

MAINTENANCE TECHNICAL SUPPORT CENTER
HEADQUARTERS MAINTENANCE OPERATIONS
UNITED STATES POSTAL SERVICE



Maintenance Management Order

SUBJECT: Preventive, Predictive, and Operational
Maintenance Guidelines for Advanced Facer
Canceller System (AFCS200) using eCBM

DATE: January 12, 2016

NO: MMO-149-15

TO: All AFCS 200 Sites

FILE CODE: 2AD

dgar:mm14072ag

Online Change Record		
Change #	Date	Description of Change
7	07/22/2020	Added a PSN and corrected the PSIN in Attachment 3, Task 10, Step1 b.
6	10/17/2019	The attached MMO-149-15 contains online changes for: Task 22 - step 1 - delete "the" from sentence Task 72 – edited step 2 and 3 Task 75.5 – Removed SW versions and all reference to earlier software versions for the ACC/ACR 2.21 and ACP 0.5.2
5	2/8/2017	Attachment 1, Update Summary Work Load Estimates based on Change #2 updates.
4	7/7/2016	Attachment 2, Items 21 and 22 have been changed to update shoe alignment.
3	6/6/2016	Attachment 2, Item 75.5 added to verify cancellation and franking marks.
2	3/30/2016	Attachment 2, Items 41, 42, 46, and 47, updated the threshold values.
1	3/17/2016	Attachment 2, Item 12, updated Stock Numbers (PSNs).

This Maintenance Management Order (MMO) provides Preventive, Predictive, and Operational Maintenance Guidelines for the Advanced Facer Cancellation System 200. The acronym is AFCS200 and the class code is AA. **This Maintenance Management Order (MMO) supersedes MMO-020-13.** Steps have been added to address at risk pieces.

The workhours indicated in the workload estimate reflect the *maximum* annual workhours required to maintain each system. Actual workhour requirements and the frequency of tasks are dependent on run time and pieces processed. Therefore, PM workhour requirements will vary day-to-day based on site-specific machine utilization. Management may modify task frequencies to address local conditions.

The minimum maintenance skill level required to perform each task is included in the Minimum Skill Level column of each checklist. This does not preclude higher level employees from performing any of this work.

Preventive Maintenance (PM) guidelines provide maintenance employees with the recommended task based maintenance activities. The Electronic Conditioned Based Maintenance (eCBM) is an abbreviated task list that represents a portion of the PM checklist. The complete master PM checklist must be accessible to all maintenance employees when performing PM and eCBM task based maintenance activities.

WARNING

Various products requiring Safety Data Sheets (SDS) may be utilized during the performance of the procedures in this bulletin. Ensure the current SDS for each product used is on file and available to all employees. When reordering such a product, it is suggested that current SDS be requested. Refer to SDS for appropriate personal protective equipment.

WARNING

The use of compressed or blown air is prohibited. An alternative cleaning method such as a HEPA filtered vacuum cleaner, a damp rag, lint-free cloth, or brush must be used in place of compressed or blown air.

WARNING

Steps contained in this bulletin may require the use of Electrical Work Plan (EWP) Personal Protective Equipment (PPE). Refer to the current EWP MMO for appropriate EWP PPE and barricade requirements.

For questions or comments concerning this bulletin contact the MTSC HelpDesk, either online at **MTSC>HELPDESK>Create/Update Tickets** or call (800) 366-4123.



Kevin Couch
Manager
Maintenance Technical Support Center
HQ Maintenance Operations

Attachments

1. Summary of Workload Estimate
2. Master Checklist 03-AFCS200-AA-001-M – Power Off Power On PM
3. Master Checklist 09-AFCS200-AA-001-M – Operational Maintenance

ATTACHMENT 1

SUMMARY

WORKLOAD ESTIMATE

FOR AFCS 200 SYSTEM

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SUMMARY WORK LOAD ESTIMATES FOR AFCS200 AA

Attachment 1

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ATTACHMENT 2

AFCS200 MASTER CHECKLIST

POWER OFF POWER ON

03-AFCS200-AA-001-M

Time Total: See Attachment 1

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

SAFETY STATEMENT	1	<p>COMPLY WITH ALL SAFETY PRECAUTIONS. Disconnect power and apply lockouts when required by this instruction. Refer to current local lockout procedures to properly shut down and lock out this machine. Open equipment and inspect dust conditions. Check for suspicious dust or unusual debris. If any unusual substance is found, notify supervisor prior to proceeding with any further action on the equipment.</p> <p>THE USE OF COMPRESSED OR BLOWN AIR IS PROHIBITED. When cleaning is required, an alternative cleaning method such as a HEPA filtered vacuum cleaner or a damp rag must be used in place of compressed or blown air. A lint-free cloth or brush may be used on optical equipment only when other cleaning methods cannot be used. Report safety deficiencies to your supervisor immediately upon detection.</p> <p>WARNING FOR EWP/PPE: Steps contained in this bulletin may require the use of Electrical Work Plan (EWP) Personal Protective Equipment (PPE). Refer to the current EWP MMO for appropriate EWP PPE and barricade requirements.</p> <p>NOTE: Operational checks must be made with machine processing mail in a normal operating mode.</p>	1	All			
	2**	<p>Analyze the Run Statistics, Electronic or Hardcopy Log.</p> <p>NOTE</p> <p>Prior to performing the power down and lock out do an AFCS200 performance analysis.</p> <p>NOTE</p> <p>Reference At-Risk bulletin MMO-115-13 for possible causes and solutions.</p>	5	10		30	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM				

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		<p align="center">NOTE</p> <p>Reference Table 4. Baseline At-Risk Targets in the MMO for goal % based on National rollup data.</p> <p align="center">NOTE</p> <p>Reference current At-Risk bulletin and MTSC web dashboard for comparative scores.</p> <ol style="list-style-type: none"> Access run statistics from the previous runs on the GUI Report Display. Reference MIRS and/or MPE Watch to analyze the data for any anomalies that may indicate degradation of machine performance. Be alert for abnormal data concerning: <ol style="list-style-type: none"> Pieces Fed (acceptable/target throughput per hour is 28,300 pieces) Pieces Sorted Bin 12 (Reject) <ul style="list-style-type: none"> Mechanical Rejects No Indicia / Errors Dual Verifier Errors Unfaced/Misfaced Phantoms Malfunctions Doubles Fine Cull 1 <ol style="list-style-type: none"> Gap Metal Profile Underheight Underlength Fine Cull 2 <ol style="list-style-type: none"> Overlengths 					
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		b. Underlength c. Overheight d. Underheight e. Gap Skew f. Stiffness g. FC2 Doubles different than Bin 12 5. Bin 6 (timeout) a. Handwritten b. Window Envelop Content Shift c. Foreign mail d. Debris blocking camera, dirty camera, white calibration tab dirty or missing, calibration card dirty or of poor quality. 6. Jams a. Modules -ACR, Bypass, Cancel, Fine Cull 2, Manual Feeder, Printer, SBU 1, SBU 2, Stacker, Crossover, Singulator 7. Machine Stops and Faults 8. SBU 1 and 2 Rejects 9. Check the Electronic and/or Hardcopy Log for any unresolved issues. 10. Inform supervisor if numbers are out of defined range.					
AFCS-200 SYSTEM: ORDERLY SHUTDOWN	3**	Perform an Orderly Shutdown of the AFCS200. The following describes the orderly shutdown procedure for the AFCS 200: 1. Verify current mail processing run finishes. 2. Press TRANSPORT STOP button on OCP. 3. Remove all remaining mailpieces from machine transport. 4. Select Summary tab on GUI. 5. Select End Run button. 6. Select Logout in system information bar.	10	09		30	

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		<p>7. Select Maintenance from Name drop-down menu on Login Dialog box.</p> <p>8. Enter maintenance password in Password input field, and then select OK.</p> <p>9. Expand Maintenance menu in navigation window, if applicable.</p> <p>10. Select Shutdown / Restart.</p> <p style="text-align: center;">NOTE</p> <p>RMU located in Leveler, ACR, and Stacker Module is referred to as LLC in software.</p> <p>11. Select check box next to each computer system (ACC, ACP, ACR, and LLC).</p> <p>12. Select Shutdown Selected System(s) button.</p> <p style="text-align: center;">NOTE</p> <p>Once all three computers have shut down proceed to next step.</p> <p>Shutdown of IJPs must be orderly. Perform normal, orderly shutdown of IJPs before removing power from the AFCS 200. Failure to comply may cause IJP damage. It is crucial that the IJPs not have the Power switches turned off or power removed while the printhead is still active. Always shut down the printhead (by either selecting the Clean Head Screen or the <Start/Stop> key) and allow the printer to complete its shutdown sequence. Failure to do this could cause ink in the ink return line not to be drawn back into the printer. This would result in dried ink forming in the ink return line and on the ink return block, thus causing problems at the next printhead start-up.</p> <p style="text-align: center;">NOTE</p> <p>Shut down the printers and then power off the switch. Both IJPs can be shut down simultaneously. The IJP shutdown cycle takes approximately 4 minutes to complete.</p> <p>13. Perform IJP shutdown procedure (refer to MS-224, Section 7.2, Printer Shut Down Procedure).</p> <p>14. Ensure power switches on both IJPs are in</p>					
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	0	3	A	F	C	S	2	0	0	A	A	0	0	1
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		<p>the OFF (O) position.</p> <p>15. Open doors on FC / Canceller, Bypass / Invert, and Printer / Switchback Modules.</p> <p>16. Press and hold power button for 2 seconds on each of three UPS units starting with UPS #1, then UPS #2, and lastly UPS #3. Observe line power status LED turns off.</p> <p>Power down and lock out:</p> <p style="text-align: center;">NOTE</p> <p>Air pressure bleeds from system when POWER OFF button on Operator Control Panel (OCP) is pressed.</p> <p>17. Press POWER OFF button on OCP.</p> <div style="border: 1px solid black; padding: 2px; text-align: center; margin: 10px 0;">WARNING</div> <p>Electrical power will always be present at the input of the disconnect device unless the circuit is disabled at the facility power distribution panel located at _____.</p> <p>18. Place Main Power Distribution Unit (PDU) CB1 in off position.</p> <p>Verification:</p> <p>The verification process is comprised of two major sections:</p> <ul style="list-style-type: none"> MECHANICAL VERIFICATION THAT MACHINE WILL NOT START ELECTRICAL DE-ENERGIZATION VERIFICATION <div style="border: 1px solid black; padding: 2px; text-align: center; margin: 10px 0;">WARNING</div> <p>Lockout of electrical energy is not required for servicing or maintenance on equipment that operates at less than 50 volts to ground, provided no additional hazards are present and appropriate safe electrical practices are followed.</p> <p>If the work being performed on the machine will</p>					
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		<p>not expose workers to hazardous voltages (more than 50 Volts) and there are no other hazards, then only perform the steps listed under MECHANICAL VERIFICATION THAT MACHINE WILL NOT START and skip the ELECTRICAL DE-ENERGIZATION VERIFICATION section.</p> <p>MECHANICAL VERIFICATION THAT MACHINE WILL NOT START</p> <p>19. Press the POWER ON button on the OCP, and then press the START button. The machine should not start.</p> <p style="text-align: center;">WARNING</p> <p>If circuit elements and electrical parts normally operate at more than 50 Volts to ground and employees may be exposed to them, proceed to the electrical de-energization verification step.</p> <p>ELECTRICAL DE-ENERGIZATION VERIFICATION</p> <p style="text-align: center;">WARNING</p> <p>Before performing the following steps don the appropriate PPE as required by the current Electrical Work Plan (EWP) MMO.</p> <p>20. Don PPE.</p> <p>21. Ensure Main Disconnect Switch is in OFF position.</p> <p>22. Open the Main Power Distribution Unit.</p> <p style="text-align: center;">WARNING</p> <p>Notify supervisor if measured voltage is not expected input voltage from the facility power distribution panel to Main Power Distribution Unit. Troubleshooting must be performed as energized electrical work following guidance provided in current EWP MMO.</p>					
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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
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		<p>23. Using electrical test equipment (examples: voltmeter, or multimeter), verify the line side input is the expected input voltage from the facility power distribution panel to Main Power Distribution Unit.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>If there is greater than zero volts indicated on the test meter, immediately notify supervisor and determine where the additional electrical source(s) are and de-energize them. If electrical sources can not be de-energized, this activity must be performed as energized electrical work following guidance provided in current EWP MMO.</p> <p>24. Verify the load side of the electrical isolation device (disconnect) is at a zero energy state.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>Return all controls to the neutral or off position after attempting to start the machine or equipment.</p> <p>25. Apply lock out device as prescribed by the current local lockout instructions providing lockout/restore procedures.</p>					
AFCS-200 SYSTEM: MAIL SEARCH, CLEANING, CHECK HARDWARE	5**	<p>Clean Sensors and Check Cover Support Shocks.</p> <p style="text-align: center;">NOTE</p> <p>Ensure proper operation of cover support shocks. If any cover fails to remain open, write work order to correct.</p> <p>1. Starting at the Incline Hopper opening necessary covers, panels, and doors along mail travel path above and below the deck to perform the following while working through the machine:</p> <p style="padding-left: 40px;">Wipe dust off sensors, reflectors, and light barriers.</p> <p>2. Follow local procedures for returning mail</p>	10	All		30	

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		recovered during search to operations for processing.					
AFCS-200 SYSTEM: VACUUM #1	6**	Vacuum Singulator Module (BDS, Auto-feeder), Fine Cull 1, Manual Feeder, ACR Leveler, and Camera Area. <div style="border: 1px solid black; padding: 2px; text-align: center; margin: 10px 0;">CAUTION</div> <p>While vacuuming the machine, use non-metallic ends on the vacuum.</p> <p style="text-align: center;">NOTE</p> <p>While performing this task, watch for loose and missing hardware, also any belts with cuts, nicks, fraying, or other visible damage, write a work order to investigate and correct questionable condition.</p> <p>Vacuum the following:</p> <ol style="list-style-type: none"> 1. Singulator Module (above and below). <ol style="list-style-type: none"> a. BDS Feeder (above and below). b. Auto-Feeder (above and below, including inside doors). c. Vacuum out vacuum generator filter in Auto-Feeder. Write a work order to replace O-ring if needed (PSN 5330-06-000-0103). d. Check hose for damage (PSN 4720-17-000-0865). e. Vacuum air chamber from top pick-off belt side and from bottom of air chamber of the BDS and Auto-Feeder. 2. Fine Cull 1. <ol style="list-style-type: none"> a. Fine Cull 1 Channel Gate area b. Fine Cull 1 Reject pocket. 3. Manual Feeder (above and below). <ol style="list-style-type: none"> a. Manual Feeder crossover path. b. Vacuum air chamber from top pick-off belt side and from bottom of air chamber 	15	07		73	

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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
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		of the Manual Feeder.					
		4. ACR (leveler and camera areas).					
AFCS-200 SYSTEM: VACUUM #2	7**	Vacuum. <div style="border: 1px solid black; padding: 2px; text-align: center;">CAUTION</div> While vacuuming the machine, use non-metallic ends on the vacuum. NOTE While performing this task, note loose and missing hardware, belts with cuts, nicks, fraying, or other visible damage, and write a work order to cover any additional time needed to incorrect the condition. Vacuum the following areas: 1. Edging Channel (above and below). 2. Shingler Module (look for paper in belts). 3. VFS Air ducts and access doors under Shingler (clear paper, rubber bands, dirt, and debris). 4. Fine Cull 2. 5. Bypass/Invert. 6. Canceller.	12	07		73	
AFCS-200 SYSTEM: VACUUM #3	7.1**	Vacuum Areas Listed Below: <div style="border: 1px solid black; padding: 2px; text-align: center;">CAUTION</div> While vacuuming the machine, use non-metallic ends on the vacuum. NOTE While performing this task, note loose and missing hardware, belts with cuts, nicks, fraying, or other visible damage, and write a work order to cover any additional time needed to incorrect the condition. Vacuum the following areas: 1. Flats Extractor. 2. Printer areas only (the actual printer will be	6	07		146	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
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		covered in a separate task). 3. SBU 1. 4. SBU 2. 5. Stackers 1-12. Both top and bottom tiers.					
AFCS-200 SYSTEM: VACUUM #4	8**	Vacuum the Vacuum Generator Filter in the Manual Feeder. 1. Check hose for damage. Write a work order to replace, if necessary (PSN 4720-17-000-0865). 2. Ensure O-ring is in place and does not have visible damage. Write a work order to replace O-ring if needed (PSN 5330-06-000-0103).	5	07		1700	
INCLINE CONVEYOR 020: AIR FILTRATION FLUID	9**	Main Pneumatic Panel Air Filtration Fluid Removal. 1. At the Incline Conveyor Section, locate the container that accumulates the fluids from the air filtration system. 2. Remove the container and dispose of the contents using approved local procedures. 3. Re-install the container.	2	07		1700	
INCLINE CONVEYOR 020: AIR FILTRATION	10**	Check the Lubricator Oil Level. NOTE Refer to MS-266, Volume B, Servicing. 1. Check the oil level in the Hopper vibrator oiler. 2. If necessary, write a work order to add oil, as required, in accordance with the most recent documentation covering this procedure using pneumatic oil with a viscosity of 140 to 170 SUS at 100F Degree, Lubricant, oil, pneumatic (F442-003, NSL).	6	07		1700	
INCLINE	11**	Clean, Check, and Lubricate Incline and Over-	25	09		5500	

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CONVEYOR 020: CLEAN - CHECK BELTS - LUBRICATE	thick Units: <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Climbing on Incline Conveyor Module and Edging Channel Module is dangerous due to uneven and incline surfaces. Use ladder to access components on Incline Conveyor Module, Flat Overthick Separator Module, or Incline Overthick Separator Module that are not accessible from floor. Failure to comply may cause injury or death. 1. Ensure Main Power Distribution Unit door is secure to prevent unwanted dust from entering power box. 2. Check Incline Conveyor belt and rollers. a. Check the Incline Conveyor belt for wear and proper tracking. b. Check the Incline Conveyor for wear and loose hardware. c. Check the beater bar drive belt for wear and proper tension of approximately 1/4 inch deflection. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Various products requiring Safety Data Sheets (SDS) may be utilized during the performance of this task. Ensure the current SDS for each product used is on file and available to all employees. When reordering such a product, it is suggested that current SDS be requested. Refer to SDS for appropriate personal protective equipment. 3. Lubricate Incline Conveyor bearings. Lubricate bearing assemblies on Incline Conveyor and beaters using lithium based NLGI grade 2 grease. 4. Fill Incline Conveyor gear motors. Check oil level in Incline Conveyor and beater gear						

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		motors. Fill to proper level using AGMA #7 gear oil.					
INCLINE CONVEYOR 020: AIR FILTERS	12**	Incline Conveyor Filter Replacement. NOTE Reference MS-266 Electronic Parts Handbook, Incline Conveyor. 1. Locate the air filtration assembly on the Incline Conveyor. 2. Disassemble and clean the regulator filter and both micron mist separators. 3. Replace the filter elements as required (5 Micron PSN 4160-13-000-6672, 0.3 Micron PSN 4330-08-000-1029, .01 Micron PSN 4330-13-000-4548). 4. Re-assemble the regulator filter and Micron mist separators.	13	07		1100	
INCLINE 020 AND OVERTHICK 030: BELTS ROLLERS AND LUBRICATE	13**	Check Flat Overthick and Incline Overthick Conveyor Belts and Rollers. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Various products requiring Safety Data Sheets (SDS) may be utilized during the performance of this task. Ensure the current SDS for each product used is on file and available to all employees. When reordering such a product, it is suggested that current SDS be requested. Refer to SDS for appropriate personal protective equipment. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Climbing on Incline Conveyor Module and Edging Channel Module is dangerous due to uneven and incline surfaces. Use ladder to access components on Incline Conveyor Module, Flat Overthick Separator Module, or Incline Overthick Separator Module that are not accessible from floor. Failure to comply may cause injury or death.	23	09		5500	

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Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>1. Check Flat Overthick Conveyor Belt and Rollers.</p> <p>a. Check the Flat Overthick Conveyor belt for wear and proper tracking.</p> <p>b. Check the Flat Overthick Conveyor and drum roller drive belts for wear and proper tension.</p> <p>c. Using the GO / NO-GO gauges (PSN 3915-06-000-8521, 5210-01-432-4243) from the AFCS Tool Kit (PSN 5180-06-000-8166), check at both ends and center of the drum. If checks fail, generate a work order, and perform the complete check as outlined in MMO-001-09 or the most recent documentation covering this procedure. Make necessary adjustments using MS-266, Volume B, and re-test.</p> <p>d. Lubricate the bearing assemblies on the Flat Overthick Conveyor and drum rollers using lithium based NLGI grade 2 grease.</p> <p>e. Check the oil level in the drum roller gear motor. Fill to the proper level using AGMA #7 gear oil.</p> <p style="text-align: center;">NOTE</p> <p>Conveyor beds can get bent if stood on. This can cause the drum height to be inconsistent across the length of the drum. A culling bed kit, i.e. BED, FLAT CONVEYOR: 34.1519.028-00.SL and BED, INCLINE CONVEYOR: 34.1519.038-00.SL may be ordered from Topeka if necessary.</p> <p>PROCESS:</p> <p>2. Contact Dennis Maygers or Tom Arnold via e-mail.</p> <p>3. Provide P/N and QTY each needed.</p> <p>4. CRF will send quote and lead-time via return e-mail.</p> <p>5. Quotes may vary based on Qty ordered. For</p>					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>instance, Raleigh, NC ordered a total of 14 Beds. We were able to get the average down to under \$250 per Bed.</p> <p style="text-align: center;">NOTE</p> <p>Lead-times will vary based on our workload at the time the order is placed. Site will confirm acceptance via return e-mail. Site will provide the Finance Number and Fed Strip where they want the Beds charged to. The Fin/Fed will serve as 'Confirmation to Proceed'. Upon completion, Beds will be palletized and shipped to site via C.H. Robinson. Freight will be charged to Site Fin/Fed. After Site confirms receipt of finished Beds, CRF will request a JV to debit the Site Fin/Fed and credit CRF. JV will be completed by TMDC Accounting office.</p> <p>6. Check Inclined Overthick Conveyor Belt and Rollers.</p> <p>a. Check the Incline Overthick Conveyor belt for wear and proper tracking.</p> <p>b. Check the Incline Overthick Conveyor and drum roller drive belts for wear and proper tension.</p> <p>c. Using the GO / NO-GO gauges (PSN 3915-06-000-8521, 5210-01-432-4243) from the AFCS Tool Kit (PSN 5180-06-000-8166), check at both ends and center of the drum. If checks fail, generate a work order to perform the complete check as outlined in MMO-001-09 or the most recent documentation covering this procedure. Make necessary adjustments using MS-266, Volume B, and re-test.</p> <p>d. Lubricate the bearing assemblies on the Incline Overthick Conveyor and drum rollers using lithium based NLGI grade 2 grease.</p>					
EDGING CHANNEL: BELTS AND ROLLERS	14**	<p>Check Edging Channel, Horizontal Belts, Rollers, and Shingler.</p> <p>1. Verify knock down roller keys in Waterfall</p>	1	09		2400	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION															
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model								Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		area are in good condition and not worn excessively or damaged. 2. Use a straight edge to verify both conveyor belts are higher than the Waterfall fence. 3. Verify modules are level to ensure mail transitions smoothly from one module to the next. 4. Write a work order to perform necessary corrective actions.					
FLATS EXTRACTOR: RUBBER ROLLERS AND BELTS	15**	Check Flats Extractor Pick-Off Rubber Rollers, Belts, and Module Levels. 1. Check Flats Extractor belting for wear and signs of improper tracking. 2. Check rollers for dirt and label build up (above and below deck). 3. Check for missing green keys in red tractor belts. 4. Check horizontal transport belt for damage, improper tracking, and proper tension. 5. Check the condition of rollers for any abnormal wear or cracks that may prevent the pick off Flats. 6. Ensure no gap exists between rollers. 7. Verify modules are level to ensure a smooth mail piece transition from module to module. 8. Write a work order to perform any necessary corrective action.	1	09		5500	
SINGULATOR MODULE 70.1: BELTS	18	Check Singulator Transport and Drive belts. 1. Check for wear (frayed edges, shiny surface) and rollers for dirt build-up (above and below deck). 2. Write a work order to perform the necessary corrective actions.	1	09		420	
SINGULATOR 70.1: PRE-SINGULATOR GUIDE	19**	Check the Pre-Singulator Guides. 1. Check the Pre-Singulator Guides for proper orientation and for excessive wear and/or binding.	1	09		420	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		2. Write a work order if corrective maintenance is required.					
SINGULATOR MODULE 70.1: SINGULATOR FEEDER	20**	Clean BDS Feeder P-SEN20 and P-LED20 Assemblies. <div>WARNING</div> <p>PPE must be properly used as required by the current SDS when using alcohol. Alcohol is a flammable liquid. Discard alcohol soaked materials according to local procedures to prevent spontaneous combustion.</p> <ol style="list-style-type: none">1. Thoroughly clean transmit and receive ports of the P-LED20 and P-SEN20 modules using isopropyl alcohol on a cotton-tipped applicator.2. Ensure that the P-SEN20 and P-LED20 air lines are connected to the assemblies.	1	07		1700	
SINGULATOR MODULE 70.1: FEEDER ADJUSTMENTS	21**	Check BDS Feeder Adjustments. Check BDS Singulator Feeder adjustments that can be done with power off for proper tolerances to determine if a complete feeder alignment is necessary. Reference MS-266 or the NCED Student Training Manual. <ol style="list-style-type: none">1. Verify the pick off belts are not excessively worn, damaged, or glazed and are capable of supporting a complete running tour.2. Ensure the nylon flap and stripper flap are not damaged and are capable of supporting a complete tour.3. Verify pickoff belts and stripper flap are free of glazed build up. Scuff with 60-80 grit sand paper to remove glaze.4. Ensure the slide release lever opens the Feeder easily and does not bind.5. Verify Pick-off drive pulley is 6 mm ± 0.2 mm above the base plate by inserting a 6 mm hex wrench between the drive pulley and base plate.	10	09		73	

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	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model								Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		6. Verify distance from top of wear plate to horizontal centerline of LEDs on the P-SEN20 is 85 ± 2 mm. 7. Verify the P-LED20 LEDs align with the P-SEN20 sensors. Verify LEDs SLi1 - SLi20 go out while placing a test card between the LEDs. 8. Verify Fence Fingers are not excessively worn and rounded on the tips. 9. Verify Fence Fingers are not bent and rubbing on pickoff belts. 10. Verify Fence Fingers are adjusted to protrude to $1.0 \text{ mm} \pm 0.5\text{mm}$ inside the pickoff belts. 11. Verify Fence Sensor LED goes out after 5.0 mm of fence travel. 12. Verify Fence spring force on the middle finger of the BDS fence is 1 lb +/- 10% (0.9 to 1.1 lbs.) after 3 mm of travel. 13. Verify support backing plate just touches the back of the pickoff belts without pushing the belt out of line with the rollers. The belts and backing plate should be flush with no gaps. 14. If a feeder alignment is necessary, write a work order for any corrective action.					
AUTOFEEDER 070.2: BELTS AND HARDWARE	22**	Check Auto Feeder Adjustments. Check Auto Feeder adjustments that can be done with power off for proper tolerances to determine if a complete feeder alignment is necessary. Reference MS-266 or NCED Student Training Manual. 1. Verify the pick-off belts are not excessively worn, damaged, or glazed, and capable of supporting a complete tour. 2. Ensure the nylon flap and stripper flap are not damaged and are capable of supporting a complete tour. 3. Verify pickoff belts and stripper flap are free of glazed build up. Scuff with 60-80 grit	10	09		73	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>sand paper to remove glaze.</p> <ol style="list-style-type: none"> Ensure the slide release lever opens the Feeder easily and does not bind. Verify Pick-off drive pulley is 6 mm \pm 0.2 mm above the base plate by inserting a 6 mm hex wrench between the drive pulley and base plate. Verify distance from top of wear plate to horizontal centerline of LEDs on the P-SEN20 is 85 \pm 2 mm. Verify the P-LED20 LEDS align with the P-SEN20 sensors. Verify LEDs SLi1 - SLi20 go out while placing a test card between the LEDs. Verify Fence Fingers are not excessively worn or rounded. Verify Fence Fingers are not bent and rubbing on Pickoff belts. Verify Fence Fingers are adjusted to protrude to 1.0 mm \pm 0.5mm inside the pickoff belts Verify Fence spring force on the middle finger of the Autofeeder fence is .5 lb +/- 10% (0.45 to 0.55 lbs.) after 3 mm of travel. Verify vacuum manifold belt guide just touches the back of the pickoff belts without pushing the belt out of line with the rollers. The belts and backing plate should be flush with no gaps. If a feeder alignment is necessary, write a work order to perform the alignment. 					
AUTOFEEDER 070.2: LED ASSEMBLIES	23**	<p>Clean Auto Feeder P-SEN20 and P-LED20 Assemblies.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;">WARNING</div> <p>PPE must be properly used as required by the current SDS when using alcohol. Alcohol is a flammable liquid. Discard alcohol soaked materials according to local procedures to prevent spontaneous combustion.</p>	1	07		1700	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<ol style="list-style-type: none"> 1. Thoroughly clean the transmit and receive ports of the P-LED20 and P-SEN20 modules using isopropyl alcohol on a cotton-tipped applicator. 2. Ensure that the P-SEN20 and P-LED20 air lines are connected to the assemblies. 					
FINE CULL 1 080: DIVERTER AND PADDLE	24	Check the Fine Cull 1 Diverter and Paddle. <ol style="list-style-type: none"> 1. Check the Fine Cull 1 diverter for ease of movement. 2. Check the diverter for damage. 3. Check the Fine Cull 1 paddle for ease of movement and the absence of binding and rubbing. 4. Write a work order for any corrective action. 	1	07		7200	
MANUAL FEEDER 100: BELTS AND HARDWARE	26**	Check Manual Feeder Adjustments. NOTE An improperly adjusted Manual Feeder can contribute to an increase in mechanical rejects thereby impacting At Risk scores. <ol style="list-style-type: none"> 1. Verify pick off belts are not excessively worn or damaged, glazed and capable of the supporting a complete tour (66.0006.001-00). 2. Check for obstructions in mail path. 3. Check Strippers for even wear and verify there is no excessive wear (strip 502-32235-05, clip 66.1000.121-03). 4. Verify distance from edge of feeder throat fence to end of large Teflon strip is 25 ± 1 mm (66.1040.466-03). 5. Verify distance from edge of feeder throat fence to end of small Teflon strip is 6 ± 1 mm (66.1040.466-02). 6. Verify slide release lever opens the Feeder easily and does not bind. 7. Verify Pickoff Idler and Drive pulleys are 6 mm ± 0.2 mm above the base plate using a 6 mm hex wrench as a guide. 	10	09		5500	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
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		8. Verify vacuum chamber is flush against pickoff belts. Loose or worn pickoff belts can cause poor Manual Feeder performance. 9. Using the Feeder alignment template (66.1040-149-00), ensure the Upper and Lower pressure sensing levers protrudes from the surface of the pickoff belt by 3.5 mm for the Upper and 2.5 mm for the Lower Finger. Upper finger controls the paddle. Bottom finger controls the feeder belt. 10. Verify Stripper Stop Bracket Adjustment - Front and Back of Stripper Shoe to be within 0.3 mm. 11. Verify the P-SEN10 height is 85 ± 2 mm as measured from the top of the wear plate to the horizontal centerline of the LEDs. 12. Verify large stripper spring is 150 ± 10 grams (55.4171.426-31). 13. Verify small stripper spring is 40 ± 10 grams (502-32235-01). Not adjustable, replace as needed. 14. Run a Wide Field of View deck from the manual feeder to check Doubles Detector and manual feeder performance. Ensure to use the paddle to push the deck verses by hand. 15. If more than 1% of deck sorts to Fine Cull 2 as Doubles, a Manual Feeder adjustment is needed. 16. Write a work order to perform the necessary corrective actions.					
MANUAL FEEDER 100: ACC/ACP COMPUTER FILTERS	27**	Clean ACC/ACP Computer Fans/Filters Outer Doors. 1. Open the doors at the manual feeder to gain access to the 2 computers. 2. Remove the two filters in the outer doors and vacuum using a brush attachment. Replace if needed.	2	07		420	

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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

MANUAL FEEDER 100: ACC/ACP COMPUTER FILTERS	28**	Clean ACC/ACP Computer Filters Inner Doors. <ol style="list-style-type: none"> 1. Open the doors to access the computers. 2. Open the doors located on the front the computers. 3. Remove the filters by pulling them upwards. 4. Clean filters. 5. Reinstall the filters. 	1	07		1700	
MANUAL FEEDER 100: P-SEN10 P-LED10	29**	Clean Manual Feeder P-SEN10 and P-LED10 Assembly and Vacuum Chamber. <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;">WARNING</div> <p>PPE must be properly used as required by the current SDS when using alcohol. Alcohol is a flammable liquid. Discard alcohol soaked materials according to local procedures to prevent spontaneous combustion.</p> <ol style="list-style-type: none"> 1. Thoroughly clean the transmit and receive ports of the P-LED10 and P-SEN10 modules using isopropyl alcohol on a cotton-tipped applicator. 2. Ensure that the P-SEN10 and P-LED10 air lines are connected to the assemblies. 3. Make sure the vacuum chamber is aligned parallel to the pick off belts and just touching the pick off belts. 4. If any problems are encountered generate a work order to do corrective maintenance. 	2	07		1700	
ACR 110: ROLLERS AND PLATE	30**	Clean and Check ACR Cameras and Hardware. Reference MS-266, Volume B. <p style="text-align: center;">NOTE</p> <p>Verify white calibration tab is intact on faceplate and not discolored.</p> <p style="text-align: center;">NOTE</p> <p>If a camera is replaced, be sure to keep the suspect camera faceplate. Topeka does not stock faceplates.</p>	4	07		73	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM		

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
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		<p align="center">NOTE</p> <p>Ensure Leveler belts are installed with white lettering on the inside so as not to cause unwanted camera triggering.</p> <ol style="list-style-type: none"> 1. Remove the camera faceplates. Verify the faceplates of the two cameras are clear of any foreign substance or dirt. Clean as required. 2. Clean the camera LEDs using the bottle brush. Be aware that a sticky residue can build up on the LEDs, which may not be removed using the bottle brush. In this case, a soft clean cotton cloth dampened with water may be used. 3. Write a work order for any corrective actions. 					
ACR 110: ACR CAMERA AND ROLLERS	31**	<p>Check Camera and Roller Adjustments</p> <p align="center">NOTE</p> <p>Reference: MS 266 for adjustment procedures.</p> <ol style="list-style-type: none"> 1. Verify that the cameras are properly adjusted with relation to the belts. The foam roller should be pushed up against the belt so that approximately 1 inch of the roller contacts the belt. 2. Verify the center of the roller is approximately 15 mm upstream from the center of the read window. 3. Inspect both camera foam rollers for damage and/or excessive wear. 4. Verify foam rollers are adjusted properly to the aperture to ensure mail is presses against aperture. 5. Verify foam roller just touches the belt on the backside of the roller. 6. Verify that the air lines are connected to the camera to ensure proper cooling. 7. Write a work order for any corrective action. 	5	09		420	
DOUBLES	32**	Clean Doubles Detector Lens.	1	07		73	

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	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
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Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
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DETECTOR 120: CLEAN		Using a lens cleaning cloth or Microfiber Gloves (PSN-8415-06-000-7500), wipe the glass cover on the Doubles Detector camera.					
PRE ID DETECTOR 130.1: CLEAN	33**	Check and Clean ID-Tag Pre-Reader and Air Filter. NOTE At this time, the Pre-Reader is not used for pre-reading functions but it must be powered on to get a ready light and before the machine can be run. 1. Check ID Tag Pre-Reader readhead faceplate, window, and reflector for accumulation of dried ink, dirt, or foreign matter. If needed, clean using lens cleaner and cotton tipped applicator or a Micro Fiber glove or cloth, recommended cleaner is Riptide, PSN 6850-01-394-0164, and P/N RIP-TIDE-BX4EA. 2. Vacuum the air filter located on the face of the ICS Electronics Assembly. 3. Replace filter if damaged or dirt can not be removed by vacuuming. Obtain filter material from Siemens. NOTE Siemens Postal, Parcel & Airport Logistics LLC P.O. Box 613209 2700 Esters Blvd. Suite 200 B DFW Airport, TX 75261-3209	1	07		1100	
ID-TAG VERIFIER 130.2: CLEAN	34**	Check and Clean ID-Tag Verifier and Air Filter. 1. Check ID Tag Verifier read head faceplate, window, and reflector for accumulation of dried ink, dirt, or foreign matter. If needed, clean using lens cleaner and cotton tipped applicator or a Micro Fiber glove or cloth. Recommended cleaner is Riptide, PSN 6850-01-394-0164, and P/N RIP-TIDE-BX4EA. 2. Vacuum the air filter located on the face of the ICS Electronics Assembly.	3	07		73	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
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		<p>3. Replace filter if damaged or dirt can not be removed by vacuuming. Obtain filter material from Siemens.</p> <p>NOTE</p> <p>Siemens Postal, Parcel & Airport Logistics LLC P.O. Box 613209 2700 Esters Blvd. Suite 200 B DFW Airport, TX 75261-3209</p>					
FINE CULL #2 140: STIFFNESS DETECTOR	35**	<p>Fine Cull Stiffness Detector.</p> <p>NOTE</p> <p>Belts should be correctly tensioned before making adjustments.</p> <p>NOTE</p> <p>Also, be aware that due to the design of the Stiffness detector, adjustments can change during the tightening process.</p> <p>NOTE</p> <p>An improperly adjusted stiffness detector can increase Fine Cull 2 rejects thereby impacting At Risk scores.</p> <ol style="list-style-type: none"> 1. Check the swing arm for ease of movement. 2. Ensure the bumpers are not worn and that the mechanism is adjusted correctly. 3. With a digital force gauge, verify force required to pull roller assembly approximately 3 mm toward baseplate outer edge is 4.9 to 5.0 lb. 4. Verify Idler Roller edge is 83 mm from edge of baseplate at the home position. 5. Verify the LED goes out when the Idler Roller is pulled 74 mm from the home position. 6. If more extensive adjustment is needed, generate a work order and perform the adjustment in accordance with MS 266, Volume B, Alignment and Adjustment Procedures. 	1	09		1700	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1
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LUMIN DETECT 160: CLEAN	36**	Check Luminescent Detector. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>Due to the heat generated by these lamps, ensure the machine has been powered down long enough for the lamps to cool (approximately 15 minutes).</p> <p style="text-align: center;">NOTE</p> <p>Schedule this task towards the end of the PM tour to allow lamp and unit to cool.</p> <p style="text-align: center;">NOTE</p> <p>Reference MS-266 for cleaning procedure.</p> <ol style="list-style-type: none"> 1. Ensure the Detector read head is clear of any foreign debris, label, or dirt. 2. Clean faceplate and two windows. 3. Confirm air lines are connected to the read head and the inverter assemblies (air flows from the panel into the read head first and then into the inverter second). 4. Ensure belts are not rubbing on air lines. 	1	07		420	
CANCELLER 170: IJC CHECK PURGE AND CLEAN	37**	Ink Jet Cancellor. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>Chemical proof goggles (with side shields), aprons, and rubber gloves must be worn when handling cancellation ink.</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">CAUTION</div> <p>Do not over tighten the ink bottle. Over tightening the ink bottle may cause the bottle cap to break.</p>	16	10		30	

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					Run Hours	Pieces Fed (000)	Freq.

		<p style="text-align: center;">CAUTION</p> <p>Do not wipe or blot the printhead engine or orifices. Wiping or blotting may damage the print engine or clog the orifices.</p> <p style="text-align: center;">CAUTION</p> <p>Use manufacturer recommended clean wipes and foam swabs when performing the cleaning tasks associated with the IJC.</p> <p style="text-align: center;">CAUTION</p> <p>To avoid damaging the print engine, do not contact the bottle tip on the orifices.</p> <p style="text-align: center;">CAUTION</p> <p>If cleaning areas around the printer not associated with the printer, put a blank test card or equivalent over print engine plate to protect it from cleaning agents.</p> <ol style="list-style-type: none"> 1. Check the ink bottles on the ink system of the IJC deck plate assembly. If an ink bottle is empty, replace by removing ink bottle ship cap from new ink bottle and install ship cap onto empty ink bottle. Discard empty ink bottle. 2. Insert the new ink bottle into the ink bottle port, aligning the arrow with the mate line and tighten. 3. Clean print engine: <ol style="list-style-type: none"> a. Move springs away from the printhead and lock in the maintenance position. b. Remove the top cover from the printhead using a 5 mm hex wrench. c. Insert two folded clean-wipes on each side of the print engine. Refer to latest documentation (currently MMO-061-06) for illustrations and information. 					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>Discard solvent soaked materials according to local procedures to prevent spontaneous combustion.</p> <p>d. Spray print engine with 2 squirts of approved cleaning solvent (PSN 7930-07-000-4112). Let solvent soak for 30 minutes while continuing with other tasks.</p> <p>4. After 30 minutes, continue with the following:</p> <p>a. Using cleaning swabs, clean dust and debris from the three holes and gap between print engines rub strip. Refer to latest documentation (currently MMO-061-06) for illustrations and information.</p> <p>b. Remove clean wipes inserted in step 2.c, and clean this area, including the slots on both sides, with wipes and vacuum. Refer to latest documentation (currently MMO-061-06) for illustrations and information.</p> <p>5. Purge the printheads:</p> <p>a. Move springs away from the printhead and lock in the maintenance position.</p> <p>b. Using only recommended clean wipes, fold three clean wipes in half, and place flat under the front of the engine. Do not touch print engine.</p> <p>c. While holding clean wipes in place, lightly press purge bulb through a full depression on the ink system until ink is expelled from orifice. Continue to hold clean wipes under print engine for approximately 15 seconds. Remove and discard wipes.</p> <p>d. Using new clean wipes, wipe ink from printhead rub strip and front of print engine.</p> <p>e. Use cleaning solution and wipes to remove any excess ink or debris from guide springs.</p>					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION															
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model								Bulletin Filename mm14072ag			Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>f. Pull pin up on guide springs and rotate toward printhead orifices. Lower pin to lock springs in place. The short spring should just make contact with the rub strip, and the long spring should be flush to 1/8" from the surface of the rub strip.</p> <p>g. Reinstall top cover with 5 mm hex wrench.</p>					
ID-TAG IJP: INK SUPPLY	38**	<p>Check ID-Tag Printer Ink/Makeup Level.</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p>Open the door to the machine and the door on the IJP and validate that the level of ink and make-up fluid is greater than 1/8 full. If less than 1/8 full replace as follows:</p> <ol style="list-style-type: none"> 1. Removing the cap on the bottle in the IJP. 2. Removing and replacing the old bottle. 3. Replacing the cap on the new bottle. 4. Clean up any spilled or splattered ink. 5. Close the printer door and machine door. 	3	10		420	
ID-TAG IJP: CLEAN	39**	<p>ID-Tag Printhead Cleaning.</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p style="text-align: center;">NOTE</p> <p>Reference MS-224, VideoJet 37PC manual.</p> <p style="text-align: center;">NOTE</p> <p>IJP should already be properly shutdown at the switch after performing daily shutdown step.</p> <ol style="list-style-type: none"> 1. Remove the printhead from the machine and 	6	10		30	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		remove the outer cover. 2. Inspect the printhead. 3. Clean printhead ink build up by spraying with makeup fluid. 4. Ensure printhead is completely dry before use. 5. Reinstall outer cover and install the printhead on the machine.					
ID-TAG IJP: ID TAG PRINTER AND DECK PLATE	40	Clean the Area Near the IJP Printhead. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> 1. Inspect the area around the IJP printhead for dirt and debris. 2. Clean the area of any ink splatter using makeup fluid or other approved cleaner.	5	10		146	
ID-TAG IJP: FILTER	41**	Vacuum Filter Replacement. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p style="text-align: center;">NOTE</p> <p>Reference MS-224, VideoJet 37PC manual.</p> <p>Inside of the IJP assembly locate, remove, and replace the vacuum filter.</p>	5	10		1700	
ID-TAG IJP: FILTERS	42**	Final Ink and Input Air Filter Replacement. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p style="text-align: center;">NOTE</p>	15	10		5500	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION															
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		Reference MS-224 Videojet 37PC manual. Inside of the IJP assembly locate, remove, and replace 1. Final ink filter. 2. Input air filter. 3. Filter tube assemblies.					
SORTCODE IJP 180.2: INK SUPPLY	43**	Check the Sortcode IJP Ink level. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p>Open the door to the machine and the door on the IJP and validate that the level of ink and make-up fluid is greater than 1/8 full. If less than 1/8 full replace by:</p> <ol style="list-style-type: none"> 1. Remove the cap on the bottle in the IJP. 2. Remove and replace the old bottle. 3. Replace the cap on the new bottle. 4. Clean up any spilled or splattered ink. 5. Close the printer door and machine door. 	3	09		420	
SORTCODE IJP 180.2: PRINTHEAD	44**	IMb IJP Printhead Cleaning. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <ol style="list-style-type: none"> 1. Remove the printhead from the machine and remove the outer cover. 2. Inspect the printhead. 3. Clean printhead ink build. 4. Reinstall outer cover and install the printhead on the machine. 	6	10		73	
SORTCODE IJP 180.2: SORTCODE	45	Clean the Area Near the IJP Printhead.	5	10		146	

U.S. Postal Service Maintenance Checklist		IDENTIFICATION													
		WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
		0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200		Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

DECK PLATE		<div>WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <ol style="list-style-type: none"> 1. Inspect the area around the IJP printhead for dirt and debris. 2. Remove mail guides if necessary. 3. Clean the area of any ink splatter using makeup fluid or other approved cleaner. 4. Replace mail guides. 					
SORTCODE IJP 180.2: VACUUM FILTER	46**	Vacuum Filter Replacement. <div>WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p>Inside of the IJP assembly locate, remove, and replace the vacuum filter.</p>	5	10		1700	
SORTCODE IJP 180.2: FILTERS	47**	Final Ink and Input Air Filter Replacement. <div>WARNING</div> <p>When disposing of ink or ink saturated waste, refer to procedures outlined in current Safety Data Sheets (SDS).</p> <p>NOTE</p> <p>Reference MS-224 Videojet 37PC manual.</p> <p>Inside the IJP assembly locate, remove, and replace;</p> <ol style="list-style-type: none"> 1. Final ink filter. 2. Input air filter. 3. Filter tube assemblies. 	15	10		5500	
BAR CODE VERIFIER 190: CLEAN	48**	Check Sortcode Bar Code Verifier Read Head. Check/clean the Verifier read head to ensure it is	2	09		73	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM							CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		clear of any foreign debris or dirt.					
STACKER SECTION #1: ACR COMPUTER FILTER	49**	Clean ACR Computer Filter (Outer Door). 1. Gain access to the computer door filter. 2. Vacuum using brush attachment. 3. Reinstall filter and secure door.	2	07		420	
STACKER SECTION #1: ACR COMPUTER FILTERS	50	Clean ACR Computer Filters (Inner Doors). 1. Open the doors to access the computers. 2. Open the doors located on the front the computers. 3. Remove the filters by pulling them upwards. 4. Clean filters. 5. Reinstall the filters.	1	07		1700	
STACKER SECTION #1: ACR COMPUTER FILTER	51	Replace ACR Computer Filter (Inner Doors). 1. Gain access to the computer door filter. 2. Replace filter with new filter. 3. Discard old filter. 4. Secure computer filter door.	2	07		5500	
STACKER SECTION #2: LABEL PRINTER	52	Check Tray Label Printer. 1. Check the label printer for sufficient paper stock to last for a full tour of processing operation. 2. Add paper stock if necessary. 3. Ensure paper stock is ready to be fed and all pathways are clear of obstruction/debris. 4. Clean exterior with approved general purpose cleaner.	1	07		73	
SHINGLER 060: SHOE ADJUSTMENT CHECKS	16**	Check all Shoe Assembly Adjustments. NOTE If the adjustments are found to be out of tolerance write a work order to perform the appropriate corrective maintenance. Reference the MS-266 for adjustment procedures.	20	09		5500	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		Check First Shoe assembly. NOTE The first plastic spring guide touching the tractor belt is not considered the first shoe. This piece should not require adjustment. However, ensure spring guide is properly installed where bolt heads of angle bracket are not extending into the mail path causing jams. The Flats Extractor and Shingler Module frame securing hardware bolts can be loosened to ensure this spring guide is properly installed and modules are aligned properly if necessary. Tighten hardware when alignment is complete. 1. Check to ensure the distance from the tractor belt to the face of the shoe is set 44-48 mm. 2. Ensure the action of the Shoe does not bind on the Switch. 3. Check the proximity switch LED for proper actuation. 4. Using Shimpo meter force gauge with extension check the spring force for a measurement of 0.3 - 0.4 lbs. after 2-3 mm of movement. 5. Verify a distance of 2-3 mm exists between the proximity switch and the shoe. 6. Insert the 2-3 mm gauge for Shoe #1 between Shoe #1 and the tractor belt. Slowly insert the 8-9 mm shoe gauge between shoe #1 and the 2-3 mm gauge. 7. Confirm SHPROX1 goes active at 10-12 mm – means that the indicator light on the base of the sensor should just go out when the 10 – 12 mm shoe gauge is installed in the throat of Shoe #1. The LED on the proximity switch should go out. Check Second Shoe assembly. 1. Check to ensure the distance from the tractor belt to the face of shoe is 10-12 mm.					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>2. The face of the shoe should be approximately parallel to the tractor belt.</p> <p>3. Using a force gauge check to ensure the spring force tension is 0.32 to 0.36 lbs. measured at the tip of the shoe and after 3 mm of shoe movement.</p> <p>Check Third Shoe assembly.</p> <p style="text-align: center;">NOTE</p> <p>The third shoe was replaced by a pinch roller.</p> <p>1. With a spring tension gauge, check for 1.4 - 1.8 pounds of tension at the roller shaft after 3 mm of movement.</p> <p>2. Check to ensure the distance between the roller and tractor belt is 25-29 mm.</p> <p>Check Fourth Shoe assembly.</p> <p>1. Check to ensure the distance between the shoe and the tractor belt is 8-9 mm using the 8-9 mm gauge.</p> <p>2. Using a spring tension gauge, check to ensure the spring force is 0.33 - .037 lbs. measured at the tip of shoe after 3 mm of movement.</p> <p>3. Using a digital force gauge, verify the tension at the shaft of the pinch roller is 1.3 - 1.7 lbs. after 3 mm of movement. A distance of 27-31 mm between the Spring Post and the knurled nut is a good starting place.</p> <p>Check Fifth Shoe assembly.</p> <p>1. Check to ensure the fifth shoe is just touching the inboard guide.</p> <p>2. Check to ensure there is a 2-3 mm clearance between the shoe and the proximity switch.</p> <p>3. The proximity switch bracket must aligned with the switch vertically and horizontally with the slot in the actuating arm. Verify the proximity switch is close enough to actuator properly without interfering with the</p>					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
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		movement of the shoe. 4. Slide the fifth shoe gauge (5-6 mm) along the inboard guide until it begin to push against the fifth shoe. 5. Confirm SHPROX2 goes active at 5-6 mm – means that the indicator light on the base of the sensor should just go out when the 5-6 mm shoe gauge is installed between the metal guide and the end of Shoe #5. Check Sixth Shoe assembly. 1. Check to ensure the sixth shoe is just touching the vertical transport belt. 2. Check to ensure there is a 2-3 mm clearance between the shoe and the proximity switch. 3. Slide the 5-6 mm shoe gauge along the vertical transport belt until it begins to push against the sixth shoe. 4. Confirm SHPROX3 goes active at 5-6 mm – means that the indicator light on the base of the sensor should just go out when the 5-6 mm shoe gauge is installed between the metal guide and the end of Shoe #6 5. If properly adjusted the LED should begin to go out just as the gauge is completely between the shoe and the belt. 6. Care must be taken that the slot in the shoe does not hang up on the proximity switch when opened greater than 18 mm. .					
EDGING CHANNEL: PROPORTIONAL SENSOR ADJUSTMENT CHECK	53**	Check Proportional Sensor for Proper Adjustment. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> To determine if the proportional sensor is properly adjusted requires the system to be powered on.	2	09		420	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p align="center">NOTE</p> <p>Proportional Sensor is connected to MIC 0 at J8. This connection has no polarizing key. The upper right corner should house the brown wire when properly installed.</p> <p align="center">NOTE</p> <p>The following are symptoms that the proportional sensor is missing, not connected, or misadjusted:</p> <p>Missing/Not Connected</p> <ul style="list-style-type: none"> • Culler motors slowing down. • Culler belts slowing down. <p>Misadjusted</p> <ul style="list-style-type: none"> • Too little or too much mail in Edger • Excessive jams in Edger <p>Check to ensure the Proportional Sensor is properly adjusted.</p> <p><u>Reference May 25, 2012, Volume 14, No. 32 Maintenance Update Article.</u></p> <ol style="list-style-type: none"> 1. Verify that the LED is "On" solid when the roller is resting against the red shingler belt. 2. Verify the LED flashes when the roller is gently pressed against the shingler belts. 3. Verify the LED is "On" solid and the light barrier is not blocked when the roller is furthest away from the shingler belts. 4. Verify brown roller is in good condition and free of sticky build up and labels. 					
AFCS-200 SYSTEM: POWER UP	54**	<p>Restore Power to the Equipment Using the Following Reference.</p> <p>For detailed steps to properly power up the system refer to MS Handbook MS-266, Volume B, Section 3.2.1 and Section 3.2.2.</p> <ol style="list-style-type: none"> 1. Close all covers and secure all doors except for doors to access the computers and UPSs. 	10	10		30	

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	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		2. Place Main Power Distribution Unit (PDU) CB1 in ON position. 3. Press POWER ON button on Operator Control Panel (OCP). 4. Press power button on each of three UPSs. 5. Open left door on ACR computer, ACP computer, and ACC computer front panels. 6. Place power switch on ACR computer, ACP computer, and ACC computer in "ON" (I) position. 7. Secure doors to computers and UPSs.					
AFCS-200 SYSTEM: EMERGENCY STOP SWITCHES	55**	Check Emergency Stop Switches. <div style="border: 1px solid black; padding: 2px; text-align: center; margin: 10px 0;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine to be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <div style="border: 1px solid black; padding: 2px; text-align: center; margin: 10px 0;">WARNING</div> <p>Failure of any emergency stop switch must be corrected before returning the machine to operation.</p> <p style="text-align: center;">NOTE</p> <p>Check emergency stop switches. Check only one emergency stop switch with machine running. Check all other emergency stop switches with machine stopped.</p> 1. Activate each emergency stop switch. 2. Ensure that the red lamp in the body of the emergency stop switch lights, and that there is an indication on the GUI. Replace any inoperative LED lamps. If replacement of LED lamp does not correct problem write a work order to correct the problem. 3. Reset the emergency stop switch.	5	09			M

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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>4. Repeat steps 1 through 4 for each emergency stop switch listed below. This list gives first the module followed by the quantity of emergency stop switches in said module.</p> <ul style="list-style-type: none"> a. Incline Conveyor - 3 b. Over-thick Separator - 1 c. Edging Channel - 2 d. Flats Extractor - 1 e. Shingler - 1 f. Post BDS - 1 g. Singulator - 1 h. Fine Cull 1 - 1 i. Manual Feeder - 1 j. Leveler - 1 k. ACR - 1 l. Fine Cull #2 - 1 m. By-Pass Invert - 1 n. Printer Module - 1 o. SBU #1 - 1 p. SBU #2 - 1 q. Canceller Module - 1 r. Stacker Module #1 - Upper Tier - 1 s. Stacker Module #2 - Lower Tier - 1 t. OCP - 1 					
AFCS-200 SYSTEM: INTERLOCK SWITCHES	56**	<p>Check Interlock Switches.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught</p>	10	09			M

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>in moving parts.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;">WARNING</div> <p>Failure of any safety interlock switch must be corrected before returning the machine to operation.</p> <p style="text-align: center;">NOTE</p> <p>Check interlock switches. Check only one emergency interlock switch with machine running. Check all other interlock switches with machine stopped.</p> <ol style="list-style-type: none"> 1. Open appropriate panel, door, or top cover. 2. Ensure that the red malfunction/fault lamp lights and that there is an indication on the GUI. Replace any burnt out lamps. If replacement of bulb does not correct problem, write a work order to troubleshoot. 3. Close the panels, doors, or top covers. 4. Ensure that the malfunction/fault lamp extinguish. 5. Repeat steps 1 through 4 for each interlock stop switch listed in table below. This list gives first the module followed by the quantity of emergency stop switches in said module. <ol style="list-style-type: none"> a. Hopper - 1 b. Incline Conveyor - 3 c. Overthick #1 and #2 - 8 d. Edging Channel - 2 e. Flats Extractor - 4 f. Shingler - 1 (Pre BDS Hood) - 1 g. Singulator - 5 h. Fine Cull 1 - 2 i. Manual Feeder - 6 j. Leveler - 2 k. ACR - 2 l. Fine Cull #2 - 2 					
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	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag			Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		m. By-Pass Inverter - 2 n. Printer Module - 2 o. End of Facer Module - 1 p. SBU #1 - 2 q. SBU #2 - 2 r. Canceller Module - 2 s. Stacker Module - 8 t. MIC 0 Control Box (under the Incline Conveyor) - 1					
AFCS-200 SYSTEM: PREDICTIVE MAINTENANCE	57**	Perform Predictive Maintenance. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts. NOTE While performing these tasks make a note of any area where excessive vibration, noise, and/or heat are detected. Initiate a work order to cover any annotated area that requires additional investigation. Prepare Machine. NOTE Ensure all necessary doors and panels are open and interlock switches are enabled to perform the following Predictive Maintenance tasks. 1. Ensure system is powered up. a. The monitor will display the start up process and bring you to the Log In Screen. b. At the HMI under Processing, select	90	10		8000	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p><RUN>.</p> <p>c. Then select <Start Run> tab.</p> <p>d. Under "Mode" select <Maintenance Without Printing> from the drop down menu.</p> <p>e. Select <Start Run>.</p> <p>f. On the OCP verify Culler READY and Facer Ready Lamps are illuminated.</p> <p>g. Press the START CULLER and the START FACER push buttons on the OCP to start the machine.</p> <p style="text-align: center;">NOTE</p> <p>The machine must have been running for minimum of 15 minutes prior to starting the Ultrasonic Scan Test.</p> <p>2. Ultrasonic scan tasks (Bearings and Air Leaks).</p> <p>a. Conveyor section - Monitor all bearing assemblies, top and bottom, of the conveyor sections for excessive vibration and noise. This includes the Incline Conveyor, Incline Overthick Separator, and Flat Overthick Separator. Check for compressed air leaks at valves, filters, and manifold.</p> <p>b. Edger channel - Monitor all bearing assemblies, top and bottom, of the Edging Channel for excessive vibration and noise.</p> <p>c. Flats extractor - Monitor all bearing assemblies, top and bottom, of the Flats Extractor for excessive vibration and noise.</p> <p>d. Shingler - Monitor all bearing assemblies, top and bottom, of the Shingler for excessive vibration and noise.</p> <p>e. Singulator - Monitor all bearing assemblies, top and bottom, of the Singulator for excessive vibration and noise. Check for compressed air leaks at</p>					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM							CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM		

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>valves, filters, and manifold.</p> <p>f. Auto-Feeder - Monitor all bearing assemblies, top and bottom, of the Automatic Feeder for excessive vibration and noise.</p> <p>g. Manual Feeder - Monitor all bearing assemblies, top and bottom, of the Manual Feeder for excessive vibration and noise.</p> <p>h. Leveler/ACR - Monitor all bearing assemblies, top and bottom, of the Leveler/ACR for excessive vibration and noise.</p> <p>i. Fine Cull#2/Canceller - Monitor all bearing assemblies, top and bottom, of the Fine Cull#2/Canceller for excessive vibration and noise.</p> <p>j. ByPass Inverter/SBU#2 - Monitor all bearing assemblies, top and bottom, of the ByPass Inverter/SBU#2 for excessive vibration and noise.</p> <p>k. Printer/SBU#1 - Monitor all bearing assemblies, top and bottom, of the Printer/SBU#1 for excessive vibration and noise.</p> <p>l. Stacker Section - Monitor all bearing assemblies, top and bottom, of the Stacker Section for excessive vibration and noise.</p> <p>3. Tasks to perform the infrared scans (Electrical terminals, belts).</p> <p style="text-align: center;">NOTE</p> <p>Open any additional doors and panels. While opening additional doors and panels to perform the infrared scans, ensure appropriate interlock switches are enabled to perform the following Predictive Maintenance tasks.</p> <p style="text-align: center;">NOTE</p> <p>The machine must have been running for</p>					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>minimum of 15 minutes, (normally while doing the Ultrasonic Scans) and remain running when using non-contact infrared to obtain correct scans. Investigate cause of abnormal temperature and notify supervisor before taking corrective action.</p> <ol style="list-style-type: none"> Main Power Box - Monitor the Main Power Distribution Panel for abnormal temperature. Scan all terminal connections, belts, and connector plugs. Incline Power Box - Monitor the Incline Power Box assembly for abnormal temperature. Scan all terminal connections and connector plugs. Conveyor - Monitor the Conveyor section for abnormal temperature. This includes the Incline Conveyor, Flat Over-thick Separator, and Incline Over-thick Separator. Scan all motors, terminal connections, belts, and connector plugs. Edging Channel - Monitor the Edging Channel for abnormal temperature. Scan motor, terminal connections, belts, and connector plugs. Flats Extractor - Monitor the Flats Extractor for abnormal temperature. Scan motors, terminal connections, and connector plugs. Shingler - Monitor the Shingler for abnormal temperature. Scan motors, terminal connections, and connector plugs. Singulator section and Power Distribution Box - Monitor the Singulator for abnormal temperature. Scan Power Distribution Box, motors, terminal connections, belts, and connector plugs. Auto-Feeder - Monitor the Auto-Feeder for abnormal temperature. Scan motors, terminal connections, belts, and connector plugs. 					
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U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceled System 200	Equipment Model								Bulletin Filename mm14072ag			Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		i. Manual Feeder - Monitor the Manual Feeder for abnormal temperature. Scan all terminal connections, belts, and connector plugs. j. Leveler/ACR section - Monitor the Leveler/ACR section for abnormal temperature. Scan motors, terminal connections, belts, and connector plugs. k. Fine Cull/Canceller section - Monitor the Fine Cull/Canceller section for abnormal temperature. Scan motor, terminal connections, belts, and connector plugs. l. Facer Power Distribution Box - Monitor the Facer Power Distribution Box for abnormal temperature. Scan all terminal connections, belts, and connector plugs. m. Variable Frequency Power Distribution Box - Monitor the Variable Frequency Power Distribution Box for abnormal temperatures. Scan all terminal connections, belts, and connector plugs. n. ByPass Inverter/SBU#2 - Monitor the ByPass Inverter/SBU#2 for abnormal temperature. Scan motors, terminal connections, belts, and connector plugs. o. Printer/SBU#1 - Monitor the Printer/SBU#1 for abnormal temperature. Scan motors, terminal connections, belts, and connector plugs. p. Stacker Section - Monitor the Stacker Section for abnormal temperature. Scan motors, terminal connections, belts, and connector plugs.					
HOPPER 010: OILER CHECK	58**	Check Vibrator Hopper Oil Rate. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in	3	09		420	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		moving parts. Start Culler and Facer. 1. While machine is running, check for excessive oil around vibrator hopper. <p style="text-align: center;">NOTE</p> 30 psi is a good starting point. Adequate mail volume on Incline may be achieved by setting regulator to 15 - 30 psi. It is common to see some variation from one machine to the next machine. <p style="text-align: center;">NOTE</p> Always reference the Peak Season bulletin to ensure the Hopper angle and critical adjustments have not changed if required psi is higher than 30. 2. Verify the Electro-pneumatic regulator is set to achieve adequate mail volume to cover incline. 3. Turn the Adjustment knob CCW to ensure a rate of 1 to 2 drops per minute (1 drop every 30 to 40 seconds). 4. Stop the Culler and Facer when rate check is completed.					
FINE CULL 1 080: POCKET FULL SWITCH	60**	Check the Fine Cull 1 Pocket Full Switch. <div style="border: 2px solid black; padding: 5px; text-align: center; margin: 10px 0;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> 1. Start the machine. 2. When the belts are moving, pull the Fine Cull paddle to the 75% full position and you should get a warning on the GUI. 3. Move the paddle to the 100% position and	1	09		8500	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION															
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model								Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		the machine should stop, validate that the machine stops and reports the pocket full. 4. Write a work order for any needed corrective action.					
FINE CULL 1 080: METAL DETECTOR	61**	Check Fine Cull #1 Metal Reject Metal Detection Sensor Adjustment. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts. 1. Verify that the LED turns on when a piece of metal is brought in the proximity of sensor. 2. Check alignment of metal detector for proper operation in accordance with the most recent documentation covering this procedure. 3. Verify distance from face of sensors to center of two belts is 14 mm. 4. Write a work order is corrective action is required.	1	09		8500	
ACR 110: CALIBRATION	62**	Perform ACR Camera Calibration. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts. <div style="text-align: center;">NOTE</div> Reference MS-266 and ensure a good quality calibration card is used. Perform a camera calibration on both ACR Cameras.	10	10		420	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<ol style="list-style-type: none"> 1. Obtain an ACR camera calibration card. 2. On the GUI select "Maintenance" and then "ACR". 3. Start the machine. 4. Note the orientation and run the calibration card. 5. View the image of the card on the GUI and validate that the horizontal and vertical location is correct. 6. View the image and validate that the image quality is acceptable. 7. Change the calibration card orientation for the other camera and repeat the validation. 					
LUMIN DETECT 160: CALIBRATION	63**	Perform a Calibration of the Luminescent Detector. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts. NOTE Reference MS-266. Perform the calibration of the Luminescent Detector in accordance with the most recent documentation covering this procedure.	5	10		420	
PRE ID DETECTOR 130.1: FANS	64**	Check the ID-Tag Pre-Reader Fan and Power Supply Fan. <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. NOTE The Pre-Reader features are not currently	1	09		1100	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM		

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>being used. However, the Pre-Reader must be powered on in order to get a ready light.</p> <ol style="list-style-type: none"> Check the ID-Tag Pre-Reader Fan. <ol style="list-style-type: none"> Check that there is no light emitting from the read head before making the following check. Check the Electronics fan located behind the halogen lamp to be rotating at a high speed. A light source may be required to view the rotation. Check the ID-Tag Pre-Reader Power Supply Fan and verify it is rotating at a high speed. 					
BAR CODE VERIFIER 190: CALIBRATION	65**	<p>Perform a Verifier System Calibration.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <p>Perform the Bar Code Verifier System calibration in accordance using MS-266, Volume B, Alignments and Adjustments, Bypass, Invert, and Switchback Module, Barcode Reader procedure.</p>	15	10		5500	
SBU #1 AND SBU #2: MAINTENANCE TEST	66**	<p>SBU 1 and SBU 2 Functional Test.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <p style="text-align: center;">NOTE</p> <p>SBU belts can be turned inside out to</p>	10	10		420	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		extend the life of the belt. NOTE Belts should not slip easily if grasped with thumb and forefinger and slide in opposite direction. 1. Logon as Maintenance. 2. Under Maintenance select Tests. 3. Select test SBU 1-SBU 2 tests. 4. Run approximately 100 test deck cards using the Manual feeder. 5. Verify zero pieces are in the SBU 1 and SBU 2 reject pockets. 6. Verify test cards in Stacker pocket are not damaged or folded. If either exists, write a work order to adjust SBU belt tensions as needed. 7. Reference Bin/Labels tab on GUI to note that SBU1 pieces should sort to bin 5 while SBU2 pieces should sort to bin 11.					
STACKER SECTIONS: POCKET PADDLES AND BIN SWITCHES	67**	Check Stacker Pocket Paddles and Switches. <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts. 1. Press the START FACER pushbutton on the Operator Control Panel. 2. Ensure the belts are moving. NOTE Activation of the 100% switches in Bins 1-5 and 7-11 will stop the Culler. Activation of the 100% switches for Bin 6 and 12 will stop the machine. Activation of the 75% switches for Bins 1-5 and 7-11 will display	2	07		5500	

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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200		Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>a warning on the GUI.</p> <p>3. Check all of the stackers bin switches using the red indicator lamps on the face of the stacker bin as follows:</p> <ol style="list-style-type: none"> Pull the pocket paddle back to the 75% position. Ensure that the red lamp flashes. Pull the pocket paddle to the 100% position. Ensure that the red lamp is on steady. Ensure the paddle rides smoothly and that there is consistent spring tension. <p>4. Press the STOP Pushbutton on the Operator Control Panel.</p>					
STACKER SECTION #2: LABEL PRINTER	68**	<p>Check the Tray Label Printer for Faults.</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied</p> <ol style="list-style-type: none"> Ensure unit has input power and is free of faults. Print a test card by pressing one of the bin label print selection switches next to the Operator Control Panel. Last run sortplan information will be printed. 	1	09		420	
AFCS-200 SYSTEM: CALIBRATION	69**	<p>Evaluate the AFCS 200 Performance.</p> <div style="border: 1px solid black; padding: 2px; text-align: center;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires the machine to be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <p>Run the 12 piece test deck (PSN 7690-17-000-0285) in accordance with MMO-093-19.</p>	12	10		30	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p align="center">NOTE</p> <p>The AFCS 200 & AFCS-OCR Twelve Piece End-to-End Test Deck Set consists of twelve pieces designed to emulate live mail and test end-to-end processing of either mail flowing from an AFCS 200 to DBCS operations or an AFCS-OCR to OSS/Multimode operations. The deck tests AFCS-OCR, functionality including quality of cancellation marks, camera image quality, ID Tag printing, FIM/meter/green phosphor indicia detection, and wrinkling of envelope windows. For the AFCS 200, the same functionality is tested with the addition of Information Based Indicia (IBI) decode and AFCS 200 Postal Intelligent Mail Barcode (PIMb) printing and verify errors. The deck also tests ID Tag reading, PIMb printing, verifying, and reading functionality on DBCS/OSS, CIOSS, and DIOSS and ID Tag and PIMb reading on DBCS equipment.</p>					
VALIDATION 900: SORTCODE IJP AND VERIFIER	70**	<p>Perform an operational Verification of the Sortcode IJP and the Sortcode Verifier.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;"> WARNING </div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <ol style="list-style-type: none"> Obtain 5 blank cards. On the GUI select "Maintenance" and then "Sortcode". Enter the required sortcode information. Start the machine. At the Manual Feeder run the 5 cards one at 	5	10		30	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION													
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE
	0	3	A	F	C	S	2	0	0	A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag			Occurrence eCBM		

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>a time. After each card has been run, validate on the GUI that each card was verified.</p> <p>6. Validate that the cards were sorted to the proper bin.</p> <p>7. Verify the Bar Code location on the mail piece. If not correct write a work order to correct.</p> <p>8. Stop the machine.</p>					
VALIDATION 900: ID-TAG PRINTER AND VERIFIER	71**	<p>Perform an Operational Verification of the ID TAG IJP and the ICS ID TAG Verifier.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <p>1. Obtain 5 blank cards.</p> <p>2. On the GUI select "Maintenance" and then "ID TAG".</p> <p>3. Enter the required information.</p> <p>4. Start the machine.</p> <p>5. At the Manual Feeder run the 5 cards one at a time. After each card has been run, validate on the GUI that each card was verified.</p> <p>6. Validate that the cards were sorted to the proper bin.</p> <p>7. Verify the Bar Code location on the mail piece. If not correct write a work order to correct.</p> <p>8. Stop the machine.</p>	5	10		30	
VALIDATION 900: IJC PRINT QUALITY	72**	<p>Perform an Operational Verification of the Ink Jet Cancellor.</p> <div style="border: 1px solid black; padding: 5px; text-align: center;">WARNING</div>	5	10		30	

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	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceled System 200	Equipment Model						Bulletin Filename mm14072ag				Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>Be cautious when working around or on equipment when power has been applied. This task requires that the machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <ol style="list-style-type: none"> Obtain 5 blank cards. Login to the ACC as user maint. On the ACC GUI menu select "Maintenance, Tests, System tab, and Canceled tests from the drop down". Start the machine. At the Manual Feeder run the 5 cards one at a time. Stop the machine. Locate the cards in the bins and validate that each card contains the following: <ol style="list-style-type: none"> The cancellation mark contains the correct city and state where the facility is located. The cancellation mark contains the facility's correct Sectional Center Facility (SCF) three digit code. The cancellation mark contains the correct date. The cancellation mark contains the correct machine number. The print quality is acceptable in accordance with the IJC Standard Placard (PSN: 7610-08-000-4151). 					
VALIDATION 900: DOUBLES DETECTOR	74**	<p>Perform an Operational Verification of the Doubles Detector.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;"> WARNING </div> <p>Be cautious when working around or on equipment when power has been applied. This task requires that the</p>	5	10		146	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	3	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence eCBM				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>machine be running. Take precautions to prevent hair, clothing, jewelry, tools, and test equipment from being caught in moving parts.</p> <p>Run the 20 piece doubles detector test deck, PSN 3915-07-000-4327. Refer to the latest documentation (currently MMO-062-12) for illustrations and information.</p> <p>Run using Maintenance without Printing Mode.</p>					
CONFIGURATION: STAMP DATABASE	75**	<p>Download and Activate Latest Stamp Database.</p> <ol style="list-style-type: none"> Login to the ACC computer at the Maintenance Level. Verify the machine is not in a run. From the Maintenance Menu. Select ACR. Click on the "Stamp Database" tab. <p>NOTE</p> <p>The filename of the currently active Stamp Database is displayed in the "Active Database" box above the list of available Stamp Databases. Click Download. The file may take a few minutes to download.</p> <ol style="list-style-type: none"> After the download is complete, select the newest file from the list of available Stamp Databases, and click Activate. The file may take a few minutes to activate. If the new file doesn't appear in the list after the download, click on the "Stamp Database" tab again to refresh the page, select the new file from the list, and click Activate. Verify the "Active Database" box displays the filename of the new Stamp Database. 	5	10			W
SYSTEM: IJC	75.5	<p>Verify Cancellation and Franking Marks are loaded to the IJC.</p> <p>ACC/ACR Software and ACP Software</p> <p>NOTE: The next steps assume that the ACP is</p>	10	10		30	

U.S. Postal Service Maintenance Checklist	IDENTIFICATION															
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE		
	0	3	A	F	C	S	2	0	0		A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model								Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>connected to a working, initialized IJC.</p> <ol style="list-style-type: none"> Press Ctrl key twice followed by the 2 key to navigate to the ACP computer. Log into the ACP GUI as an admin user. In the ACP web GUI, click IJC in the accordion menu on the left and then click Job Management. Click Review Jobs tab. If the Review Jobs tab is not displayed and "Please wait" appears, a reboot may be required. Verify the machine specific cancel mark used for mailpiece cancelling (e.g. the standard cancel mark with the six wavy lines or a similar cancellation artwork) is loaded. The cancellation mark display should show Yes under the "Loaded in IJC" column and 1 for the job number. Verify the machine specific left-justified cancel mark (with no artwork) used for cancelling mailpieces that do not have stamp and/or a meter mark indicia is loaded. The cancellation mark display should show Yes under the "Loaded in IJC" column and 2 for the job number. <p>If either the Cancellation mark or Franking mark is not loaded, reload the mark (Consult the latest ACP SMO on the MTSC website).</p>					
FINAL-CLEANUP	76	<p>Clean up.</p> <ol style="list-style-type: none"> Ensure all tools, lubricant, rags, etc., are removed from the work area. Ensure all equipment panels and covers are in place. Update tasks completed in eCBM section of the eMARS server and follow local procedures to submit completions. Report all deficiencies to supervisor and generate necessary work orders per local standard operating procedures, to document 	10	09			

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	3	A	F	C	S	2	0	0		A	A	0	0	1
Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag				Occurrence eCBM			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.
		and initiate corrective maintenance activity. Annotate deficiencies found and repairs made in the equipment logbook.					

* --- the tasks marked with an asterisk are per unit tasks.

** --- the tasks marked with two asterisk are critical tasks.

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ATTACHMENT 3

AFCS200 MASTER CHECKLIST

09-AFCS200-AA-001-M

Operational Maintenance

Time Total: See Attachment 1.

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM							CLASS CODE		NUMBER			TYPE
	0	9	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag			Occurrence TOURLY			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

SAFETY STATEMENT	1	<p>COMPLY WITH ALL SAFETY PRECAUTIONS. Disconnect power and apply lockouts when required by this instruction. Refer to current local lockout procedures to properly shut down and lock out this machine. Open equipment and inspect dust conditions. Check for suspicious dust or unusual debris. If any unusual substance is found notify supervisor prior to proceeding with any further action on the equipment.</p> <p>THE USE OF COMPRESSED OR BLOWN AIR IS PROHIBITED. When cleaning is required, an alternative cleaning method such as a HEPA filtered vacuum cleaner or a damp rag must be used in place of compressed or blown air. A lint-free cloth or brush may be used on optical equipment only when other cleaning methods cannot be used. Report safety deficiencies to your supervisor immediately upon detection.</p> <p>WARNING FOR EWP/PPE: Steps contained in this bulletin may require the use of Electrical Work Plan (EWP) Personal Protective Equipment (PPE). Refer to the current EWP MMO for appropriate EWP PPE and barricade requirements.</p> <p>NOTE: Operational checks must be made with machine processing mail in a normal operating mode.</p>	1	All			
OPERATIONAL: ELECTRONIC/HARDCOPY LOG BOOK	2	<p>Read Electronic / Hardcopy Log book at Beginning of the Operational Tour.</p> <p>Check Electronic / Hardcopy Log book for unresolved or suspected problem entries from previous tour. Bring forward any unresolved problems.</p>	1	09			T
OPERATIONAL: SDO	3	<p>Check with Operational Supervisors at Beginning of Tour and Every Hour After.</p> <p>Verify that the mail processing personnel are not experiencing significant problems operating the AFCS. Verify that mail processing personnel are not having frequent jams, phantom stops, or any other problems which affect system performance.</p>	1	09			T
OPERATIONAL:	4	Observe the Machine on Start Up at Beginning	1	09			T

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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Equipment Nomenclature Advanced Facer Canceler System 200	Equipment Model							Bulletin Filename mm14072ag			Occurrence TOURLY				

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

WARNING LAMPS AND INDICATORS		of the Operational Tour. <ol style="list-style-type: none"> The lamps should be seen and the horns heard in vicinity of the machine after either START CULLER or START FACER/CANCELLER pushbuttons have been pressed. Horns and lamps should not be covered to muffle sound or inhibit illumination. Ensure that an intermittent horn on fine cull and over-thick modules sound for approximately 5 seconds after Start pushbutton is pressed before machine starts. Ensure flashing beacon lamps on crossover and over-thick modules flash continuously from the time either Start pushbutton is pressed until the machine starts. 					
OPERATIONAL: MACHINE OPERATION	5	Observe Machine Operation. <ol style="list-style-type: none"> Determine the source of any strange or unusual noises or odors. Check any abnormalities found and notify supervisor before taking corrective action. Determine if machine requires immediate corrective action or write a work order for action to occur after Operations has completed processing. 	5	09			T
OPERATIONAL: REPORT ANALYSIS	6	Analyze the Run Statistics (Every 2 Hours). <p>NOTE</p> <p>Prior to performing the power down and lock out do an AFCS 200 performance analysis.</p> <p>NOTE</p> <p>Reference At-Risk bulletin MMO-115-13 for possible causes and solutions.</p> <ol style="list-style-type: none"> Access run statistics from the previous runs on the GUI Report Display and/or MPE Watch, analyze for any anomalies that may indicate degradation of machine performance. Be alert for abnormal data concerning: <ol style="list-style-type: none"> Pieces Fed (acceptable/target throughput 	1	10			T

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Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		<p>per hour is 28,300 pieces)</p> <p>b. Pieces Sorted</p> <p>c. Mechanical Rejects</p> <p>d. Bypass Pieces (Bypass count includes conditions other than the current At-Risk elements, such as No Indicia.)</p> <p>e. Over Lengths</p> <p>f. Jams</p> <p>g. Machine Stops and Faults</p> <p>h. SBU 1 and 2 Rejects</p> <p>i. Total Abnormal Stops</p> <p>j. Unfaced%</p> <p>3. Check the Electronic / Hardcopy Log book for any unresolved issues.</p> <p>4. Refer to current At-Risk bulletin or web dashboard for comparative scores.</p> <p>5. Inform supervisor if numbers are out of defined range. Reference the At Risk bulletin for nationally derived goals and percentages, which change on a quarterly basis.</p>					
OPERATIONAL: SINGULATOR FEEDER	7	<p>Check BDS Singulator Feeder Operation (Every Two Hours).</p> <p>NOTE</p> <p>Ensure Mail Preparation is being done prior to mail entering the AFCS 200. Debris/Unwanted material will cause machine performance issues.</p> <p>1. Observe feeder for proper operation.</p> <p>2. Mail flow should be smooth and constant. High jams in edger feeder, BDS, or Auto-Feeder may indicate a misadjustment from the Hopper through the proportional sensor and shoes.</p> <p>3. Be aware of foreign matter accumulation.</p> <p>4. Look for slick belts, bent feeder fence fingers, and glazed stripper flap.</p>	1	09			T
OPERATIONAL:	8	Check Auto-Feeder Operation (Every Two	1	09			T

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	0	9	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag			Occurrence TOURLY			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

AUTOFEEDER		Hours). 1. Observe feeder for proper operation. 2. Mail flow should be smooth and constant. 3. Be aware of foreign matter accumulation. 4. Constant jams in one certain area may indicate a misadjustment.					
OPERATIONAL: MANUAL FEEDER	9	Check Manual Feeder if in use (Every Two Hours). 1. Observe feeder for proper operation. Feed should be smooth and constant. Be observant of foreign matter accumulation.	1	09			T
OPERATIONAL: SORT AND MAIL QUALITY	10	Check the Stacker Section for Sort, Cancellation Mark, ID Tag, and IMb Bar-Code Quality (Every Two Hours). Check the sort stackers for proper mail placement and stack quality. 1. Obtain a quantity of mail pieces from each stacker, one sort stacker at a time and check the mail pieces for: a. Validity of mail piece placement corresponding to the mail category assigned to that stacker by sort scheme. b. Acceptable Cancellation Mark. If the cancel mark is not in accordance with CANCELLATION STANDARDS placard (PSN 7610-08-000-4151, PSIN 030088) do the following: 1) Check ink bottles if empty - replace. 2) If needed, purge the print heads. c. Acceptable ID Tag. Ensure the ID Tag is printed clear and verifiable. d. Acceptable Post-Net. Ensure the IMB bar code is printed within IMb specifications. e. Return mail pieces to sort stacker. 2. Validate that the mail in the end stacker pocket contains only mail, which meets the criteria for being rejected. Reference At Risk	4	09			T

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
	WORK CODE		EQUIPMENT ACRONYM						CLASS CODE		NUMBER			TYPE	
	0	9	A	F	C	S	2	0	0	A	A	0	0	1	M
Equipment Nomenclature Advanced Facer Canceler System 200			Equipment Model						Bulletin Filename mm14072ag			Occurrence TOURLY			

Part or Component	Item No	Task Statement and Instruction (Comply with all current safety precautions)	Est. Time Req (min)	Min. Skill Lev	Thresholds		
					Run Hours	Pieces Fed (000)	Freq.

		bulletin for details on reject criteria.					
OPERATIONAL: DETECTION UNITS	11	Check Camera Faceplates and/or Areas Associated with the Detection Devices on the AFCS 200 System. Ensure the camera faceplates and/or areas on the following units are clear of debris and any foreign matter that would cause degradation in quality of operations. 1. Doubles Detector lens 2. ID-Tag Verifier and reflector 3. Sortcode Verifier 4. ACR Cameras 5. Luminescent Detector 6. IJC	5	09			T
AFCS-200 SYSTEM: MAIL SEARCH	12	Perform Mail Search. NOTE At the end of the tour, perform a mail search. NOTE Ensure proper operation of door shocks. If any cover fails to remain open, write work order to correct. 1. Open all necessary panels and doors along mail travel path for a thorough mail search. 2. Remove any additional panels to access the lower belts in each section. 3. Starting at the Incline Hopper, perform mail search. 4. While performing mail search, remove any large pieces of dirt and debris. 5. Place all recovered mail in a tray. 6. Follow local procedures for returning mail to operations for processing.	5	All			T
OPERATIONAL: COMPILE RUN INFORMATION	13	At the End of the Operation, Compile the Following Information:	10	10			T

U.S. Postal Service Maintenance Checklist	IDENTIFICATION														
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	0	9	A	F	C	S	2	0	0	A	A	0	0	1	M
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					Run Hours	Pieces Fed (000)	Freq.

		<ol style="list-style-type: none"> Interim reports taken during the operational run with any abnormalities noted and/or highlighted. Route sheet information. Any work orders generated. Make entries in machine electronic logbook of any discrepancies found during the mail run or pertinent information that would be relevant to the next tour. Update and complete any eCBM entries. Turn in this information to maintenance supervision and brief the maintenance personnel coming on duty. 					
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