



Technical Support Bulletin

Servicing the LINAC Support Assembly Roll Pin in the M60, M45
and T60 systems

TB No.

1149

Originator: Robert Bentley	Date: 1/31/2014	Phone/Email: +44 1293 778164 Ext 8674 RBentley@RapiscanSystems.com	Rev: 3
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Classification:	<input checked="" type="checkbox"/> Major	<input type="checkbox"/> Minor	Effective Date: On release
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Distribution: Engineering Service Contractors Factory Other

Items Affected (Part Number/Description):
LINAC Support Assembly for the following systems:

- Rapiscan Eagle® M45
- Rapiscan Eagle® M60
- Rapiscan Eagle® T60

Systems Affected: Check all that apply and append list if applicable

500 Series 600 Series Secure 1000 METOR 200 Other (Describe) M60, M45 and T60 Cargo and Trailer Systems

Reason for Proposed Change or Description of Problem:

- The collars at the base of the LINAC table adjusters in the affected systems have a 6mm roll inserted pin which needs to be replaced.

Change History (UK)		
Details of Change	Date	Issue Status
Issued for Service	31/01/2014	Version 1
Minor grammatical changes	01/02/2014	Version 2
Added UK to US conversions and added signature box.	01/02/2014	Version 3

Outline Of Proposed Change (Include Part Number/ Drawing Number and Issue if possible):

- Advise Service personnel of tools, part and other requirements to carry out pin replacement

Tools Required	Part Required
<ol style="list-style-type: none"> 36mm spanner (36mm opened end wrench) 6mm parallel pin punch Hammer Torque wrench (Click type Torque wrench capable of 100Nm (75ft·lb)) 36mm open end spanner fitting (36mm Opened end crows foot adapter) Permanent Marker Pen 	6mm roll pin

Number of staff: 1	Time Allocated: 30 minutes
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Reference Document: None	
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Procedure to Implement Change:

LINAC Support Assembly Roll Pin Replacement

- I. The diagram below shows the LINAC table adjuster. The collar at the base of the adjuster has a 6mm roll pin inserted which needs to be replaced.

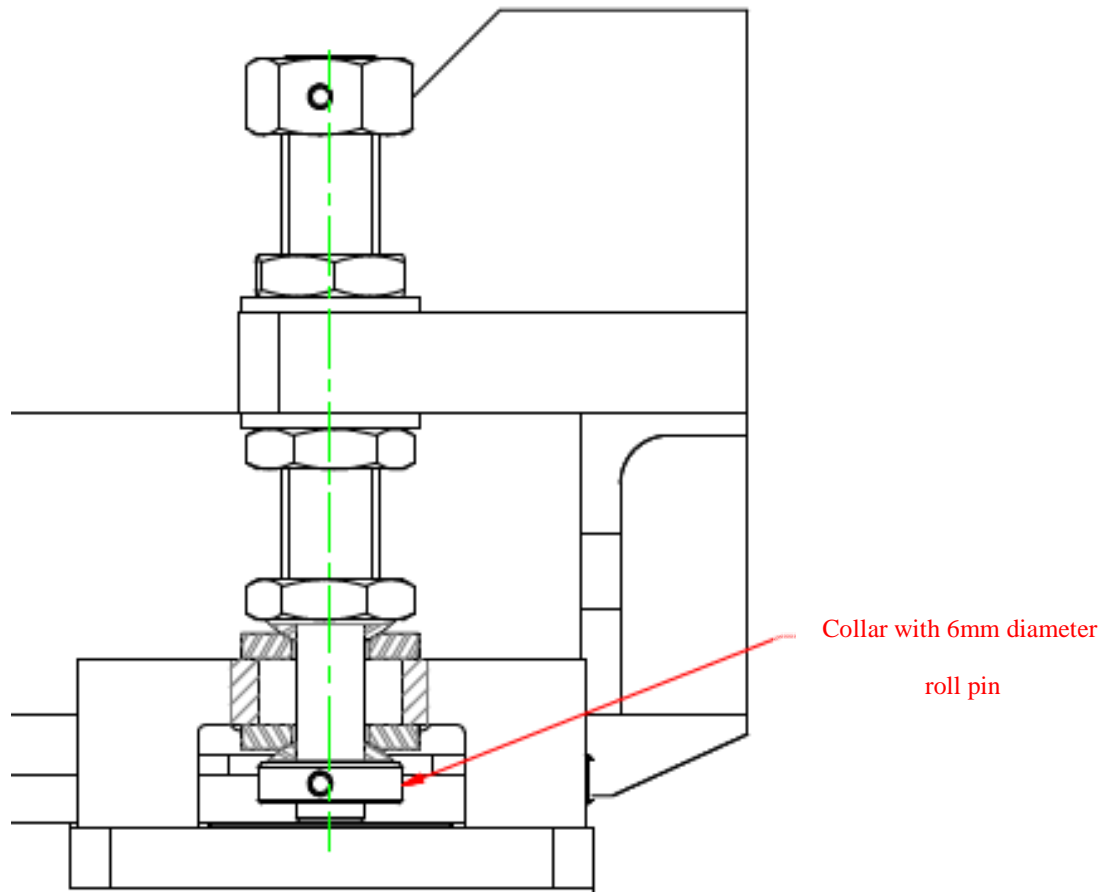


Figure 1

2. Using a 36mm spanner, loosen off the top lock nut by turning it counter-clockwise (see figure 2).

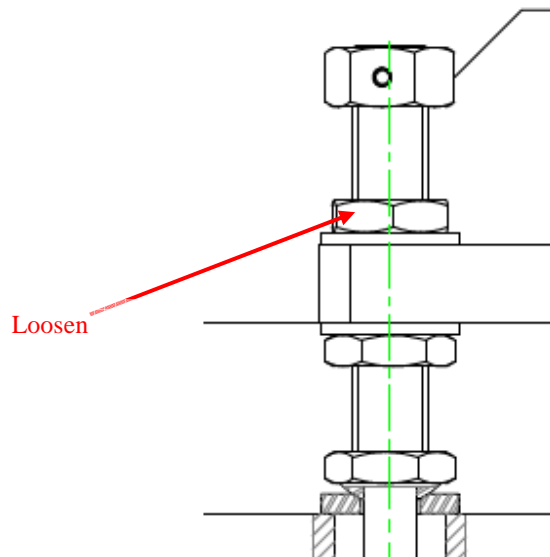


Figure 2

3. Screw the lock nut out of the way, lift the flat washer and, using a marker pen, mark the position of the adjustment screw (see figures 3 and 4).

Note: This is to ensure that the LINAC table can be set back to its original position.

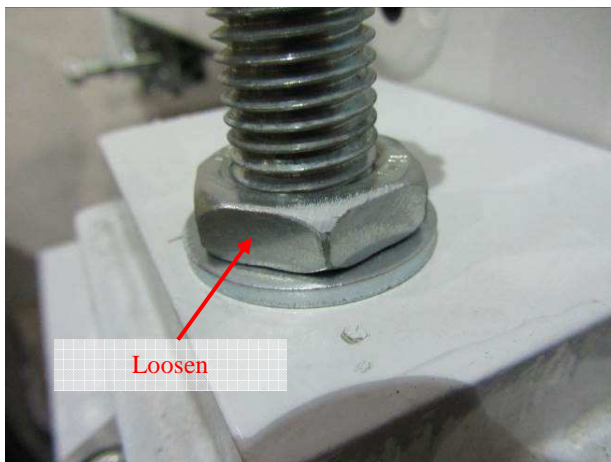


Figure 3

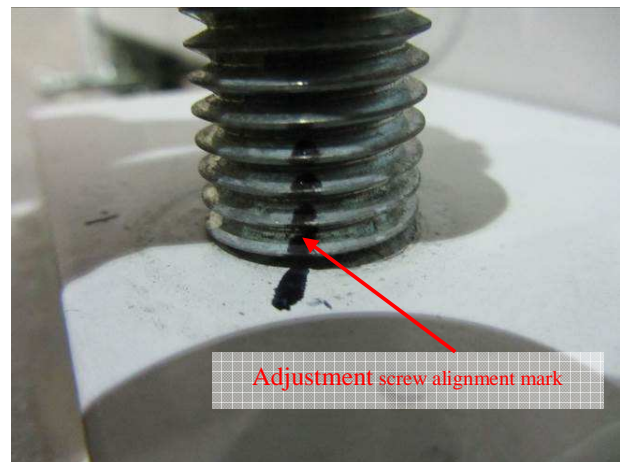


Figure 4

4. Using a 36mm spanner, loosen off the lower lock nut by turning it counter-clockwise. Using the same 36mm spanner, turn the top nut to enable you to view the roll pin at the base, as in figure 6.

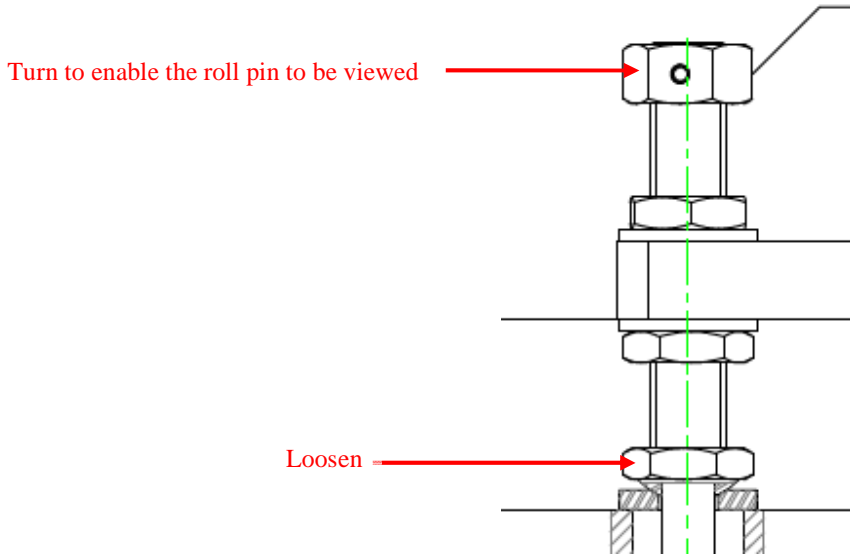


Figure 5

5. Using a 6mm parallel pin punch and a hammer, knock the roll pin approximately 50% of the way out (see figures 6 and 7).

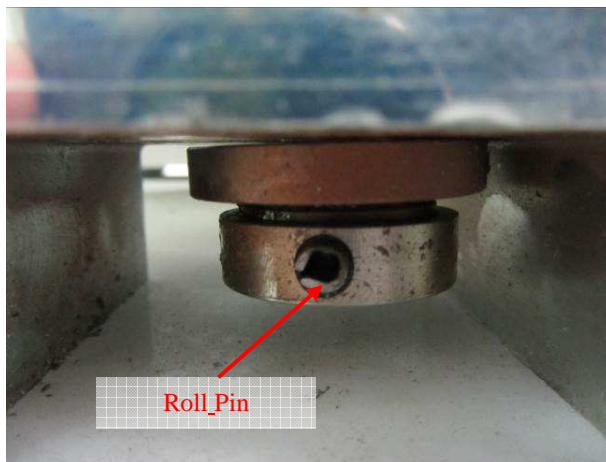


Figure 6

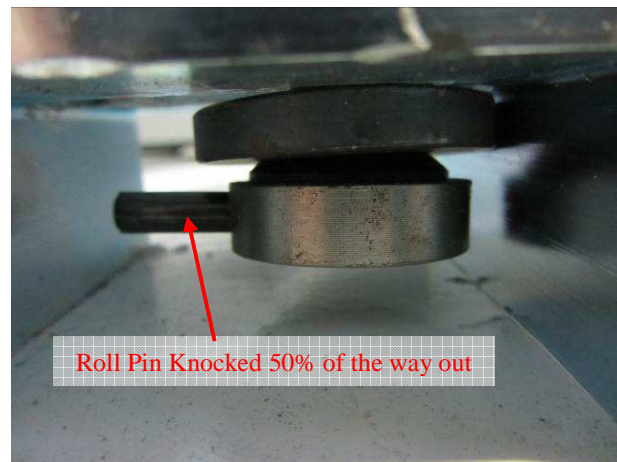


Figure 7

- Partially insert the replacement roll pin and knock into position using the hammer and parallel pin punch, pushing the existing pin out with the introduction of the new pin. The finished item should reflect figure 8.

Note: This is to ensure that the LINAC table adjuster and the collar do not misalign.

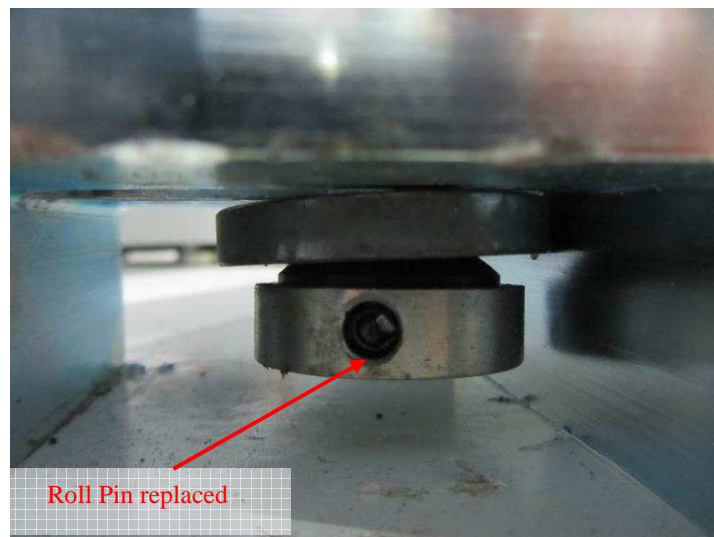


Figure 8

- Once the roll pin has been replaced, realign the marks made at step 3 by turning the nut at the top of the adjustment screw (see figure 9).



Figure 9

8. Secure the lower lock nut into position using a 36mm open ended spanner and torque wrench.

Note: Ensure that the torque wrench has an up to date calibration certificate.

9. Set the torque wrench to 95Nm (70.1 ft lb)and, once this setting is confirmed, turn the lock nut in a clockwise direction until the torque wrench 'cracks off' (clicks), identifying that the torque figure has been achieved see figure 10.

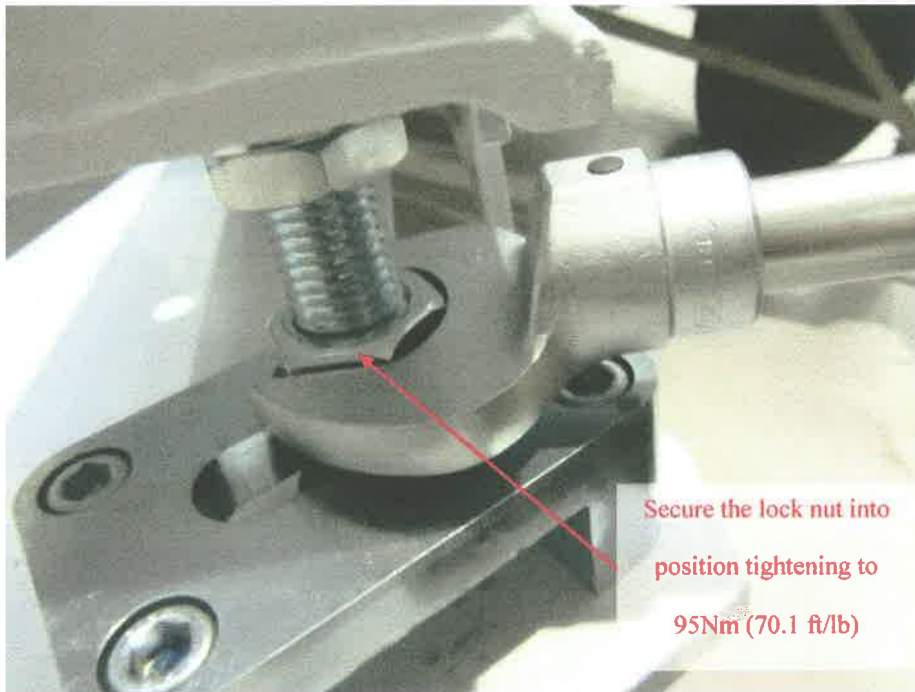


Figure 10

10. Once the bottom lock nut is secured, tighten the other two lock nuts to 95Nm (70.1 ft lb) ensuring that the mark on the adjustment pin remains aligned.

<p>UK checked by:</p> <p style="text-align: center;">S. Tiplady</p>	<p>UK approved by :</p> <p style="text-align: center;">Steve Thompson</p>	<p>UK Date:</p> <p style="text-align: center;">31/01/2014</p>
<p>US approved by:</p> <p style="text-align: center;"><i>Miguel Fuente</i></p> <p>Miguel Fuente, Technical Specialist Team Manager</p>	<p>US Date:</p> <p style="text-align: center;"><i>2/3/2014</i></p>	<p>Add Pages</p>