

VLF Trendsetter AL

Wedgemaster Upgrade

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Revision History

Revision	Date	Author	Comments
A	July 2001	Jon Dahlgren	Initial release

CONTENTS

1. Overview.....1

2. Tools Needed.....1

3. Upgrade Procedure.....1

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VLF Trendsetter AL
Wedgemaster Upgrade

1. OVERVIEW

The purpose of this upgrade is to more effectively stuff the slipsheet into the pinch rollers. The new cylinder mount block (50-2390A) enables the wedgemaster cylinder to push down while the picker is dragging the slipsheet over the pinch rolls. This should prevent the slipsheet from skipping over the tops of the rollers and getting dragged out onto the table.

This function is only active when the picker vacuum cups are on.

When the slipsheet is initially being picked, the wedgemaster falls under its own weight to prevent marking the plates.

2. TOOLS NEEDED

Upgrade kit: 05-2027

Drawings: 50-1742C schematic diagram and assembly drawing and 50-2390A assembly drawing.

3. UPGRADE PROCEDURE

1. Remove the old cylinder mount block and discard. Mount the new cylinder mount block (50-2390A) as shown on page 3 of the assembly drawing 50-1742C.

2. Plumb the hoses as shown on the schematic diagram of 50-1742C.
   Note: The changes are outlined by a dashed line.
   To make sure that none of the hoses get kinked or pinched, run the two 5/32” black hoses from the new cylinder block (50-2390A) up into the main picker arm. This will also give you more space to install the 5/32” Y-connector.

3. Install the 5/16” Y-connector by cutting the 5/16” hose that runs to the vacuum cup vacuum generator. Refer to the Pneumatic diagram (50-1742C) for details.

These changes were covered in ECO E256. Pickers built after picker serial number P071 already have the changes complete. Contact Jon Dahlgren with any questions.

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APPLY A DAB OF NAIL POLISH
OR SIMILAR TO THESE FASTENERS

585 / 1

510 / 8

520 / 8

THIS SET SCREW MUST BE ADJUSTED SO THE PCUP ARM IS HORZONTAL WHEN IN THE UP POSITION. (AIR MUST BE ON)

AS A CHECK, MAKE SURE THE PCUP ARM DOES NOT HIT THE PICKER COVER WHEN IT IS UP.

AFTER ADJUSTMENT TIGHTEN UP THE JAM NUT.

586 / 2

340 / 1

EXPLODED VIEW OF PICKER AND ARM ASSY

15 Nm

520 / 6

510 / 6

580 / 1

300 / 1

4.5 Nm

460 / 1

ALIGN PICKER BODY TO ARM IN ASSY JIG, USE SHIM WASHERS AS REQ'D.

BODY - TOP COMPONENTS SHOWN ON SHEET 02

BODY - UNDERNEATH COMPONENTS SHOWN ON SHEET 03

BODY - ASSEMBLIES UNDERNEATH SHOWN ON SHEET 04

SLIP SHEET PICKER COMPONENTS SHOWN ON SHEET 05

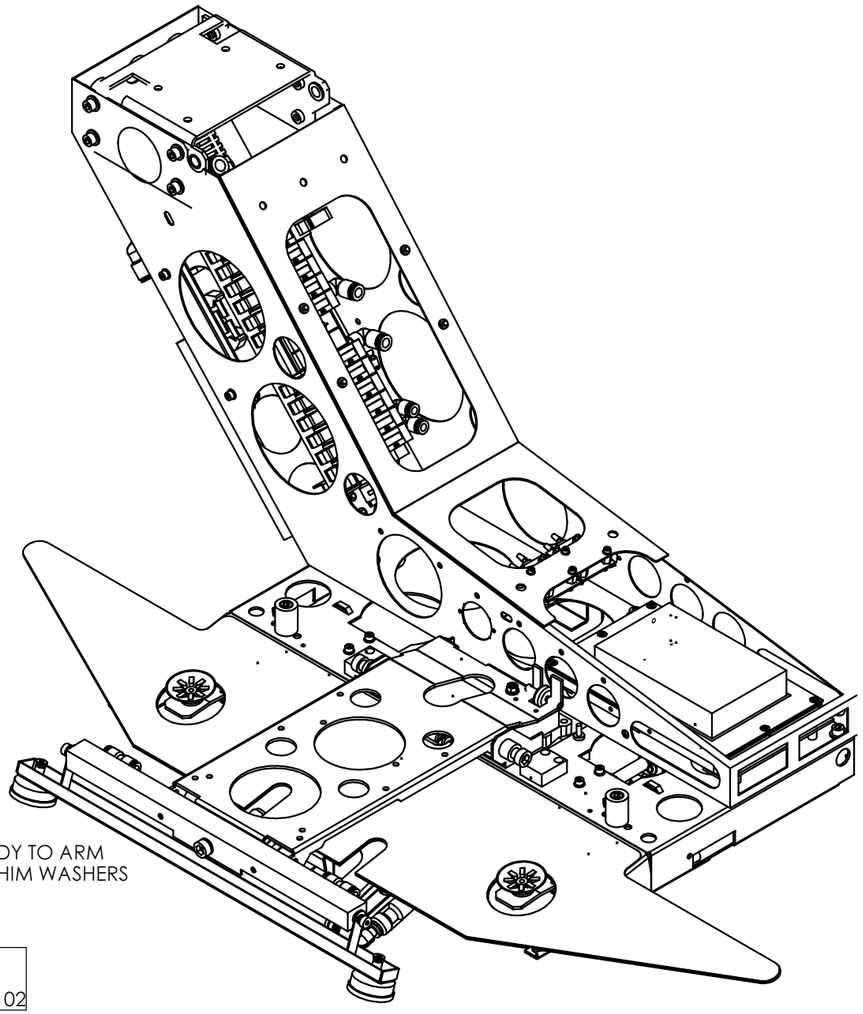
350 / 2 NOTE 01

360 / 2

36 Nm

IMPORTANT NOTE:

THIS DRAWING SHOWS A LEFT TO RIGHT PICKER. IF YOU NEED TO BUILD A RIGHT TO LEFT PICKER YOU WILL HAVE TO FLIP THE PICKER BODY 180 DEGREES.



UNEXPLODED VIEW OF PICKER AND ARM ASSY

NOTES:

1) THE ONLY CHANGES SINCE VERSION B ARE THE CHANGING OF THE WEDGEMASTER UP SENSOR ARRANGMENT AND THE WEDGEMASTER CYLINDER BLOCK (PAGE 3)

NOTES:

1. INSTALL BELVILLE WASHERS WITH BASES FACING INWARDS.

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY
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A	E256	JUN 21/2001	JON DAHLGREN	J DAHLGREN

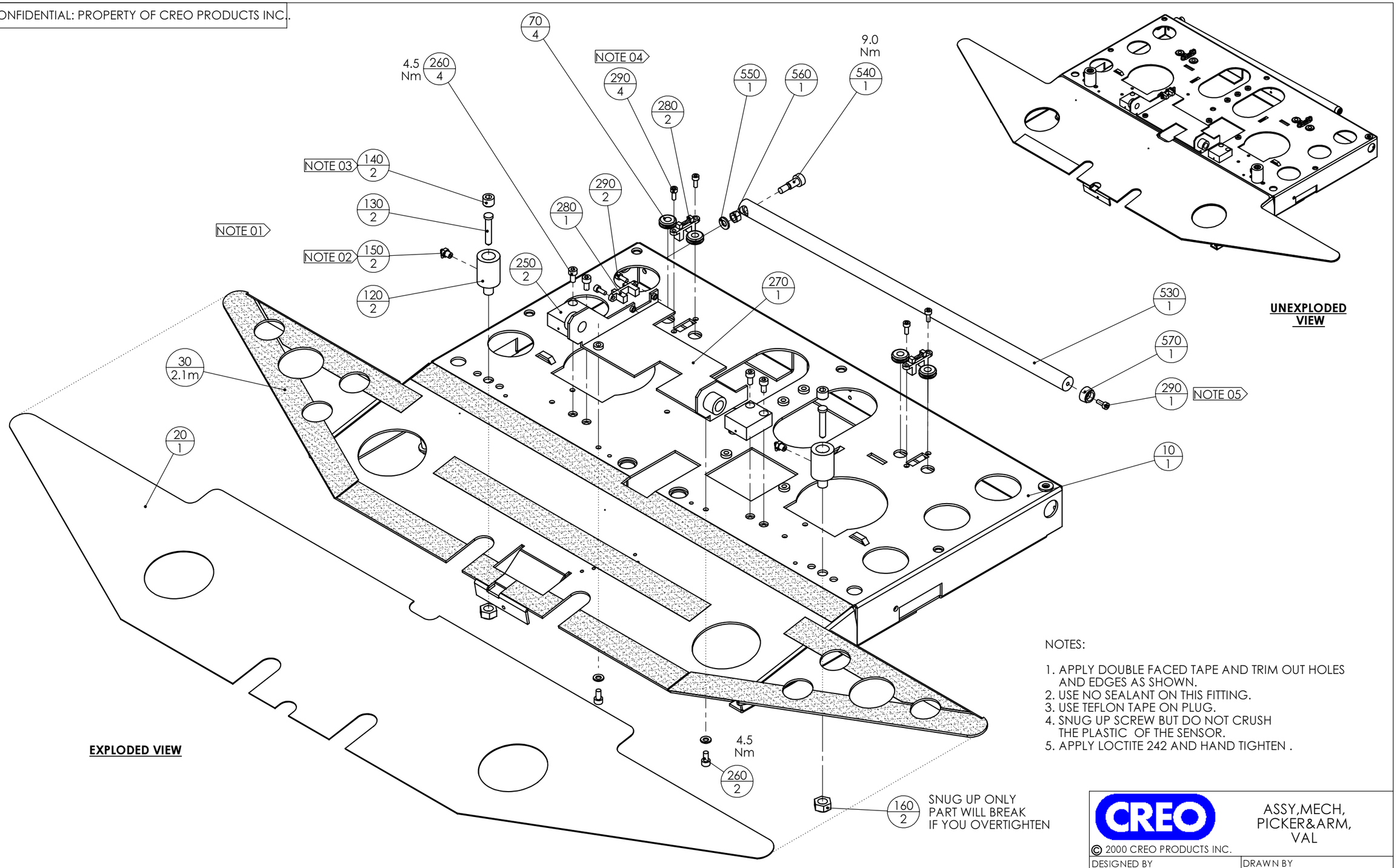
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ASSY,MECH, PICKER&ARM, VAL

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MILLIMETERS UNLESS SPECIFIED	DATE: 2001:JAN:31	SIZE B	SCALE 1:5	
PART NO. 50-1742C	REV A	DOC AD	SHEET 1	OF 6

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EXPLODED VIEW

UNEXPLODED VIEW

NOTES:

1. APPLY DOUBLE FACED TAPE AND TRIM OUT HOLES AND EDGES AS SHOWN.
2. USE NO SEALANT ON THIS FITTING.
3. USE TEFLON TAPE ON PLUG.
4. SNUG UP SCREW BUT DO NOT CRUSH THE PLASTIC OF THE SENSOR.
5. APPLY LOCTITE 242 AND HAND TIGHTEN .

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

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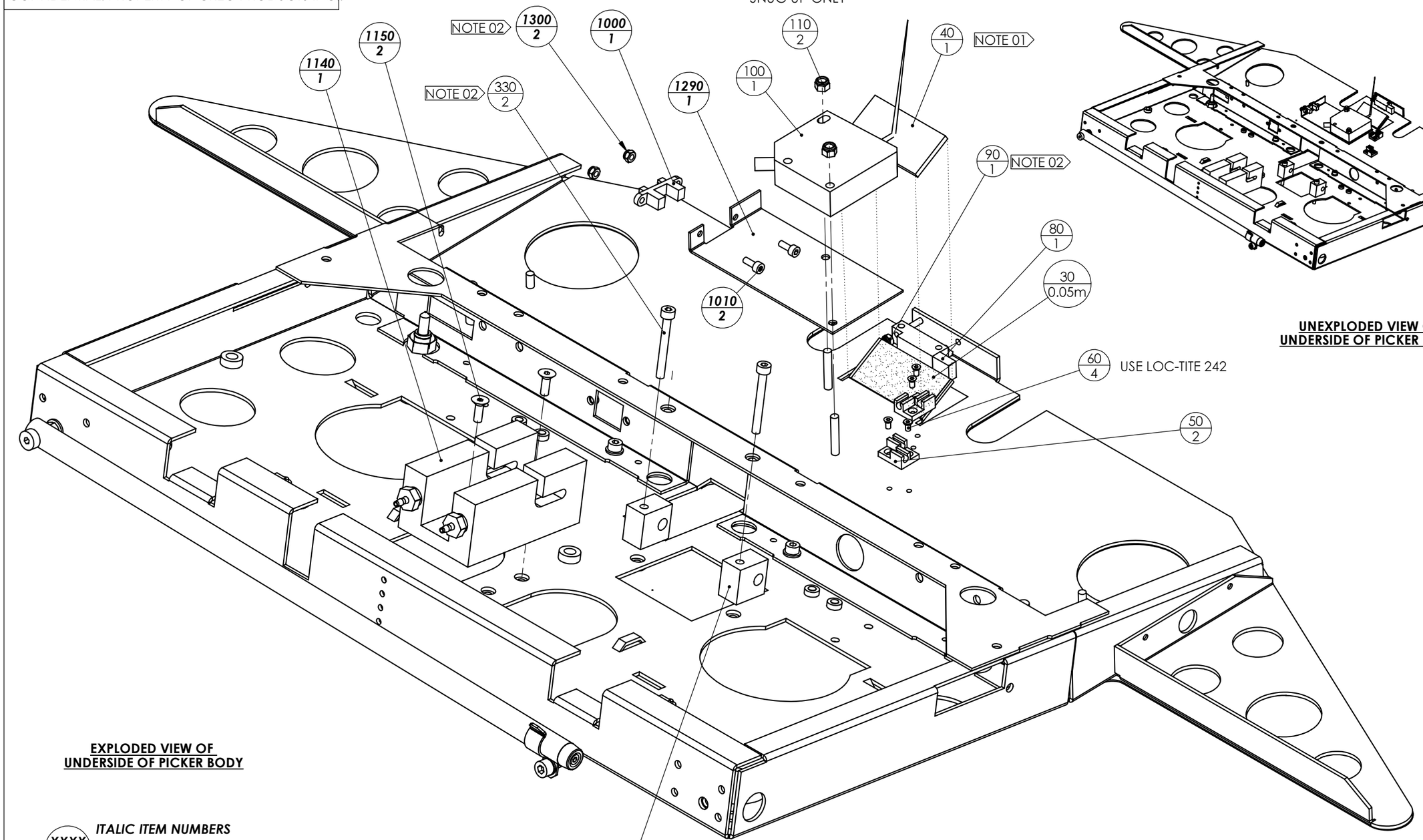
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SNUG UP ONLY



UNEXPLODED VIEW OF UNDERSIDE OF PICKER BODY

EXPLODED VIEW OF UNDERSIDE OF PICKER BODY

XXXX / *Y* — *ITALIC ITEM NUMBERS*

IF BUILDING A NON SLIP SHEET PICKER LEAVE ITALIC ITEMS OUT. THESE ARE ALL ITEM NUMBERS OVER 1000

NOTES:

1. AFFIX MIRROR TO BODY WITH DOUBLE FACED TAPE
2. TIGHTEN BUT DO NOT CRUSH PLASTIC.

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

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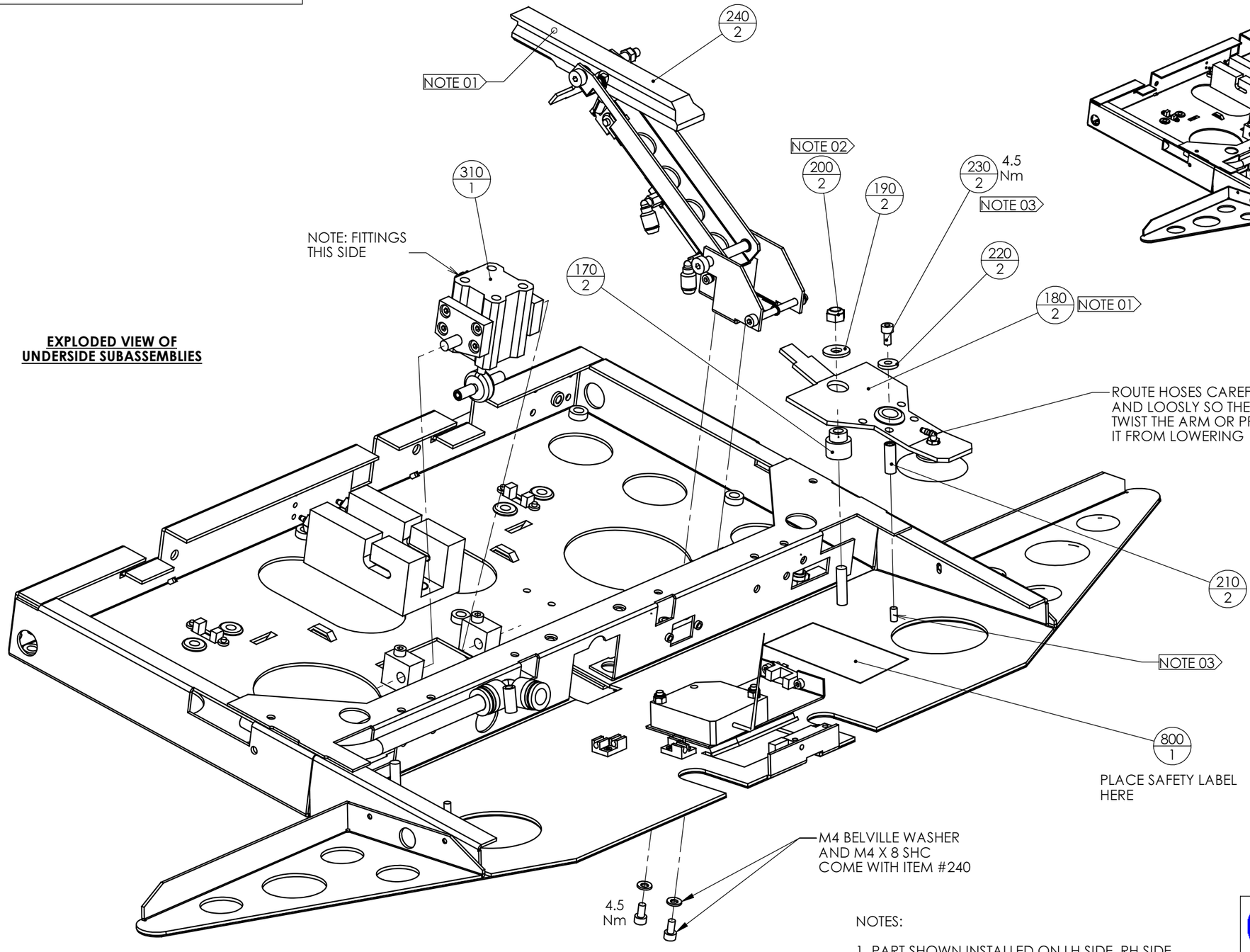
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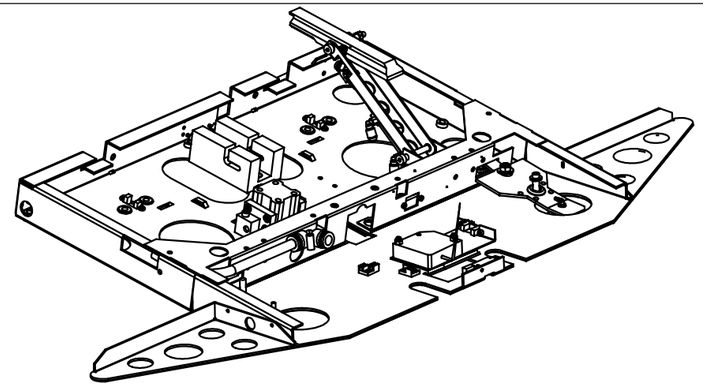
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EXPLODED VIEW OF UNDERSIDE SUBASSEMBLIES





UNEXPLODED VIEW OF UNDERSIDE SUBASSEMBLIES

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

NOTES:

1. PART SHOWN INSTALLED ON LH SIDE, RH SIDE OMMITTED FOR CLARITY. QTYS SHOWN ARE FOR INSTALLING BOTH ASSY'S.
2. TIGHTEN BUT DO NOT CRUSH PLASTIC.
3. APPLY LOCTITE 242 TO THREADS.

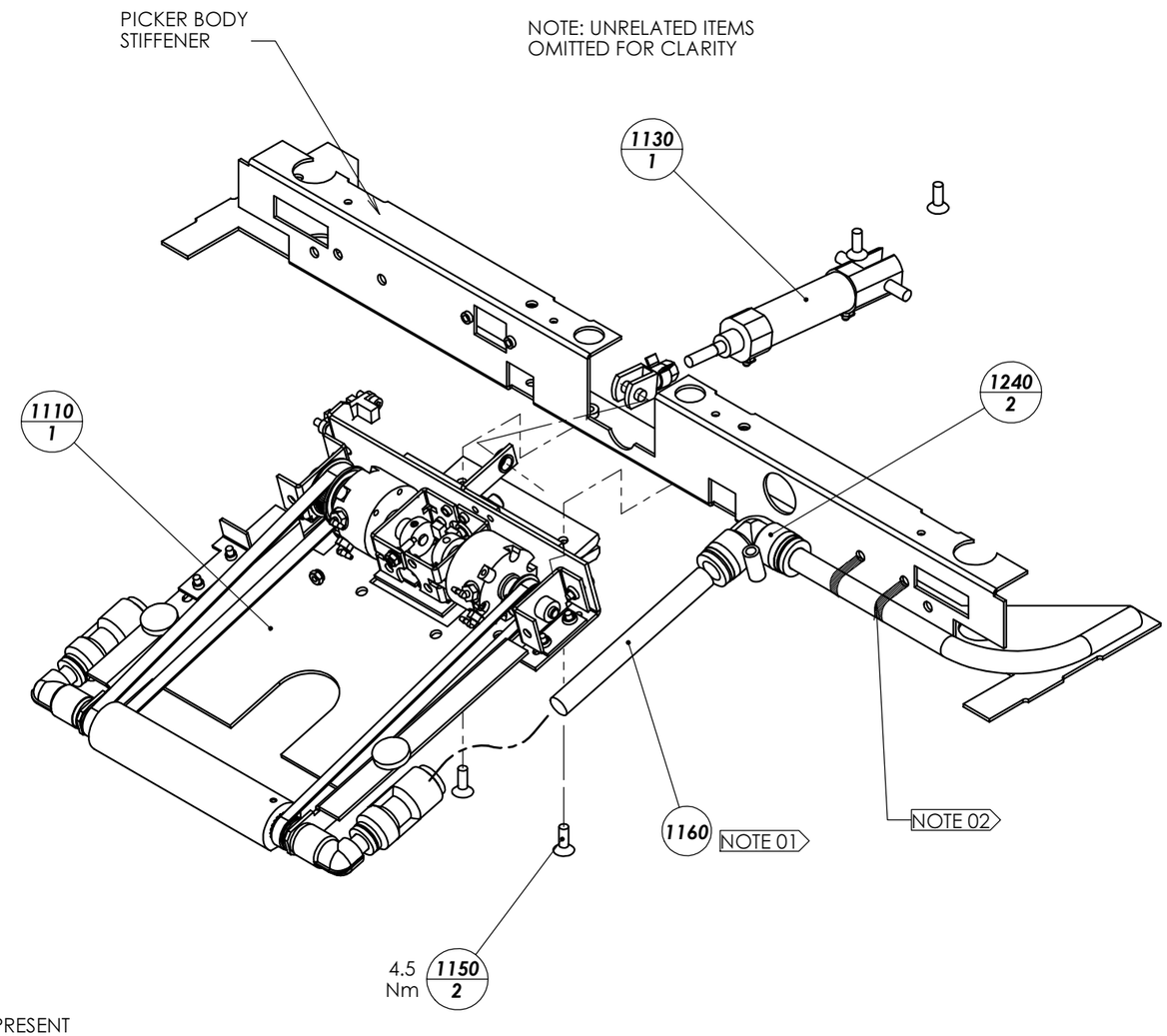
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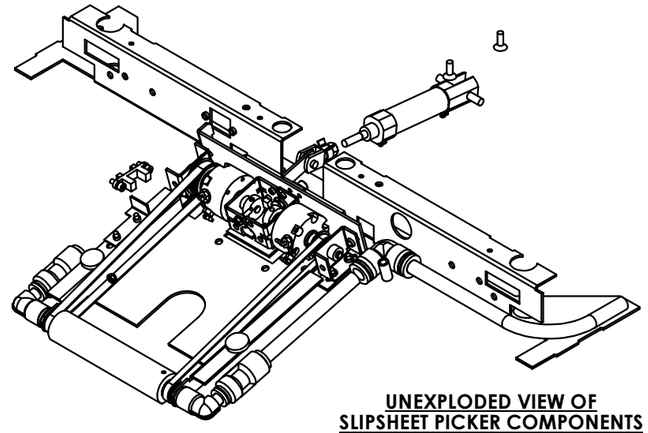
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EXPLODED ISO TOP VIEW OF SLIPSHEET PICKER COMPONENTS



UNEXPLODED VIEW OF SLIPSHEET PICKER COMPONENTS

NOTES:

1. TUBE IS REQ'D BOTH SIDES, OTHER SIDE NOT SHOWN.
2. SECURE TUBES TO STIFFENER WITH TIEWRAPS.

ITALIC ITEM NUMBERS
XXXX / ***Y***
REPRESENT COMPONENTS PRESENT ONLY WHEN SLIP SHEET REMOVAL OPTION IS INCLUDED.

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

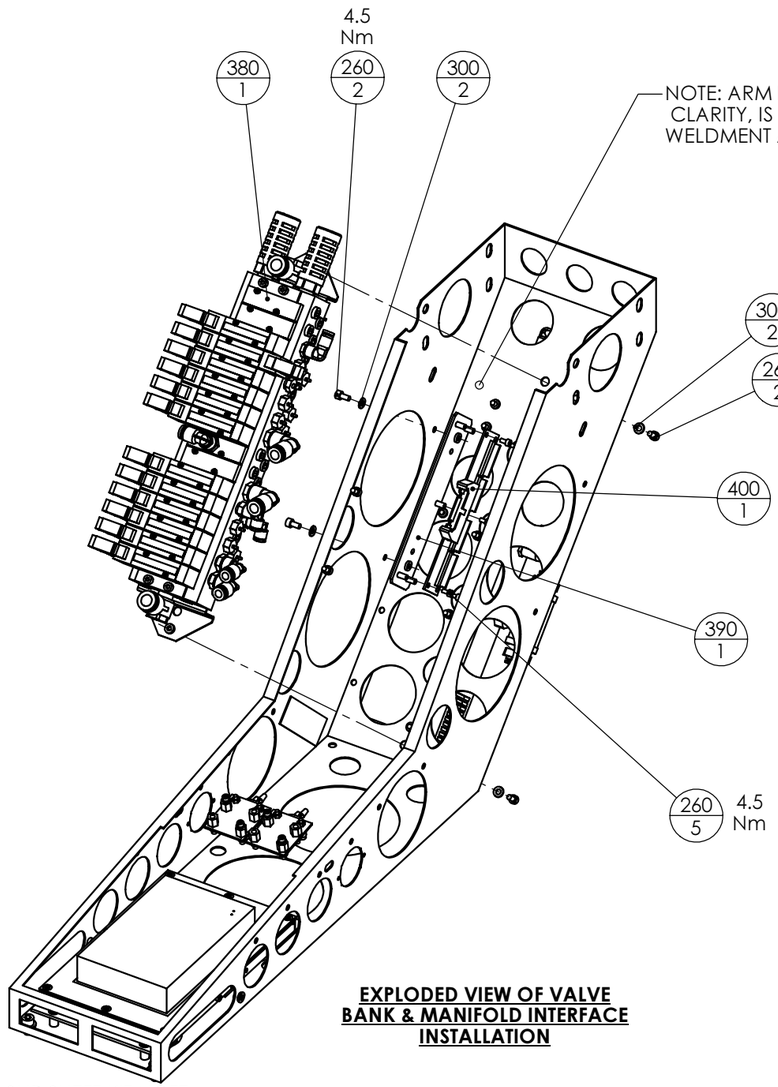
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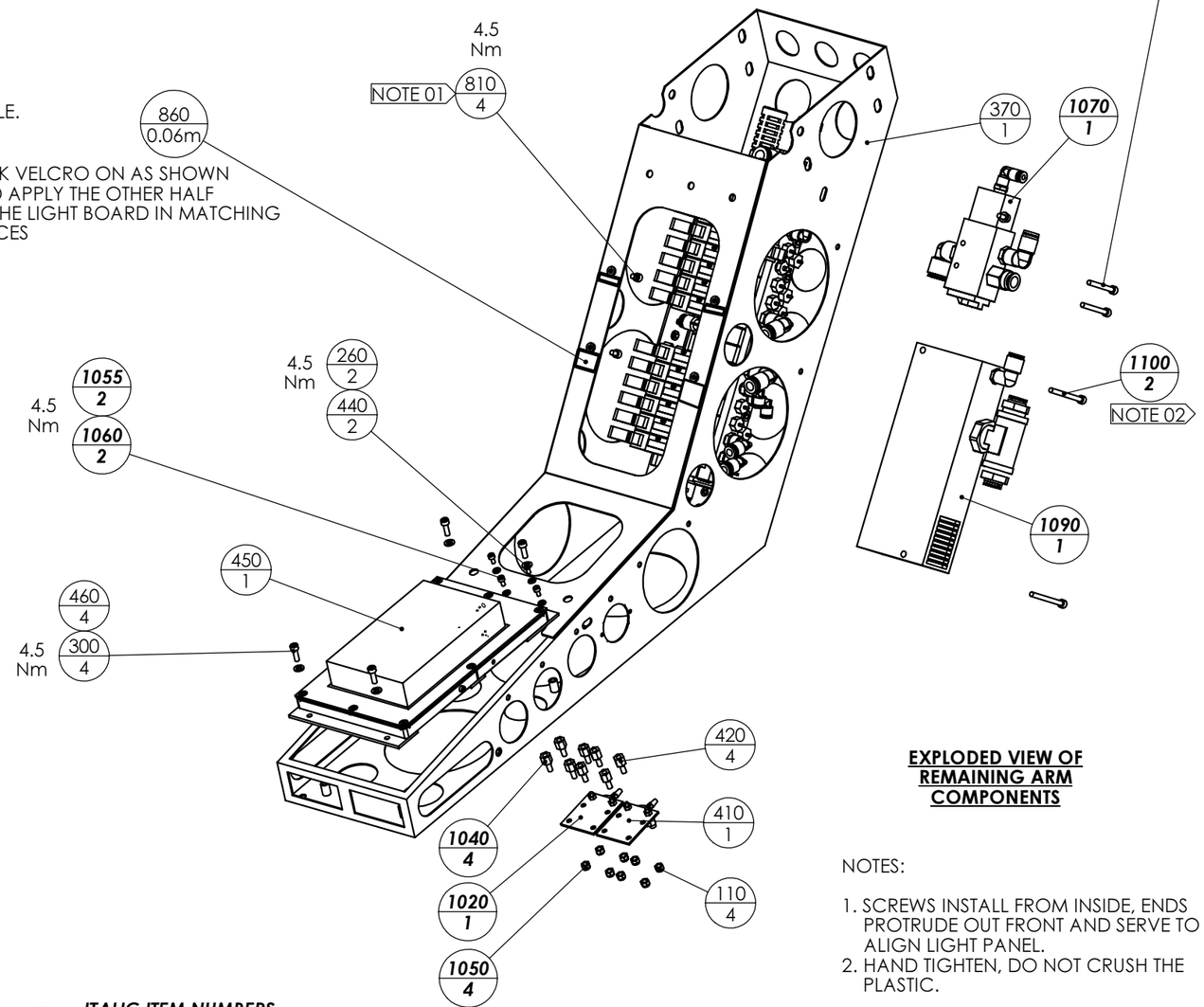
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EXPLODED VIEW OF VALVE BANK & MANIFOLD INTERFACE INSTALLATION



EXPLODED VIEW OF REMAINING ARM COMPONENTS

SLIP SHEET KIT NOTE:

1) IF THE SLIP SHEET OPTION IS NOT INCLUDED, REMOVE THE FITTINGS AND INSTALL PLUGS IN THE MANIFOLD IN THE FOLLOWING POSITIONS:

-SS ICUP UP/DOWN
-SS OCUP UP/DOWN
-SS WM UP/DOWN
-SS EJECTOR ON/OFF
-SS VAC ON/OFF

PLACE THE FITTINGS IN A BAG AND TAPE OR TIE WRAP INSIDE THE PICKER SO IT CAN BE UPGRADED IN THE FIELD

ITALIC ITEM NUMBERS
XXXX / ***Y***
REPRESENT COMPONENTS PRESENT ONLY WHEN SLIP SHEET REMOVAL OPTION IS INCLUDED.

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

NOTES:

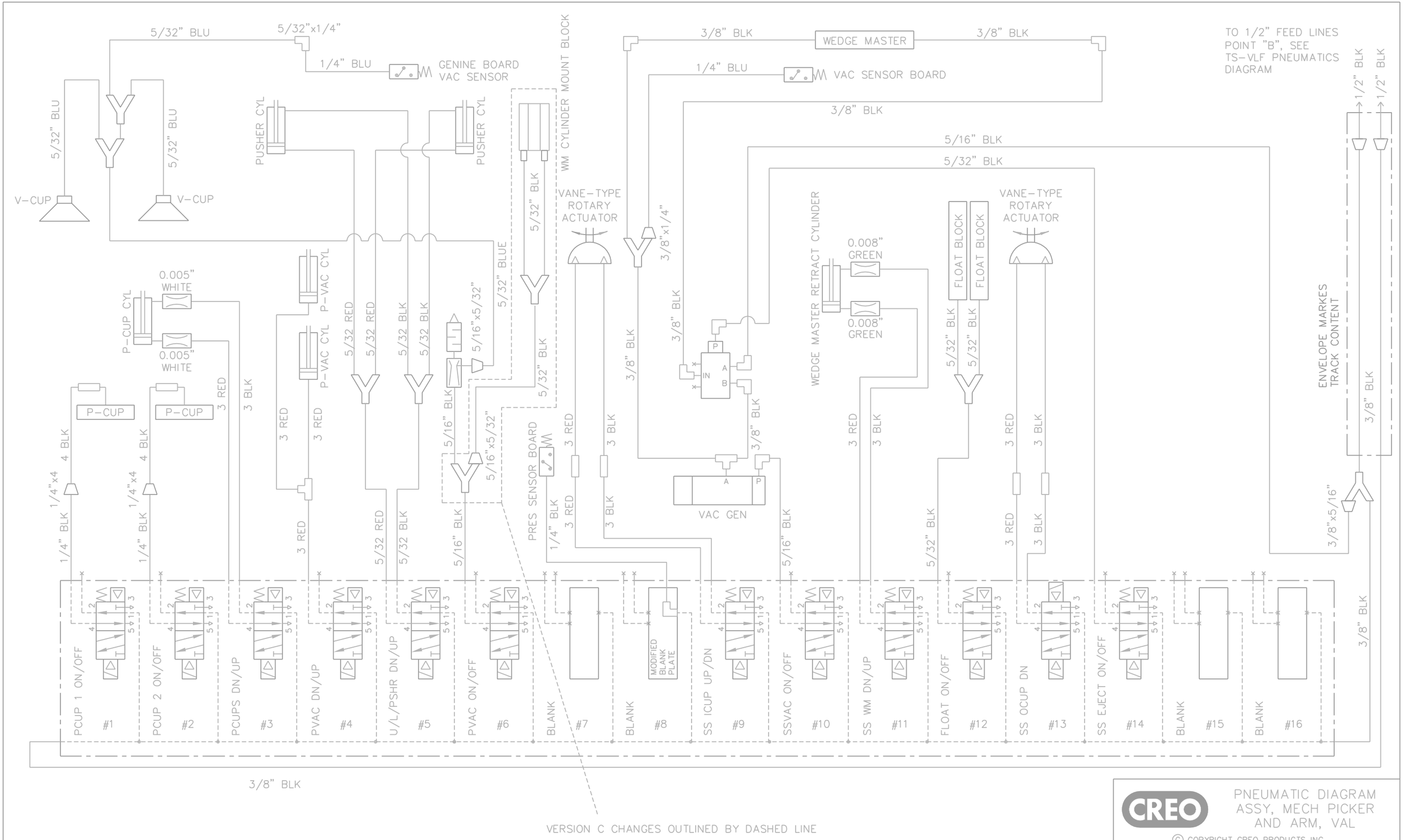
1. SCREWS INSTALL FROM INSIDE, ENDS PROTRUDE OUT FRONT AND SERVE TO ALIGN LIGHT PANEL.
2. HAND TIGHTEN, DO NOT CRUSH THE PLASTIC.

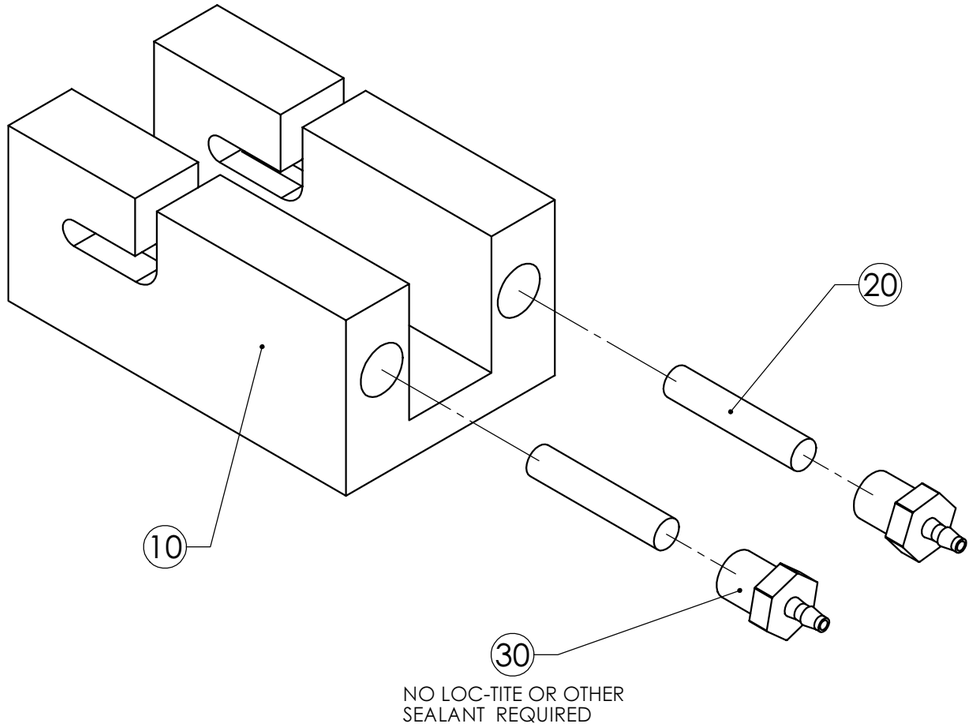
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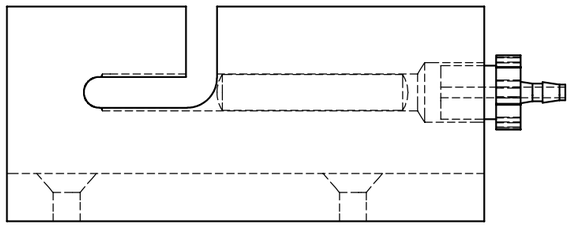
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5/32" BLU
5/32"x1/4"
1/4" BLU
GENINE BOARD VAC SENSOR
5/32" BLU
5/32" BLU
V-CUP
V-CUP
PUSHER CYL
PUSHER CYL
WM CYLINDER MOUNT BLOCK
5/32" BLK
VANE-TYPE ROTARY ACTUATOR
3/8" BLK
WEDGE MASTER
3/8" BLK
1/4" BLU
VAC SENSOR BOARD
3/8" BLK
TO 1/2" FEED LINES POINT "B", SEE TS-VLF PNEUMATICS DIAGRAM
5/16" BLK
5/32" BLK
3/8"x1/4"
3/8" BLK
WEDGE MASTER RETRACT CYLINDER
0.008" GREEN
0.008" GREEN
FLOAT BLOCK
FLOAT BLOCK
VANE-TYPE ROTARY ACTUATOR
5/32" BLK
5/32" BLK
0.005" WHITE
0.005" WHITE
P-CUP CYL
P-VAC CYL
P-VAC CYL
5/32 RED
5/32 RED
5/32 BLK
5/32 BLK
5/16"x5/32"
5/32" BLUE
5/32" BLK
5/32" BLK
P
IN
A
B
3/8" BLK
3 RED
3 BLK
3 RED
3 BLK
3 RED
3 BLK
3 RED
3 BLK
ENVELOPE MARKES TRACK CONTENT
1/2" BLK
1/2" BLK
3/8" BLK
3/8"x5/16"
P-CUP
P-CUP
3 RED
3 BLK
4 BLK
4 BLK
1/4"x4
1/4"x4
1/4" BLK
1/4" BLK
5/16"x5/32"
5/16" BLK
PRES SENSOR BOARD WM
1/4" BLK
3 RED
3 BLK
A
B
VAC GEN
5/16" BLK
5/32" BLK
3 RED
3 BLK
3 RED
3 BLK
3 RED
3 BLK
3 RED
3



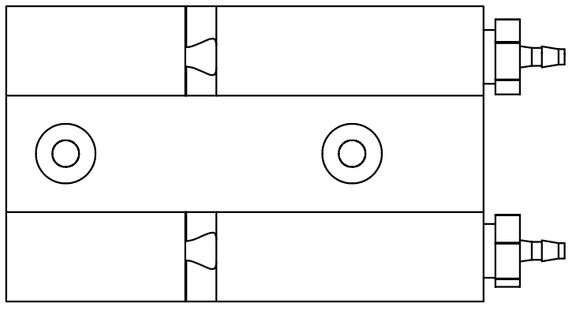
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SEALANT REQUIRED

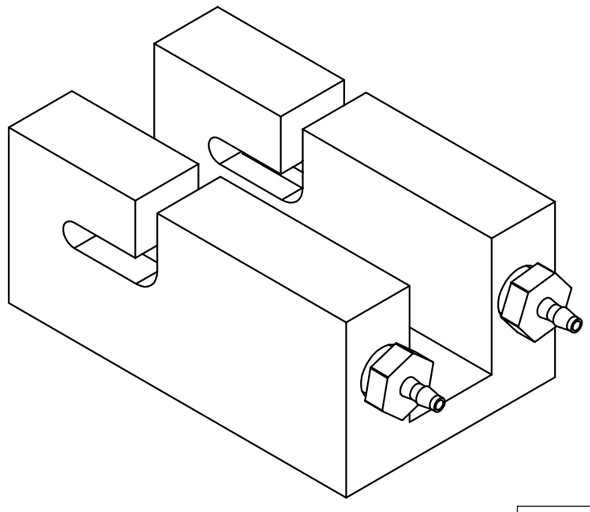


NOTES:

1) **IMPORTANT** THE DOWEL PINS MUST SLIDE FREELY INSIDE THE HOLES. CHECK BY TIPPING THE COMPLETED ASSEMBLY BACK AND FORTH IN YOUR HAND. THE PINS SHOULD SLIDE UNDER THEIR OWN WEIGHT.

   IF THEY ARE TIGHT, THE HOLES SHOULD BE CHECKED FOR DEBRIS OR BURRS AND IF NECESSARY CLEANED OUT WITH A LETTER 'C' DRILL BIT.





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A	E256	JUN 21/2001	JON DAHLGREN	JON DAHLGREN
-	-	-	-	-

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CYLINDER MOUNT BLOCK
SS PICKER
VAL

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PART NO.	REV	DOC	SHEET	OF
50-2390A	A	AD	1	1