

**SP50-15**

**S E R V I C E N O T E**

Supersedes:  
None

**Agilent Medalist  
SP Series II XL**

**Serial Numbers: SG40305015 to SG40305029, SG50300000 to SG50300012 and SG47740001 / SG47740002**

**Modification recommended for controlling clamping downstroke of SP XL for systems manufactured since 12 September 2005.**

**To Be Performed By: Agilent-Qualified Personnel or Customer**

**Parts Required:**

P/N	Description	Qty.
5186-2299	Pneumatic Elbow with Flow Control	6

**ADMINISTRATIVE INFORMATION**

SERVICE NOTE CLASSIFICATION:			
<b>MODIFICATION RECOMMENDED</b>			
ACTION CATEGORY:	<input type="checkbox"/> IMMEDIATELY <input type="checkbox"/> ON SPECIFIED FAILURE <input checked="" type="checkbox"/> AGREEABLE TIME	STANDARDS:	LABOR: 2.0 Hours
LOCATION CATEGORY:	<input checked="" type="checkbox"/> CUSTOMER INSTALLABLE <input type="checkbox"/> ON-SITE <input type="checkbox"/> SERVICE CENTER	SERVICE INVENTORY:	<input type="checkbox"/> RETURN <input type="checkbox"/> SCRAP <input checked="" type="checkbox"/> SEE TEXT
AVAILABILITY:	PRODUCT'S SUPPORT LIFE	USED PARTS:	<input type="checkbox"/> RETURN <input type="checkbox"/> SCRAP <input checked="" type="checkbox"/> SEE TEXT
NO CHARGE AVAILABLE UNTIL: Oct 2008			
AUTHOR: BW      PRODUCT LINE: PL80			
ADDITIONAL INFORMATION: The 5186-2299 is orderable through SPD (Service Parts Delivery) at 1-800-816-8650.			
Reference the service note number in the activity description field of the SR (Service Request).			

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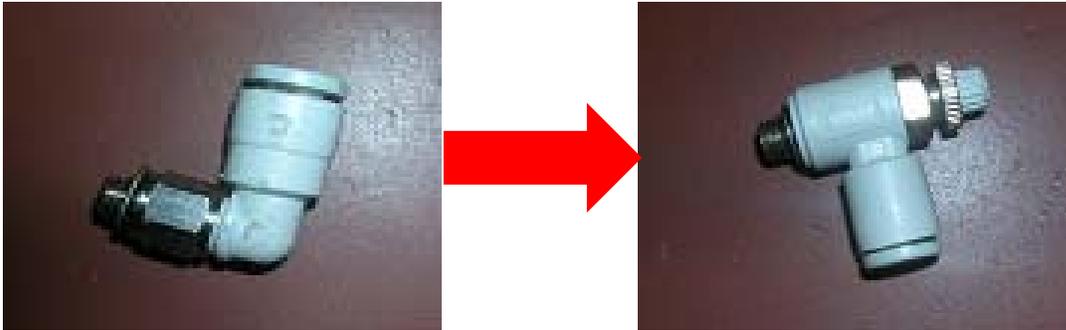
October 16, 2007

**Situation:**

All XL conveyors shipped after 12 Sept 2005 have been shipped without Air restrictor on the exhaust valve for the board clamps. This would typically not be an issue for SP systems. However if the SP XL is ever converted to a SJ XL for Pre reflow inspection, the down stroke of the clamps cannot be controlled which for Pre Reflow inspection systems could potentially result in components being knocked of pad. In total there are 2 SP systems shipped without the restrictor.

**Solution/Action:**

Replace the existing exhaust “Pneumatic elbow” with a “Pneumatic elbow with air restrictor”

**Tools Required:**

Allen key set (Metric) - 3mm

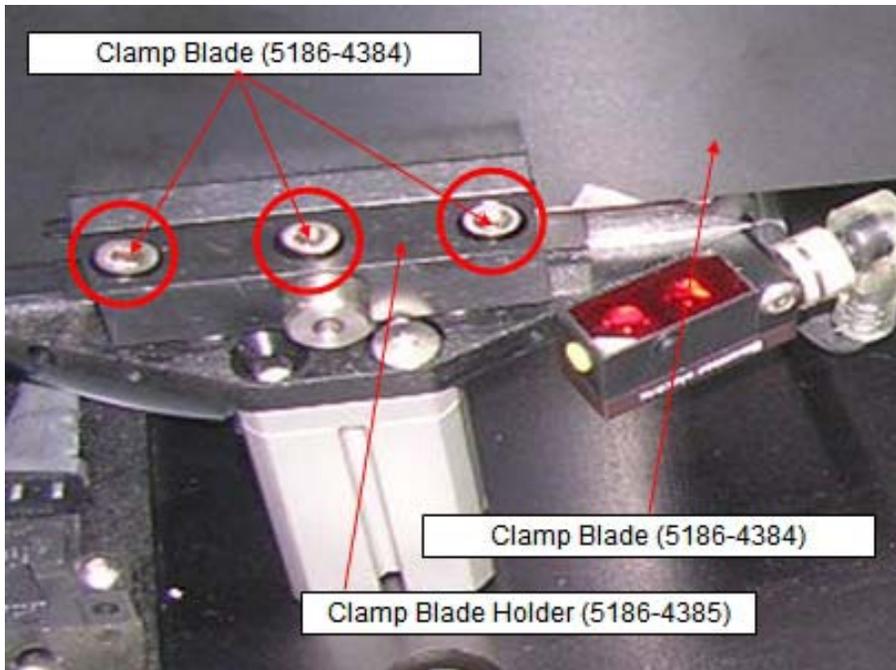
Spanner (Metric) - 8mm

**Procedure:****Step 1.**

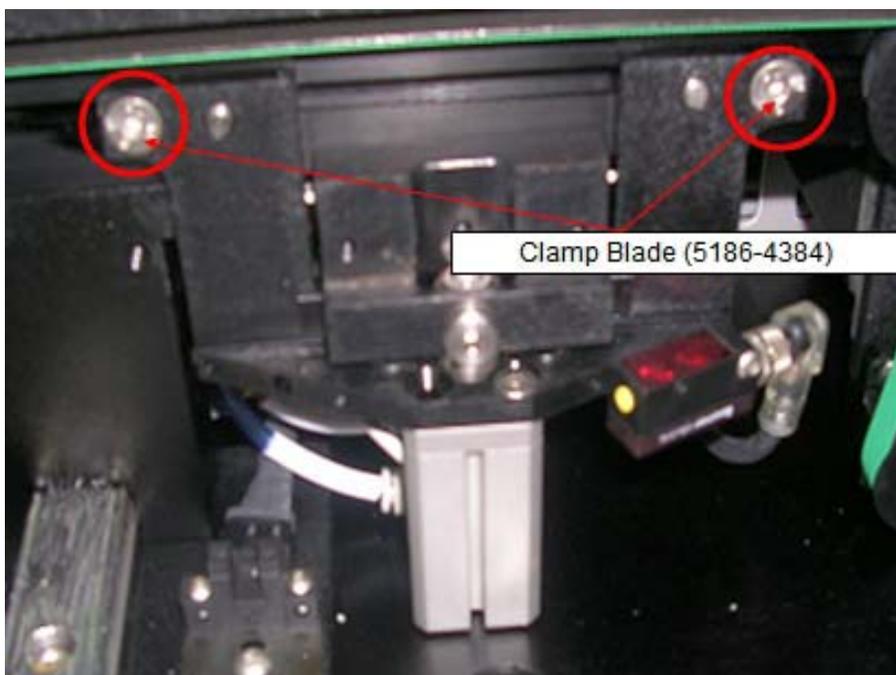
Unscrew M4 x 10 SHC x 3pcs using Allen Key (Metric, 3mm).

Remove Clamp Blade Holder (5186-4385) x 1pc

Remove Clamp Blade (5186-4384) x 1pc

**Step 2.**

Unscrew M5 x 12 countersunk x 2pcs using Allen Key (Metric, 3mm)

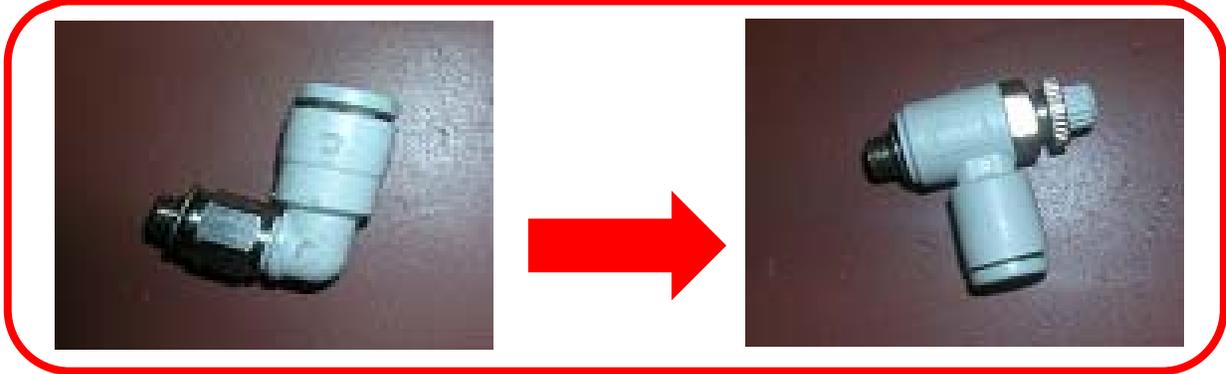
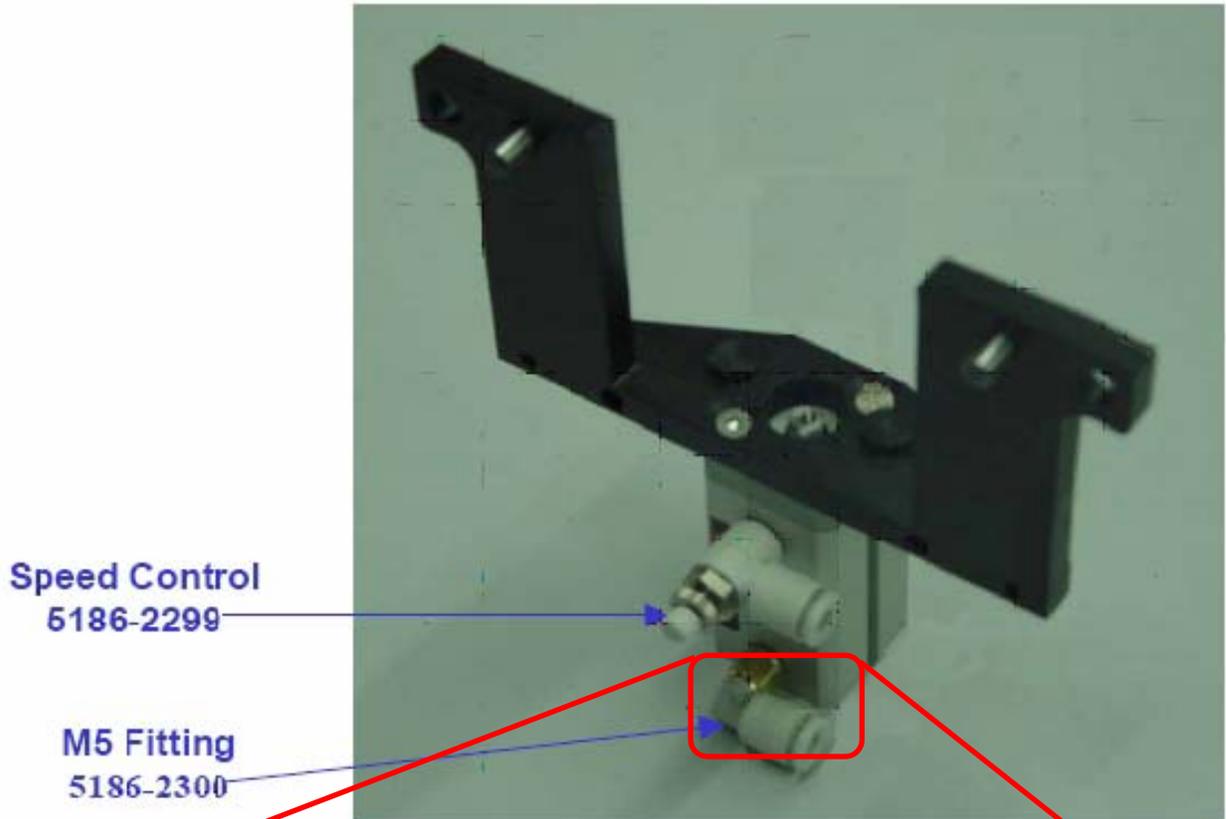


**Step 3.**

Remove Pneumatic Elbow (5186-2300) using Spanner (Metric, 8mm)

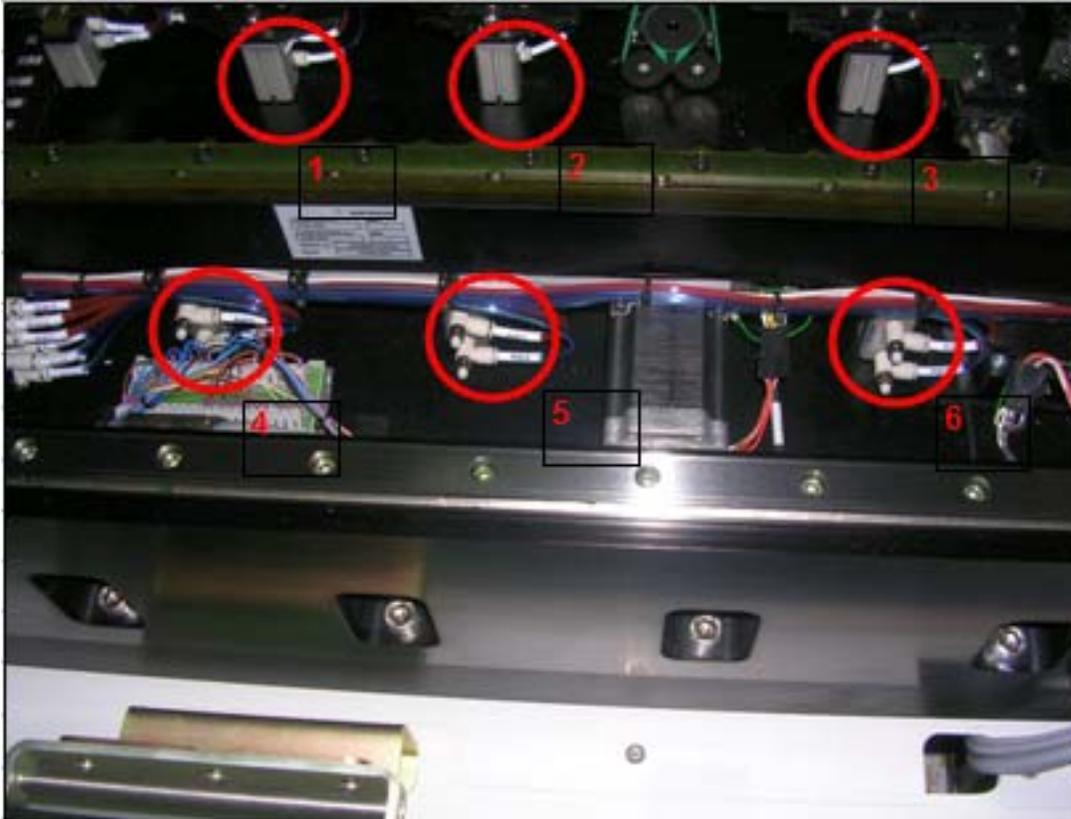
Assemble Pneumatic Elbow with flow control (5186-2299) using Spanner (Metric, 8mm)

The re-assembly steps are just the reverse of the removal steps.



**Step 4.**

Repeat the above steps with the other five(5) locations as depicted in the picture

**Step 5.**

Adjust air restrictor so downstroke of clamps is dampened sufficiently so as not to disturb Pre reflow components.

**Procedure Complete.**