

Fermi National Accelerator Laboratory

FERMILAB-TM-1859

BT14 Reference Guide

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BT14 REFERENCE GUIDE

POWER-UP

1. Remove the foam that protects the Load Arm, taking care not to damage the Hook.
2. Raise the Joystick to its upper most position.
3. Turn on the Printer (optional).
4. Press the Power Switch on (LED is on).
5. Turn on the area Lamp.
6. The machine will perform a *selftest*, then default into Automatic mode with the last configuration program reinstated.
7. Engage the Hook by moving the Joystick throughout its travel limits until the Load Arm is captured by the Joystick. Return the Joystick to its upper most position.
8. Carefully place a device onto the workholder.
9. Position the workholder under the Load Arm taking care not to damage the Hook.

NON-DESTRUCT (NDT), STEP BACK AND AUTO HOOK (AC) TEST MODE

1. Press the Non-Destruct (NDT), Auto Hook and Step Back keys (LED's are on).
2. Using the Joystick, lower the Hook to a point just above the Lower Limit.
3. Press the Lower Limit key. Use the Joystick to set a new floor for hook movement and a base for Step Back.
4. Press the Enter key. ***to keep the current limit, press the Lower Limit key instead of Enter. The current limit is reinstated.
5. Raise the Joystick to a point just below the Upper Limit.
6. Press the Upper Limit key. The upper limit ceiling should be just above the wire.
7. Press the Enter key. ***to keep the current limit, press the Upper Limit key instead of Enter. The current limit is reinstated.
8. Position the Hook above and adjacent to the wire to be tested.
9. Slowly, lower the Joystick to confirm that when the test is performed, the adjacent wire will not be damaged by the Hook. Adjust the workholder if necessary and return the Joystick to just above the Upper Limit.
10. Start the test by pressing the Test Foot Switch.
11. Press the Test Foot Switch again to cycle the machine so another wire can be tested. If the Printer is on press a number value corresponding to the proper Grade, then the # symbol on the Key Pad to record the data.
12. Repeat steps 8-11 until all wires are aligned.

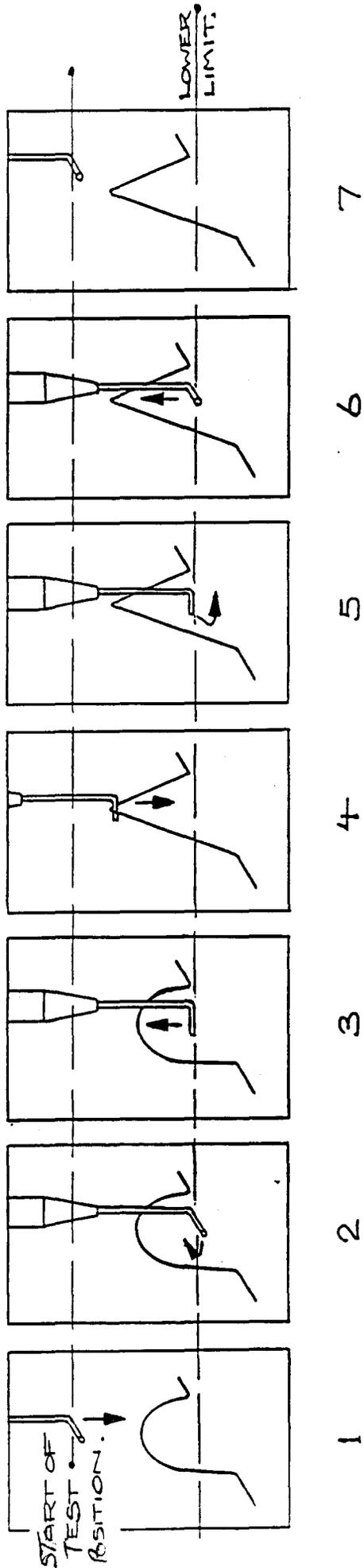
POWER-DOWN

1. Remove the workholder from under the Hook.
2. Return the foam that protects the Load arm and Hook.
3. Turn off the area Lamp.
4. Press the Power Switch off.
5. Place the workholder behind the Load Arm protector.

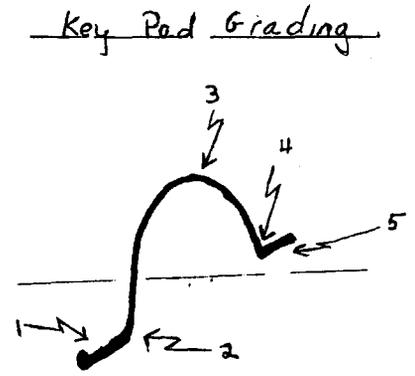
Albert Dyer TM1859

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BT14 NDT AUTO HOOK SEQUENCE.



ARROWS SHOW DIRECTION OF NEXT HOOK MOTION.



Grade

- 1 = 1st Bond Lift
- 2 = 1st Bond Break
- 3 = Loop Break
- 4 = 2nd Bond Break
- 5 = 2nd Bond Lift