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Trendsetter VLF

Autoloader to Manual Device Conversion

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Revision History

Revision	Date	Author	Comments
Draft	13 April 2007	Al Edge	First draft
1	28 May 2007	A.Blignaut	Edited and formatted

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CONTENTS

Revision History i

Overview 1

Parts and tools required 1

Reference Documents 2

Procedure 2

OVERVIEW

This procedure describes how to convert a Trendsetter VLF Autoloader to a Trendsetter VLF manual device.

The following items will be removed:

Multi Cassette Unit (MCU)

Picker and track

Slip sheet removal unit (SSR)

Conveyor table

GENINE 0 (Trendsetter power box). Leave the GENINE cables inside the power box as it is not worthwhile to remove them.

The MCU, SSR, and the conveyor table must not be returned to the factory—they should be scrapped locally. Even though the MCU will not be reused and will probably be scrapped, the forks should be lowered to the floor before the device is switched off. This is for stability and safety.

The following items can be removed from the MCU and kept as spare parts:

GENINE boards

Power supplies

Power distribution board (PDB)

KEBCO inverter (MCU fork motor driver)

The following items are not removed or changed:

Load table

Guard rails

Start button and abort switches (mounted on the rails)

PARTS AND TOOLS REQUIRED

10-4943A	CAB,ASSY,BASE ESTOP JUMPER,VAL	Qty: 1
55-0595	Plug,1/2 in.,Quick	Qty: 2
90-1182A	Tool,track support,wood,VAL	Qty: 2

04-0018A Trendsetter VLF AL Installation Tools and Fixtures. This kit includes the track support tools, jacks, wheels, and other items.

REFERENCE DOCUMENTS

73-3674A-B-PR01 *Production Upgrade Procedure* (el./mech.) - TSV to VAL. This document describes how to upgrade a manual device to an autoloader device. It is the reverse of this procedure but it has some helpful information.

725-00004A-A-PR01 *Trendsetter VLF AL Field Disassembly Procedure*. This describes the procedure to disassemble the device. The parts will be scrapped locally so disregard the section about preparing for shipping.

TechPlanet –Trendsetter VLF installation page. This page has the installation procedures for the Trendsetter VLF Autoloader. Refer to the page: AL Upgrade of an AL-Ready Trendsetter VLF

PROCEDURE

Before performing this procedure, the Trendsetter VLF Autoloader and the MCU must no longer be in use.

1. Unload all plates from the MCU. The plates can be reused after the Trendsetter VLF is converted to a manual device.
2. Once the plates have been unloaded, use the switches inside the MCU to lower the forks to the floor.
   Note: If you want to remove the cassettes first, follow the procedure in document: 725-00004A-A-PR01.
3. Enter the following commands to set the parameters for a manual device:
   ```
   >>set al pbin 0
   >>nvs save al
   ```
4. Switch off the power and the air to the device.
5. Disconnect the SSR umbilical and remove the slip sheet bin.
6. Roll out the SSR and remove the ramp.
7. Remove the guide rail on the side of the Trendsetter VLF and remove the plexi-glass safety cover on the side of the MCU.
8. Disconnect the MCU umbilical cable and air hose.



Figure 1: Umbilical cables connected to the MCU

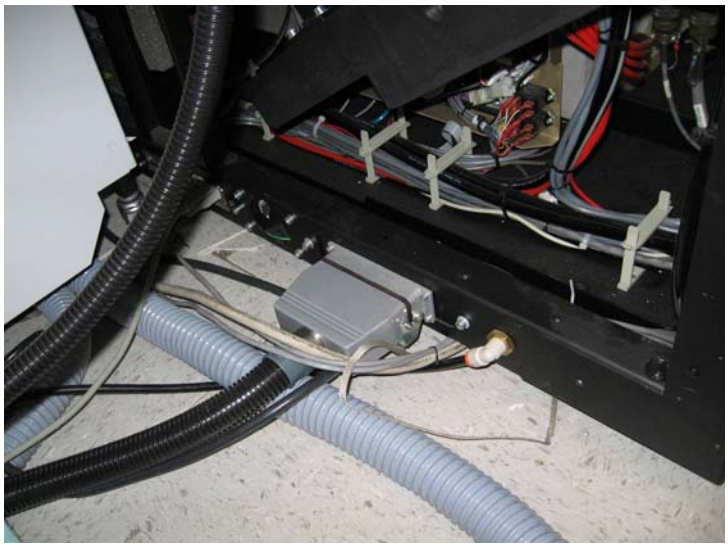


Figure 2: MCU umbilical cable at the base device

9. Install the casters on the MCU—see procedure 725-00004A-A.
   Note: If there is room to get a forklift to the MCU, you do not need to install the casters. The MCU can be picked up with the forklift and taken away.
10. If the device has a Garage (SCU) instead of a MCU, follow the procedure in 725-00004A to remove the garage.
11. Disconnect the conveyor and remove the connection plate. Remove the conveyor.

12. Pull the picker to the center of the table and remove the picker cover.

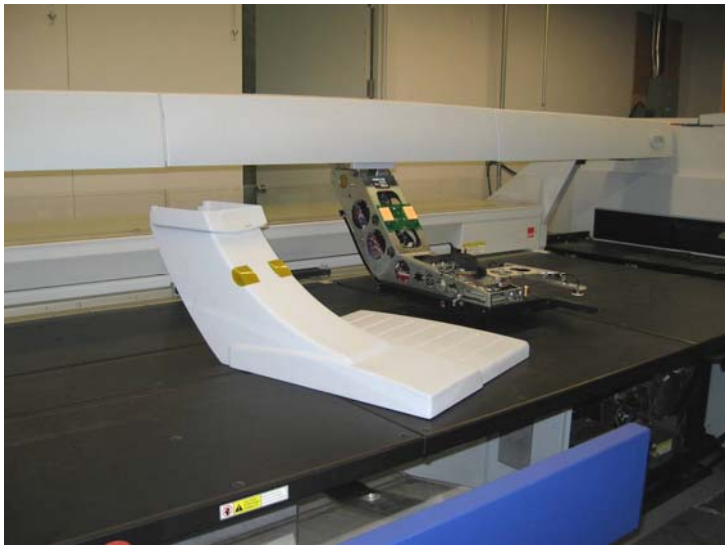


Figure 3: Picker and cover

13. Disconnect the cables and hoses that connect the picker to the picker track.

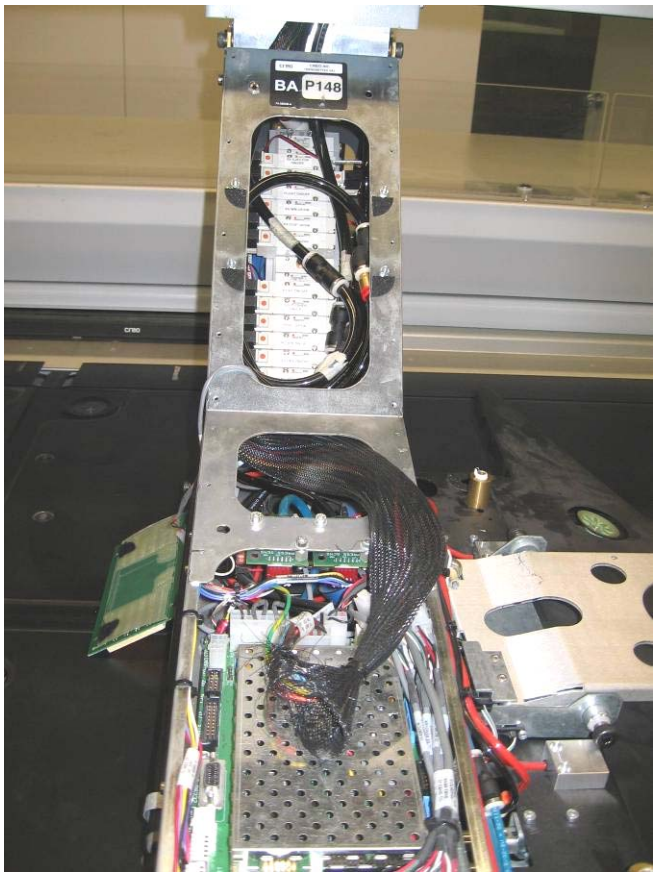


Figure 4: Picker hoses and cables

14. Remove the shoulder bolts that attach the picker to the carriage and remove the picker.

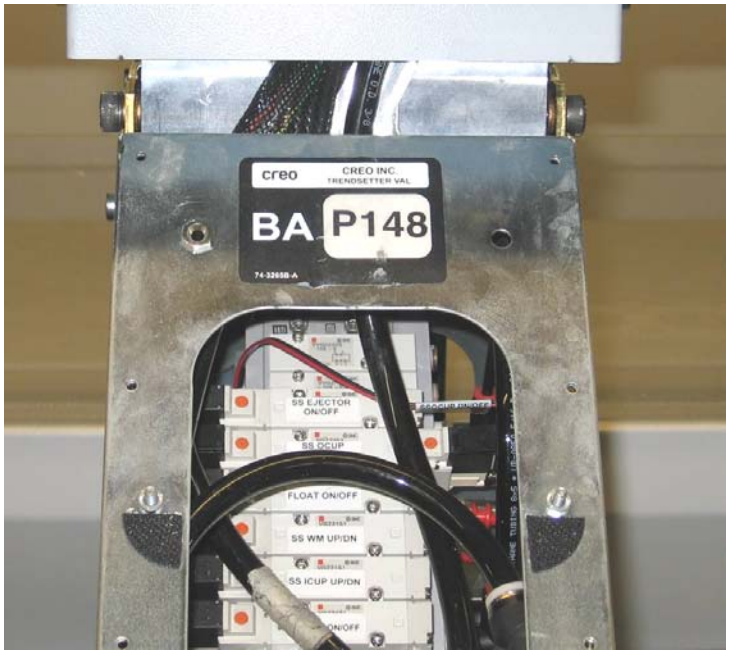


Figure 5: Remove the two shoulder bolts to disconnect picker

15. Remove the covers on the picker track and remove the Plexiglas shields on the hood of the Trendsetter.
16. Remove the picker drive motor and disconnect all cables and hoses so the picker track can be removed without interference.
17. Install the two picker track supports (90-1182A Tool,track support,wood,VAL) under the picker track. These will support the picker track when the screws are removed.



Figure 6: One of the 90-1182A track support tools in place



Figure 7: Track support tool alignment

18. Remove the four bolts at each end of the picker track that attach the track to the track arm bracket. Be careful because the picker track will drop slightly on to the wood support tools after the fasteners are removed.
19. With the aid of a helper, lift the picker track off the supports and dispose of it.
20. Remove the picker track support arms.
21. With the aid of a helper, remove the last two bolts and lift the picker track off the picker track support arms.
22. Pull all hoses and cables down through the picker track support arms and disconnect the cables at the first connector. The cables are all separate from the base device so they can also be coiled up and tied out of the way.

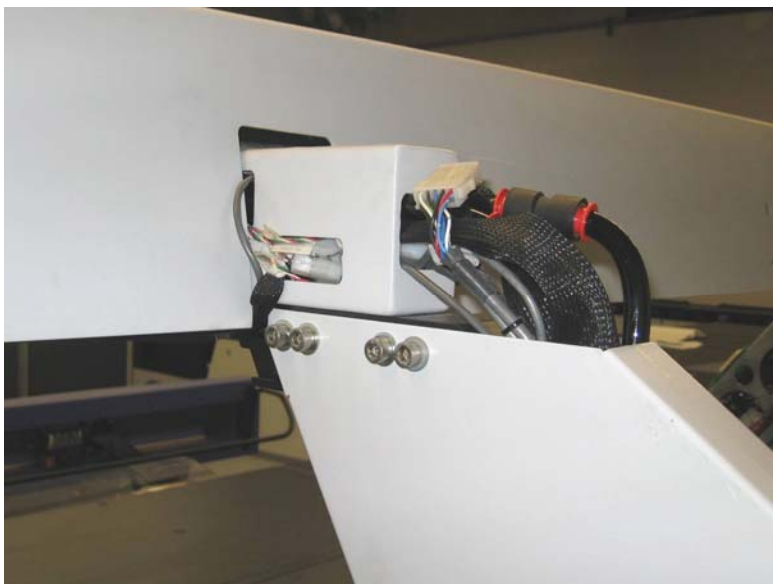


Figure 8: cables and hoses to picker track



Figure 9: Cables from picker track to be removed.

23. Remove the cover over the air filters. Locate the two ½" black hoses that supply air to the picker and remove them. Insert the two plugs (55-0595) into the picker hose fittings on the air filter assembly.

24. Install the bypass plug (10-4943A) to bypass the MCU safety loop. Disassemble the MCU umbilical connector and remove the cable and connector modules. Install the 10-4943A plug into the connector shell and install it into the umbilical connector in position 6 (the right-hand connector next to the 'a'). Pins 1 and 2 have a jumper to bypass the MCU abort button. The umbilical connector can be locked in place so the bypass will not fall out.

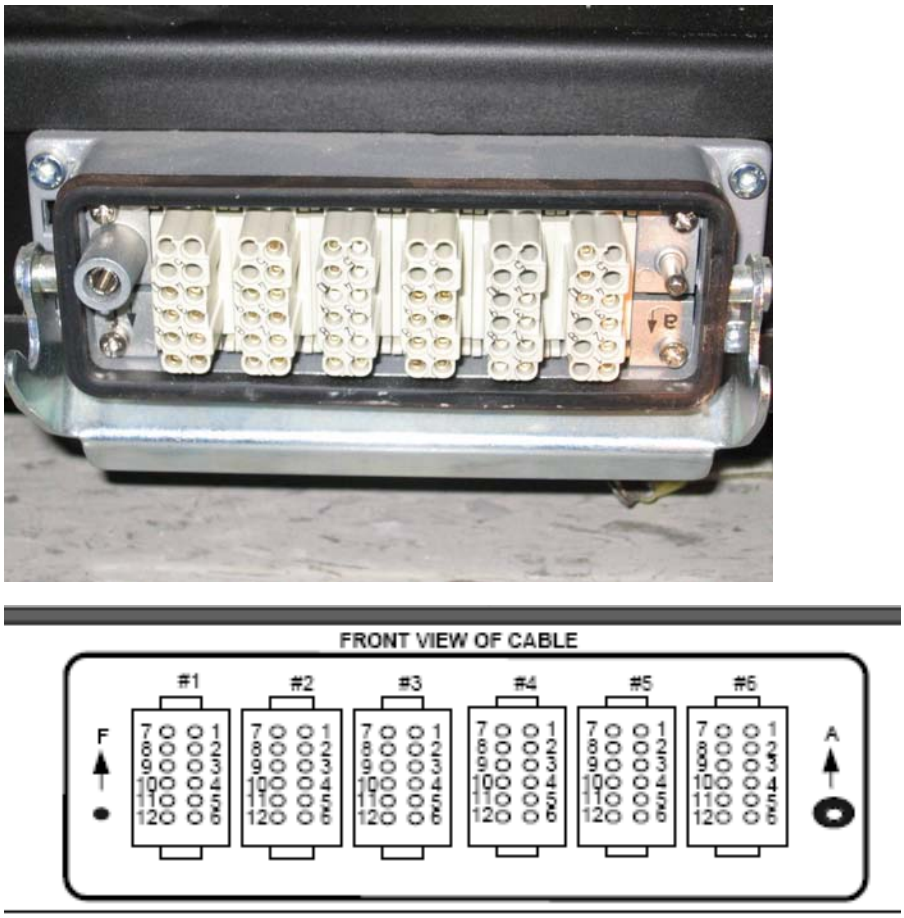


Figure 10: Umbilical connector on the base device

25. Close all panels on the device and turn on the air and power. The device should recognize that it is now a manual device.

26. Check that the abort switches are OK and that the start button works correctly when a plate is loaded.