Repairing the unload table frame (FCO CA 09416)

Document number: 719-00640A-EN Rev A

Product

- Trendsetter® Autoloader
- Trendsetter ContinuousLoad

FCO priority

Next failure

Background

The unload table outrigger bracket can break when extra shock and force is caused by a worn pivot block.

Solution

A repair kit that includes replacement braces has been designed to accommodate three-hole or four-hole brackets. The braces include three threaded holes and one larger non-threaded hole to accommodate the clevis pin. The shims are to be used on the side where the flange is broken. Clevis pins and rod end cylinders are also replaced as part of this procedure.

Time required 1 hour

Parts required

Part Number	Part Name	Quantity
512-00350A	KIT,FCO CA09416,UNLOAD FRAME REPAIR	1

Tools required 89-0007 SUPP,GREASE,MICROLUBE GL261 (for lubricating the clevis pin)

Procedure

1. Shut off the air to the device.
2. With the unload table down, remove the side panels.
3. Lift up the unload table manually and keep it in position by putting a large hex key on both sides.
4. Remove the top access panels.

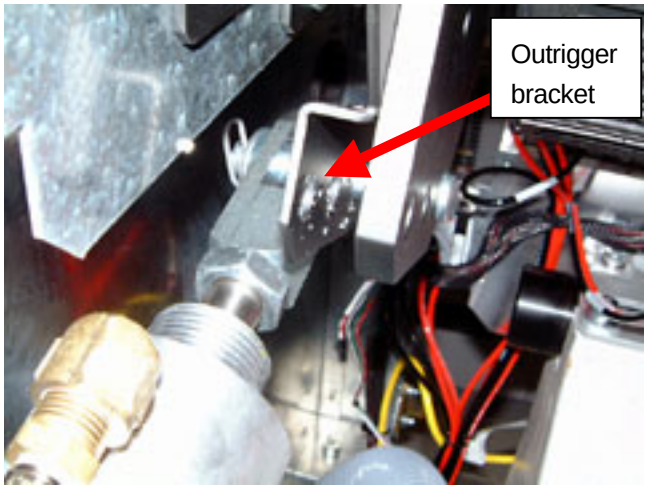


Photo 1: Outrigger bracket prior to the upgrade (and still intact)

Note: The remaining steps must be done on both the home and away side.

5. Remove the clevis pin on one side and discard.
6. Align the clevis pin holes in the new brace (252-07581A) with the table. The brace can be installed in two different ways depending on whether the device has three-hole or four-hole brackets. See photo 2.

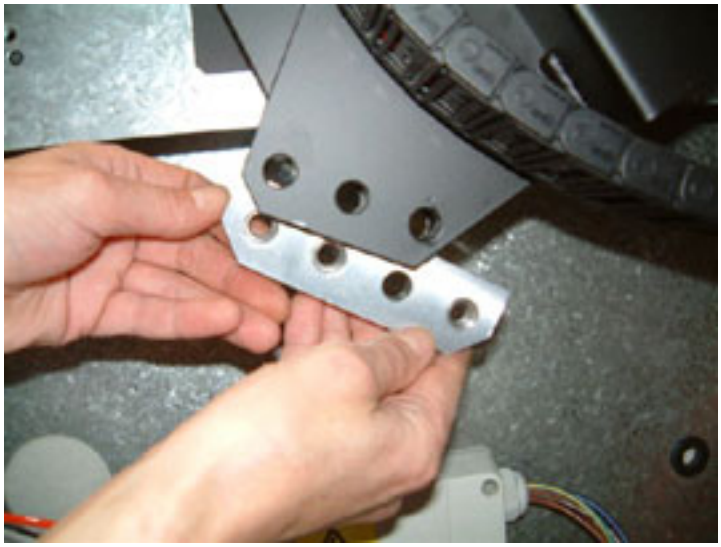


Photo 2: Fitting a three-hole bracket

7. If the flange (bracket) is broken, use the shim (252-07582A) provided in the kit.
   Place the shim between the unload table frame and the brace.
8. Use the M10 x30 socket screws to attach both the brace and the shim to the frame. See photo 3.

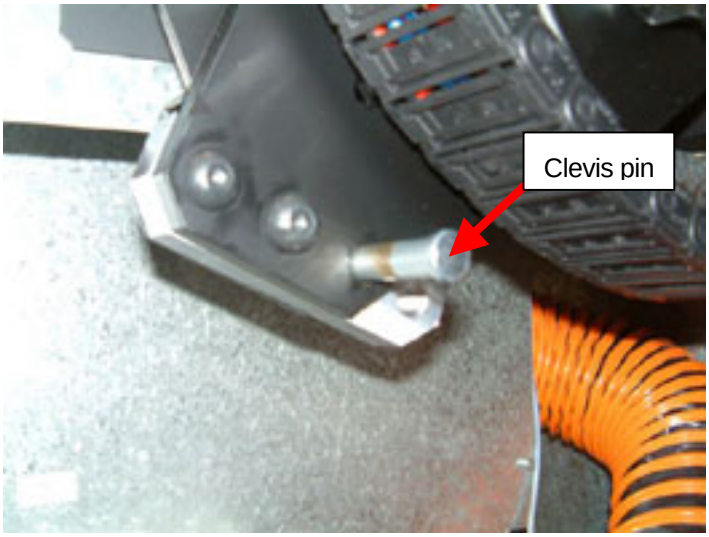


Photo 3: Brace installed

9. Grease a new clevis pin (52-4897) from the kit with Microlube GL261, or any other non-liquid mechanical grease.

10. Replace the old rod end of the cylinder with the one provided in the kit (55-0605).
11. Install the new clevis pin:
    - Place the washers (52-4072) between the rod end of the cylinder and the brace.
    - Make sure that adding the washers (up to two) does not cause some side-loading on the cylinder (leave some clearance). See photo 4.

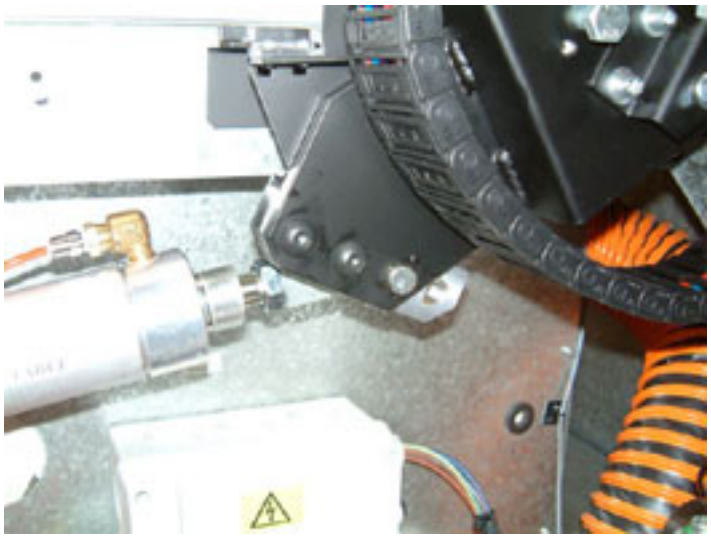


Photo 4: Clevis pin and new brace installed

12. Repeat steps 5 to 11 for the other side.
13. Lower the unload table.
14. Turn the air on.

Test

1. Turn the SIO key switch to the mechanical hazard position.
2. Use firmware commands to cycle the table up and down to confirm that the table is operating properly. Make sure that the reed switches are sensing the table position correctly.
3. Put the table down.
4. Reinstall the panels.

Technical contact	Cedric Galere
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