Trendsetter VLF AL

Field Disassembly Procedure

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Creo Inc.
3700 Gilmore Way
Burnaby, BC
Canada V5G 4M1
(604) 451-2700

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1. PREPARATION

1. On the workstation, type nvs init stats, then list stats to zero the statistics counters.
2. Back up the NVS parameters using the nvs dump command. Store the files on disk.

2. THERMAL HEAD

1. Raise the table.
2. Remove the front panel and the top panel.
3. Center the carriage at 45000.
4. Put a static strap on your wrist.
5. Remove the debris nozzle.
6. Disconnect the cooling lines, thermocouple, and power cable.
7. Release the vacuum sensor.
8. Disconnect all fasteners. Don't forget the setscrews at the bottom.
9. Loosen the debris/cooling hoses that pass in front of the head for easier access to the head.
10. Lift the head out and place it in its box with anti-static packaging.

3. CHILLER

1. Disconnect the inlet hose and drain the coolant into a plastic jug.

   Note: Dispose of the coolant safely. See the product's Material Safety Data Sheet (MSDS) on TechPlanet: http://techplanet.creo.com/output/computer_to_plate/all_ctp/nav/chiller.htm#MSDS.

2. Disconnect the outlet hose.
3. Place the unit in its crate.

4. SLIP SHEET REMOVAL SYSTEM (SSR)

1. Disconnect the SSR power cord and air tubing from the MCU or the garage. Put the umbilical cord in the shipping kit.
2. Empty the slip sheet bin. Vacuum the bag to clean out any residue, then roll the bag up and put it aside. (It will go on top of the SSR unit during crating.)
3. Pull the SSR unit out. See Figure 1. Clean its sides.

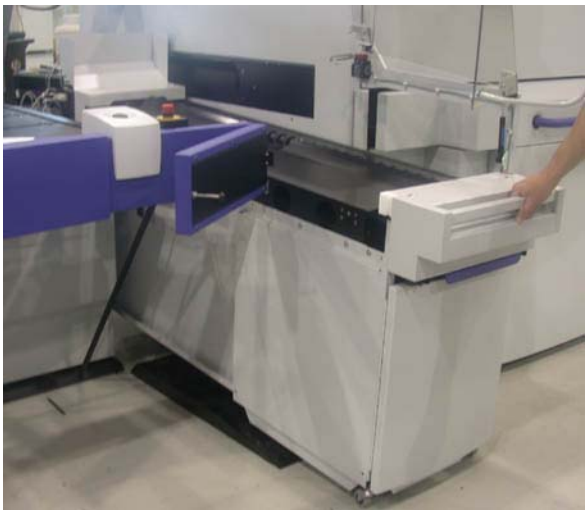


Figure 1: Removing the Slip Sheet Unit

4. Remove the SSR ramp and put it in the shipping kit.
5. Dismount the SSR safety lead edge and put it in the shipping kit.
6. Dismount the SSR guide rail on the base machine and put it in the shipping kit.

5. MCU

1. Open the chariot and remove the front panel.
2. Lower one cassette in the chariot.
3. With one person lifting each corner of the cassette, remove it carefully and slowly. Place it on two dollies, resting the rails under the cassette on blocks of foam.

   Note: It requires 4 people to lift a cassette safely.

4. Remove the guide rails and cassette stops from inside the cassette. Put them aside to be wrapped later during crating.
5. Vacuum the inside of the cassette, and then wipe it with glass cleaner and a towel.
6. Put a thin layer of green foam and a plywood insert on top of the cassette to hold the arborite in place during shipping. See Figure 2.

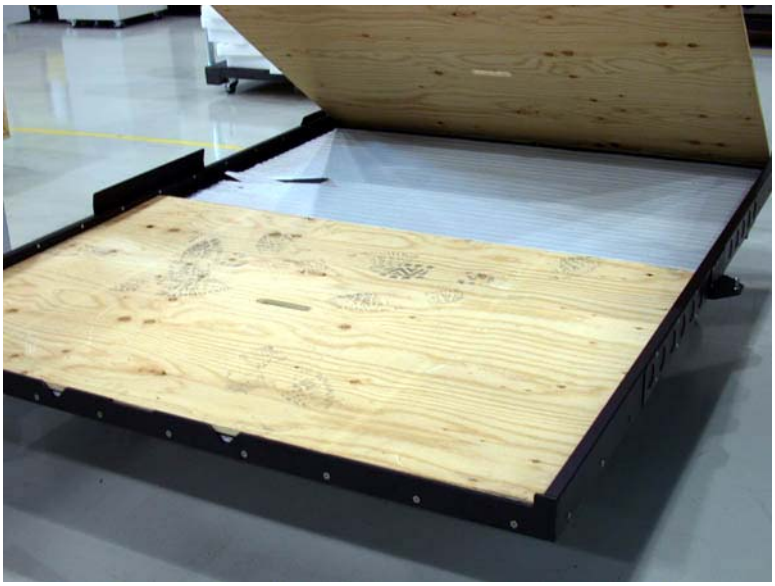


Figure 2: Cassette Protected by Foam and Plywood

7. Place 4 blocks of high-density white foam on top of the plywood to separate the cassette from the next one.

8. Repeat Steps 2-7 for the other 3 cassettes, creating a stack of cassettes on the dolly with foam and plywood between. Finish with a layer of green foam. See Figure 3.

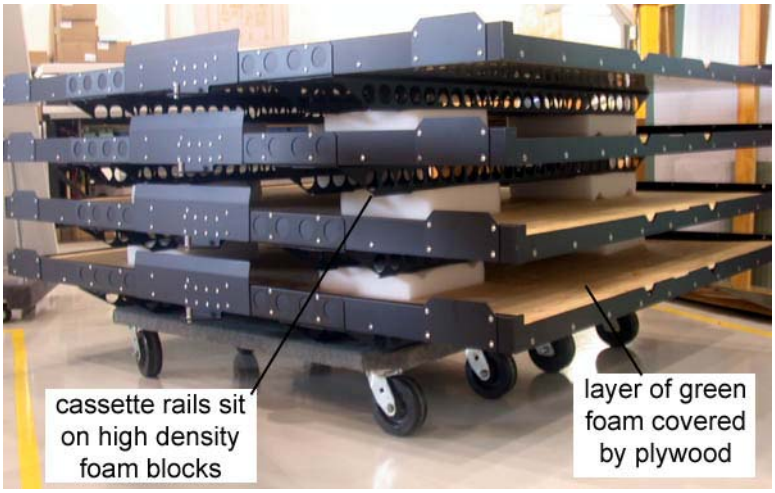


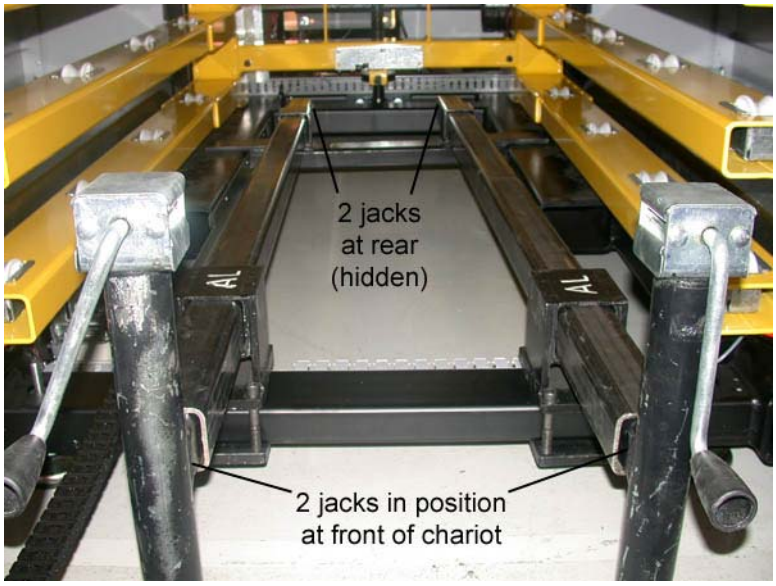
Figure 3: Cassettes Stacked for Shipment

9. Disconnect the power cord and the air hose. Coil them with tie wraps and put the umbilical cable in the box.

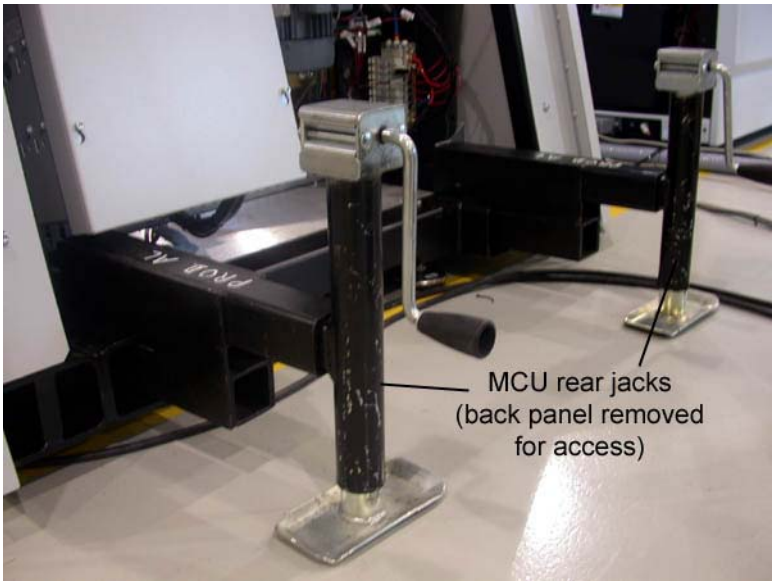
10. Clean the leadscrew.

11. Remove the back panel.

12. Position the jacks, 2 in the front and 2 in the back, and raise the MCU. See Figure 4.



(a) Jacks at front of MCU



(b) Jacks at rear of MCU

Figure 4: Raising the MCU

13. Raise each foot so that it is close to the frame. Use tape to attach the foot firmly to the frame. See Figure 5.

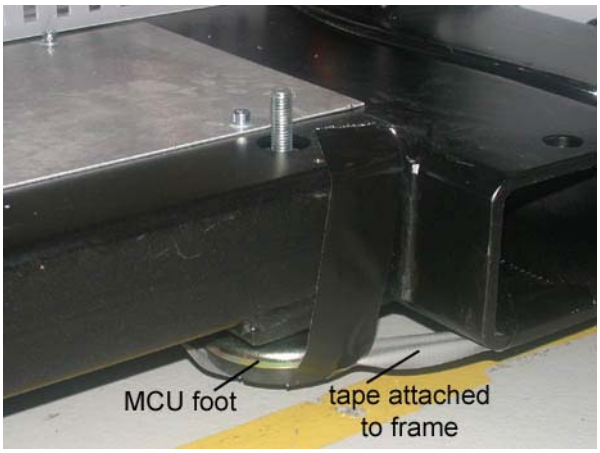


Figure 5: MCU Foot Taped to Frame

14. Attach the casters and make sure the screws are secured.
15. Lower the MCU onto the casters.
16. Place all the cables inside the power box. Check that no cables are missing.
17. Replace the front and back panels.
18. Close the chariot.

6. GARAGE

1. Disconnect the wiring and air hose. Coil them with tie wraps.
2. Adjust the height of the garage down to its lowest position.
3. Adjust the casters on the cassette cart down to their lowest positions.
4. Untie the clamp plates and support strut. Lift the garage out of the floor plate assembly, with its base plate still attached, and place it on a dolly.
5. Remove the floor plate assembly from under the base machine. Disassemble it and put the back beam and angle beam in the track crate.
6. Place all the cables inside the power box. Check that no cables are missing.
7. Replace all panels. Clean them and do any necessary touch up.
8. Raise the tongue of the cassette cart to its top position and secure it.
9. Lower the cassette cart to its lowest position by turning the bolts on top of the casters counterclockwise.
10. Check that all the screws on the cart are secure.
11. Repeat Steps 8-10 for any other cassette carts.

7. CONVEYOR

1. Disconnect the safety switch wiring.
2. Dismount the conveyor connection plate from the base machine. Put it in the shipping kit. See Figure 6.



Figure 6: Dismounting the Conveyor Connection Plate

3. Place all the cables inside the leg pod. Secure them with push mounts and tie wraps.
4. Replace all panels.
5. Check that the filler strip is inserting into the frame on the device side.
6. Check that the top panels are secured with M6x20 socket cap, full thread screws (52-3218). There should be 2 screws on each panel.
7. Clean all the panels and do any necessary touch up.
8. Cover the top panels with foam.

8. PICKER/TRACK/SUPPORT ARM

1. Detach the cable for the track lights (2 screws underneath at the end of the track).
2. Remove the skins from the track and picker. Place them on the foam on top of the conveyor to be bubble-wrapped later during crating.
3. Pull the scon connector cable out and ground it. See Figure 7.

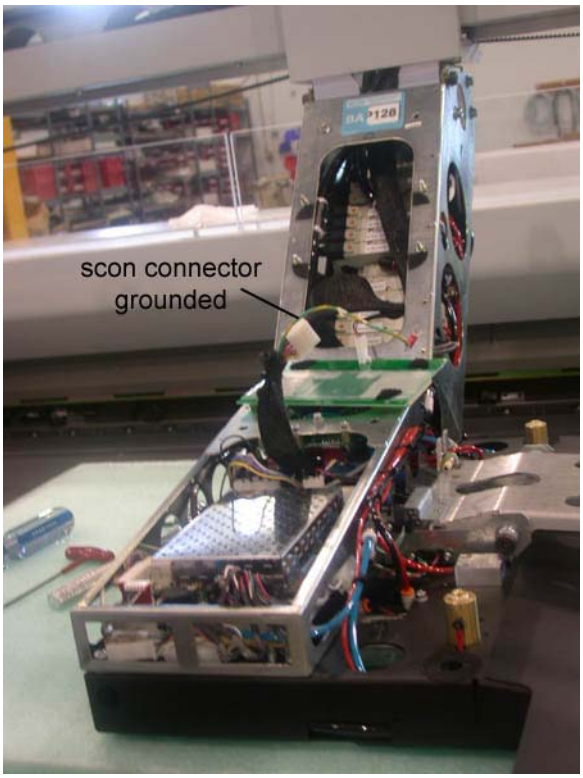


Figure 7: Picker with Skins Removed and Scon Cable Grounded

4. Disconnect all hoses.
5. Loosen the shoulder screws on the picker carriage. See Figure 8.

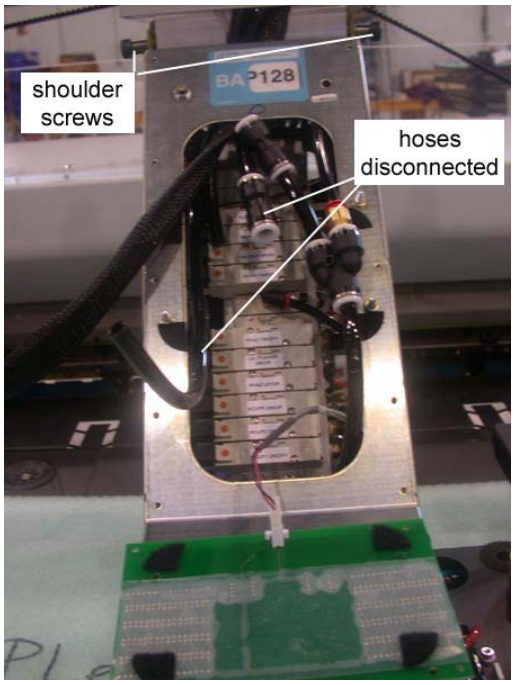


Figure 8: Removing the Picker Body

6. Disconnect the air hose and wiring.
7. Remove the shoulder screws and lift the picker body off.
8. Replace the shoulder screws on the picker carriage.
9. Clean all the track and picker skins, and do any necessary touch up.
10. Slide the picker carriage to the motor side to align with the hole on top of the track.
11. Insert an M4*45 socket cap screw (52-3207) to hold the carriage in position.
12. Remove the stepper motor and place it in the shipping kit. See Figure 9.

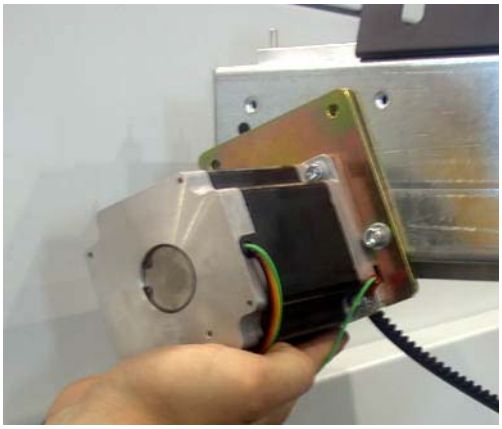


Figure 9: Removing the Stepper Motor

13. Replace the screws and tie the belt on the motor side with a tie wrap so that it will not catch on anything.

14. Remove the screws that fasten the support arms.
15. Place 2 thin layers of foam or plates on the table, lined up with each end of the track. Place a wooden block on top of each piece of foam/plate.
16. With a person on each end, lift and remove the track. Rest it carefully on the wooden blocks. See Figure 10.

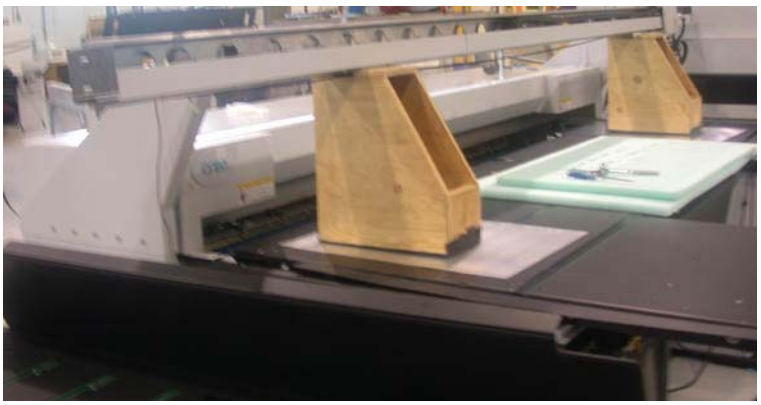


Figure 10: Track Removed onto Blocks

17. Disassemble the support arm heads and put them aside for wrapping. Replace the screws and tighten them securely. See Figure 11.

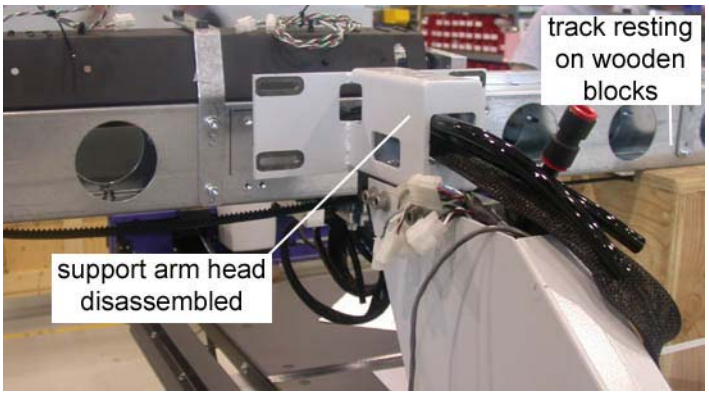


Figure 11: Support Arm Head Disassembled

18. Coil all cables inside the top of the support arms. Put them in an anti-static bag and fasten it with anti-static tape. See Figure 12.



Figure 12: Cables Stored in Support Arm

19. Place the track inside its crate.

    Note: If an SCU has been disassembled, the garage floor plate beams should already be inside the crate.

9. BASE TRENDSETTER VLF

1. Remove all front and back panels.
2. Remove the guard rail interface panel and put it aside for wrapping.
3. Dismount the guard rails and put them aside for crating.
4. Position the jacks and raise the base machine.
5. Turn the adjustable feet to their top position. Fasten them securely with duct tape.
6. Attach the casters and ensure that the screws are secure.
7. Vacuum carefully inside the machine. Watch particularly around the plate flyoff sensor and mirror, making sure that you do not alter the alignment.
8. Wrap the carriage flex track cables in an anti-static bag and fasten it with anti-static tape. See Figure 13.

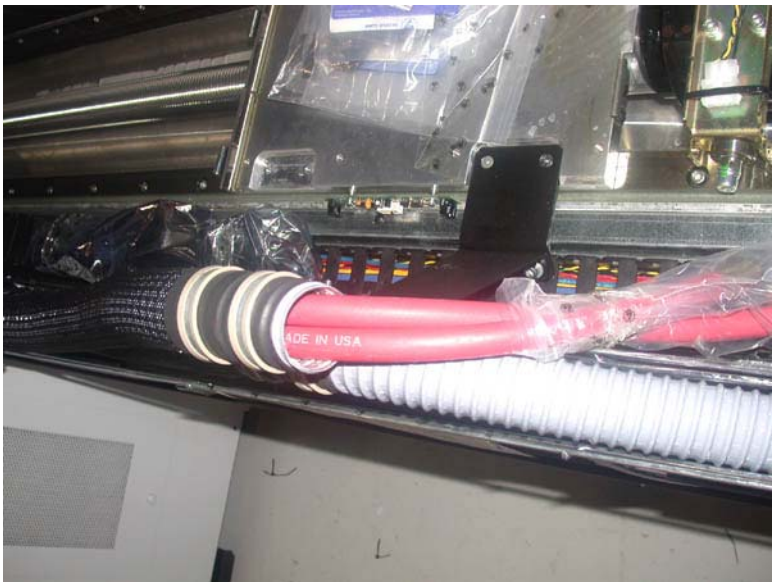


Figure 13: Flex Track and Hoses Wrapped

9. Lift the hose tray up into its higher position for forklift access. Attach a sign to the center of the hose tray as a reminder that it is needs to be lowered before the device is operated. See Figure 14.

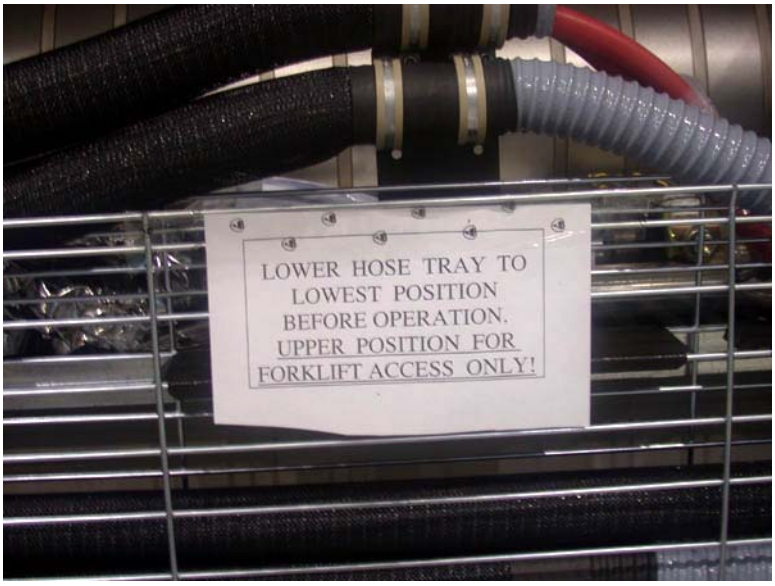


Figure 14: Hose Tray Lifted

10. Clean the center panel with alcohol and apply 2 foam strips.
11. Replace all front panels.
12. Tape over the air line fitting and chiller line fittings.
13. Lift the hood.
14. Rotate the drum so that the magnets are facing you.
15. Push 3 foam blocks under the drum and secure them with tape. See Figure 15.



Figure 15: Foam Wedged under Drum

16. Insert 6 pieces of foam on the shafts of the backbone cylinders. See Figure 16.

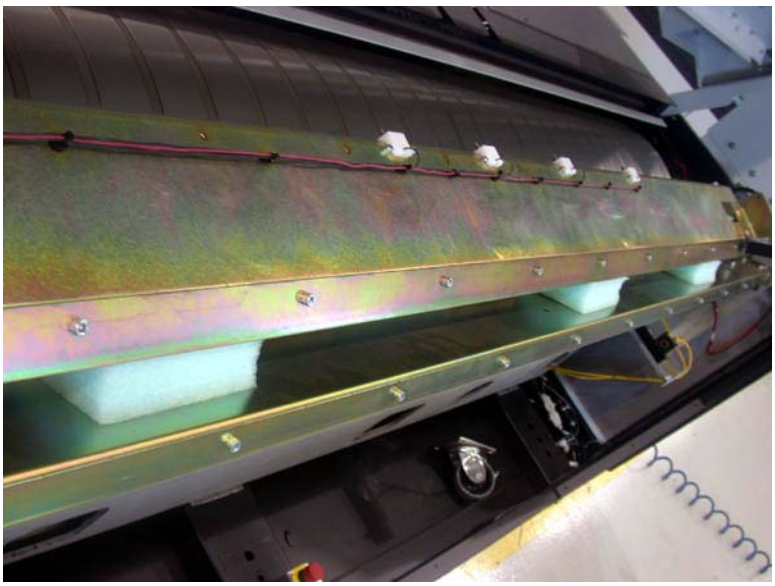


Figure 16: Foam Wedged Under Backbone

17. Insert 11 pieces of foam along the backbone between the roller and drum. The foam will need to be rotated slightly to fit in snugly. Secure them with 30 cable ties. See Figure 17.



Figure 17: Engine Packed for Shipment

18. Raise the p-door to the open position. Hold it in place by inserting a piece of foam into the pocket of the hood at both ends. See Figure 18.

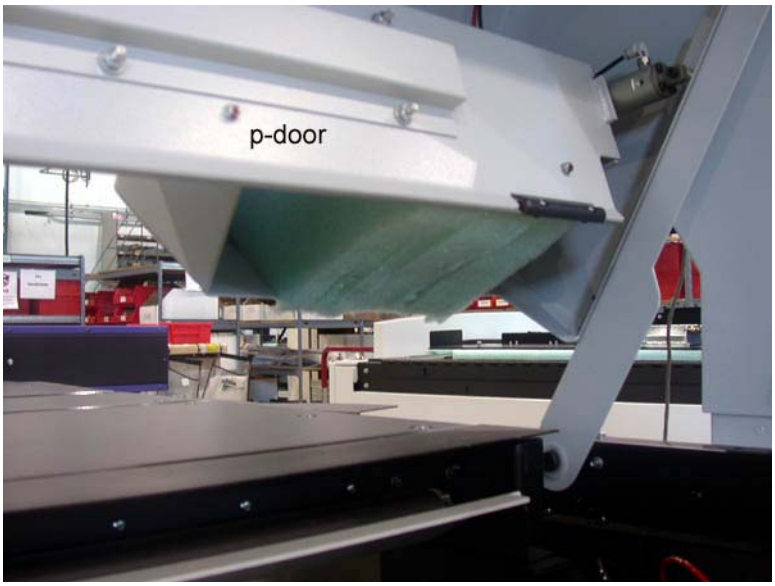


Figure 18: Foam in Pocket of Hood, Behind P-Door

19. Close the hood.
20. Open the left front panel and shut off the air supply to the base machine.
21. Clean the arborite on the table with glass cleaner
22. Remove all the table rubber bumpers. Put them in the fastener box.
23. Use table support blocks to fix the table in its up position. See Figure 19.



Figure 19: Table Supports

24. Place a washer (52-4011) above each spacer to prevent the top panel being pulled by the screw.
25. Place an M8*80 socket-cap screw (52-4651) and 2 M8 heavy washers (52-3236) to attach the crate on the top of the top panels. Use 2 washers on the power box side and one washer on the other side.
26. Disconnect the air line and the power cord.
27. Dismount the air line coupling and return it to the main frame assembly.
28. Put tape over the air line fitting and the chiller line fittings.
29. Put tape over the fittings going to the MCU/SCU and to the conveyor.
30. Replace all panels. Clean the panels and do any necessary touch up.