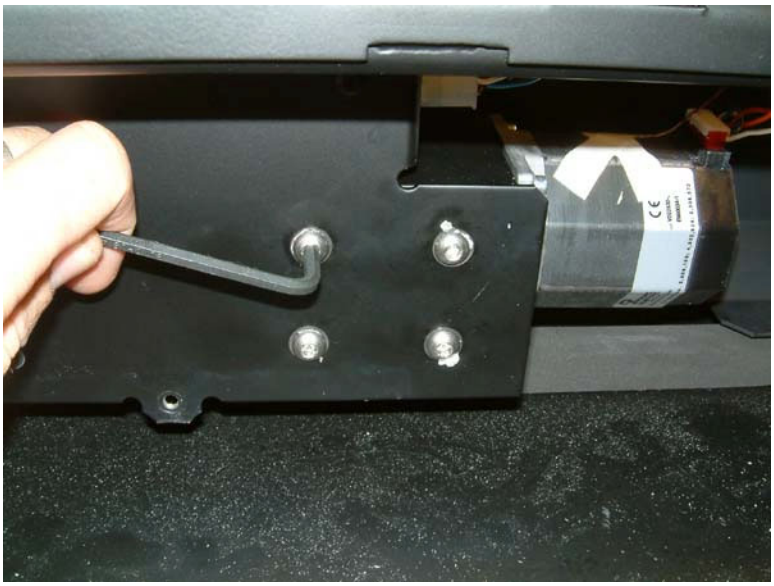




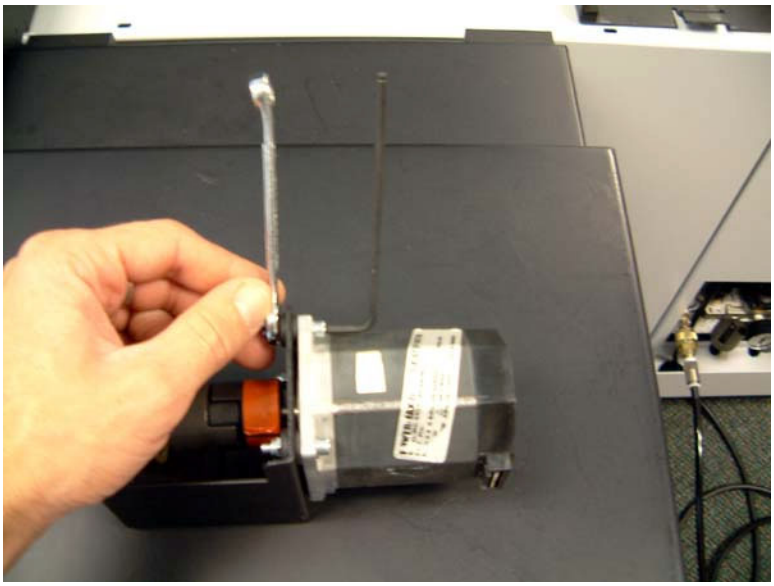
6. Remove the panel.
7. Remove the connector from the back of the motor.



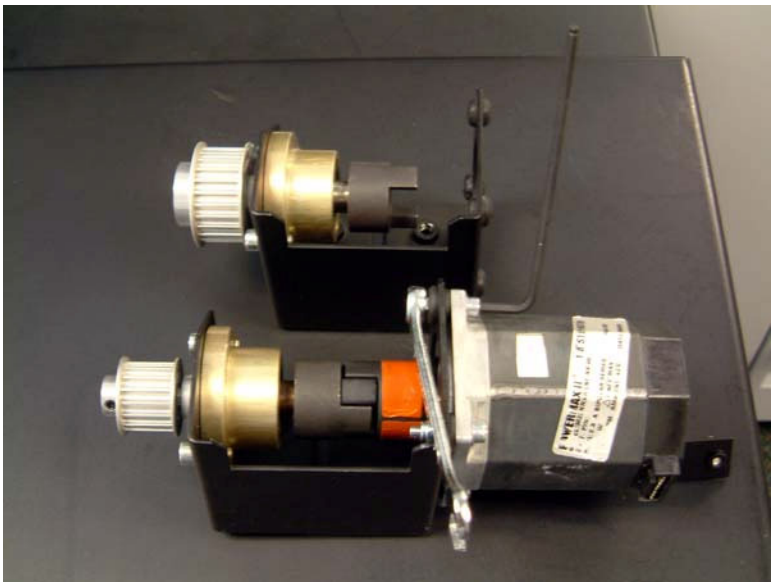
8. Remove the four screws that hold the motor assembly in place.



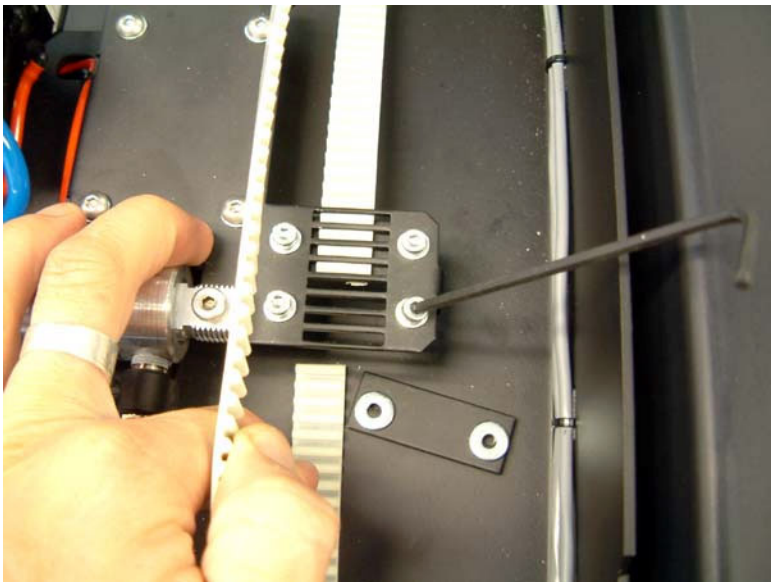
9. Remove the motor assembly.
10. Remove the four screws that attach the pulley assembly to the motor.



11. Separate the old pulley assembly from the motor.
12. Attach the new pulley assembly to the motor using the same screws.



13. Replace the motor assembly and panel.
14. Cut four teeth off the belt.

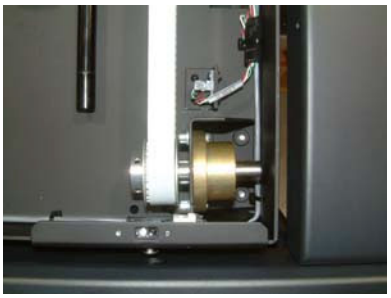


15. Reassemble the belt clamp bracket.
    Make sure that the washers are back in place.
16. If the device is a non-rotator, follow the procedure below - **To add the belt guide for non-rotator:**
17. Check the belt tension as follows:
    - Move the traveler to the Home position with the `TABLE MOVE HOME` command.
    - Place a 10mm hex key in the center of the belt.
    - Measure the distance between the top and bottom belt.
      It should be 1.8 cm.

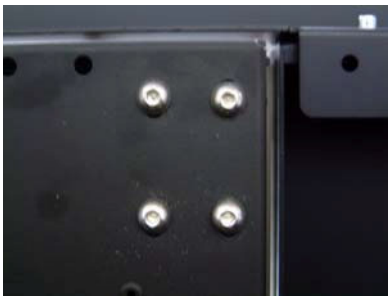


To adjust the belt tension:

- loosen the four screws on the bracket that holds the away pulley assembly to the unload pan and move as necessary.



top view



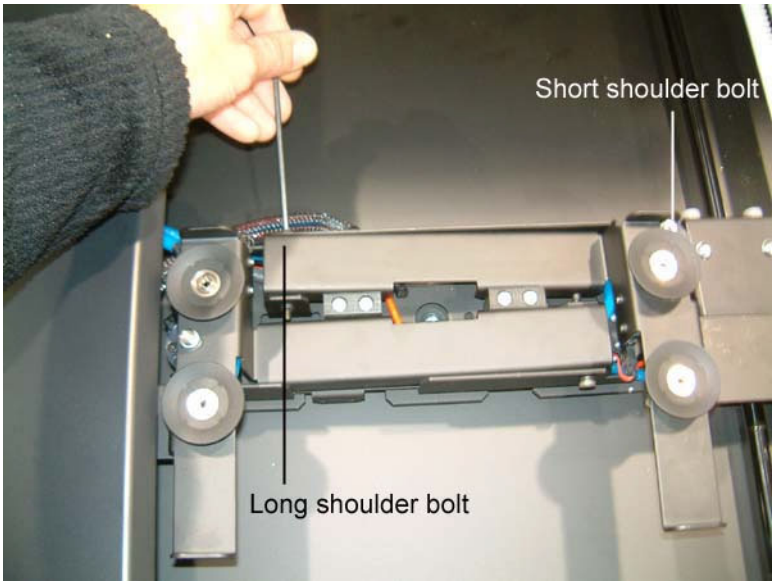
bottom view

18. Replace the unload table covers.
19. Set the following parameters:

```
set mhauto UnloaderMSR 2
set mhauto UnloaderSPM 2.550
```

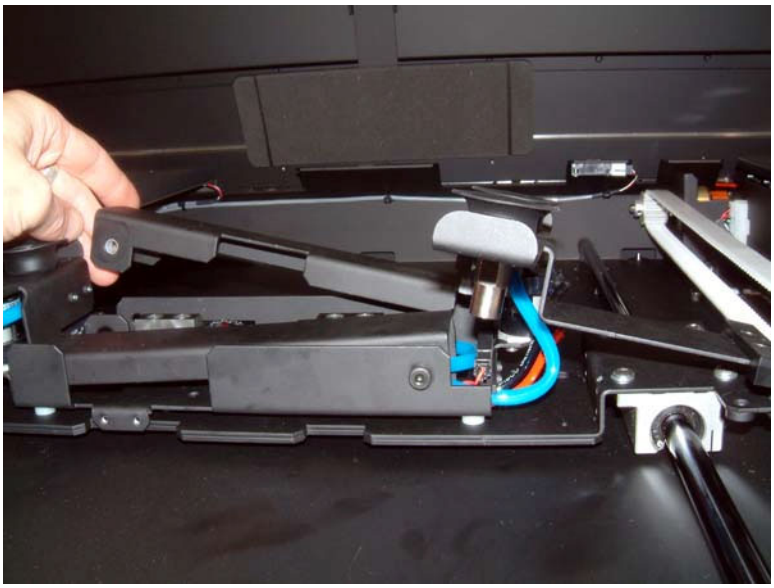
To add the belt guide for non-rotator:

1. Remove the long and short shoulder bolts on the traveler shown in photo.



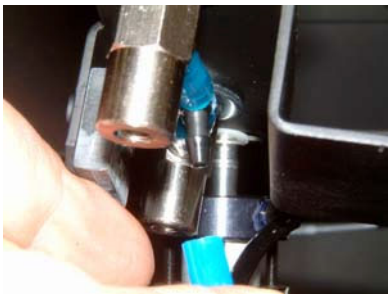
Make sure to check the washer and O-ring sequence for reassembly of the short shoulder bolt into the up/down cylinder.

2. Lift out the outrigger arm.

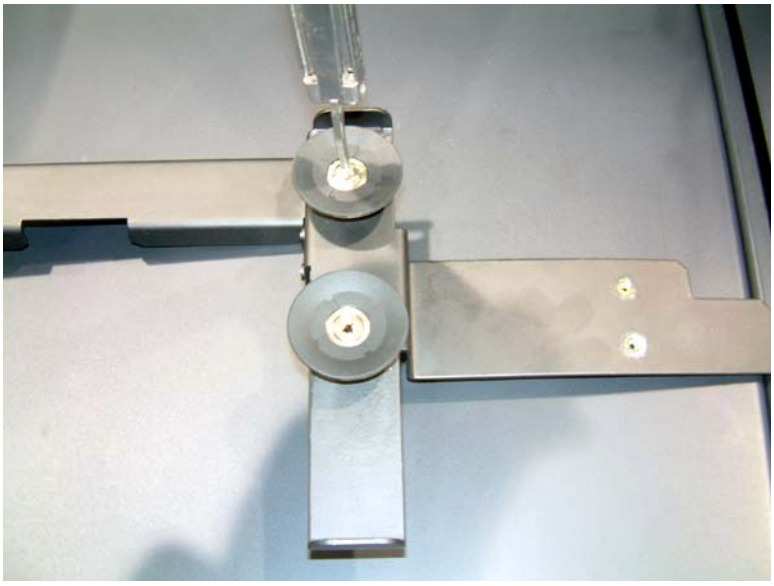


3. Remove the blue vacuum tube from the suction cup.

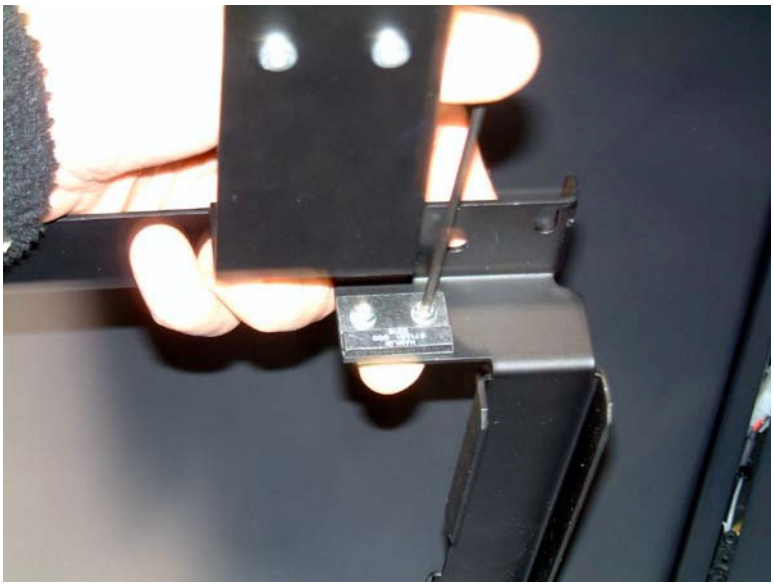




4. Remove the screws on the suction cups.



5. Remove the reed switch from the bracket.



6. Attach the reed switch and suction cups to the new outrigger arm.
7. Reinstall the outrigger arm on the traveler.
   Make sure that the washers an O-ring are in the correct sequence.
   Check the other shoulder bolt if you are not sure of the order.
8. Place the new belt guide on the traveler and tighten the screws.



9. Adjust the belt tension as described above.
10. Replace the unload table covers.
11. Set parameters as described above.

Notes	16-tooth unload table pulley is used for MCE devices
	24-tooth pulley is used on MPE devices
Technical contact	Chris Morley
Date submitted	13 Nov 2003
Date modified	