

 PRISMATIK DENTALCRAFT, INC.	<h1>SERVICE</h1>	REV ID: 13793
		DOC ID: 11822
		Effective Date:
		Revision: 1.0
TS150e Field Replacement Kit – Door		

1.0 PURPOSE

This procedure provides TS150e external and internal technicians with instructions on how to replace a TS150e door with the TS150e door assembly kit.

2.0 SCOPE

These instructions will only be used for replacing a TS150e door in the field.

3.0 APPLICABILITY

This procedure applies to external and internal TS150e technicians who will be replacing a TS150e door in the field.

4.0 SUMMARY OF CHANGES / JUSTIFICATIONS OF CHANGES SINCE LAST REVISION

REVISION STATUS		
Rev.	Effective Date	Description of Change(s) & Justification of Change(s)
1.0		Initial document.

5.0 DEFINITIONS

MCP – Mill Control Panel, Windows software used to interact with and control the Mill.

6.0 REFERENCES

N/A

7.0 RESPONSIBILITIES

- 7.1 Prismatic manufacturing is responsible for the content of this document.
- 7.2 Prismatic Inc. is not responsible for the execution or outcomes of this document when used by external TS150e technicians.

8.0 MATERIAL/EQUIPMENT

- 8.1 Door (PN 01496-05)
- 8.2 Rail, Left (PN 01497-03)
- 8.3 Rail, Right (PN 01497-02)
- 8.4 Washers, Qty 4 (PN 41071-01)
- 8.5 Wiper (PN 01556-01)
- 8.6 Thread-Locker, Vibra-tite 325, 2ml Bullet Tube (PN 41152-01)
- 8.7 Super Glue, Vibra-tite 301, 2ml Bullet Tube (PN 41161-01)
- 8.8 Screw (PN 41119-01)
- 8.9 Spacer (PN 41035-01)
- 8.10 T-9 Torx driver



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- 8.11 Hex Allen Wrench, 2mm
- 8.12 Hex Allen Wrench, 2.5mm
- 8.13 Adjustable Wrench, small

8.14 DOOR REPLACEMENT REQUIREMENTS

8.14.1 Internet access will be required in order to view the installation service video.

8.14.2 Removal and reinstallation of the following will be required:

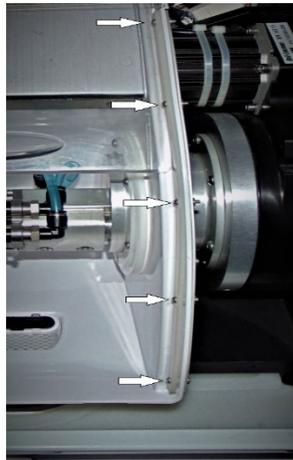
- Front Housing
- Door
- Rails
- Wiper
- Door Switch Screw

9.0 PROCESS MAP/FLOW CHARTS

N/A

10.0 PROCEDURE

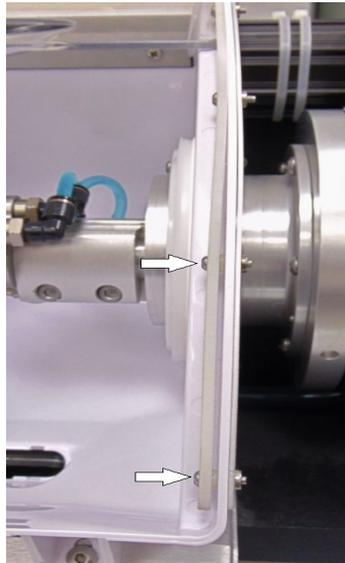
- 10.1 Power down mill, remove the front housing of the mill. (A video showing how to remove the front housing is available on our website at www.ios3d.com/resources Username = *ios*, Password = *ts150*. Please note all lower case.)
- 10.2 Unscrew the 5 screws that hold the right rail to the nut plate. Remove the rail assembly. Slide the door to the right and remove the door. Remove the 3 screws that hold the door wiper and replace with the new wiper in the kit. Reinstall the screws, but leave loose for final adjustment. Install the new door by sliding the door under the door switch and left side rail. Install the new right side rail, PN 01497-02



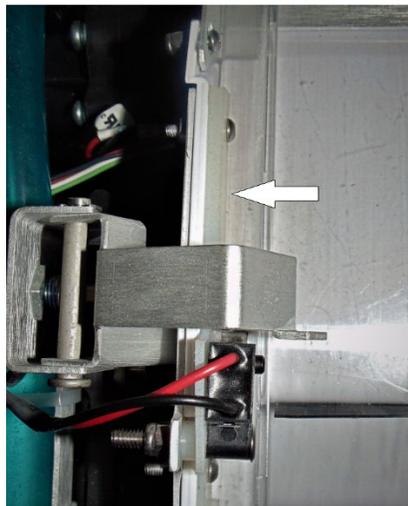


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- 10.3 Put VIBRATITE 325 on the screw threads. Reinstall the top 3 screws loosely. On the bottom 2 screws, insert a washer between the new rail and the inside of the basin. Attach screws but leave loose.



- 10.4 Remove the 5 rail screws and the screw that holds the door switch in position. Replace the rail with the new left rail, PN 01497-03. Put Vibra-tite 325 on the 5 screw's threads. Reinstall the top 3 screws, leave loose.



- 10.5 Reinstall the door switch using the new screw and spacer supplied. Ensure the tab of the door switch is not touching the door, or adjust the switch. Tighten the screw until the switch body doesn't move, then tighten a ¼ turn more.



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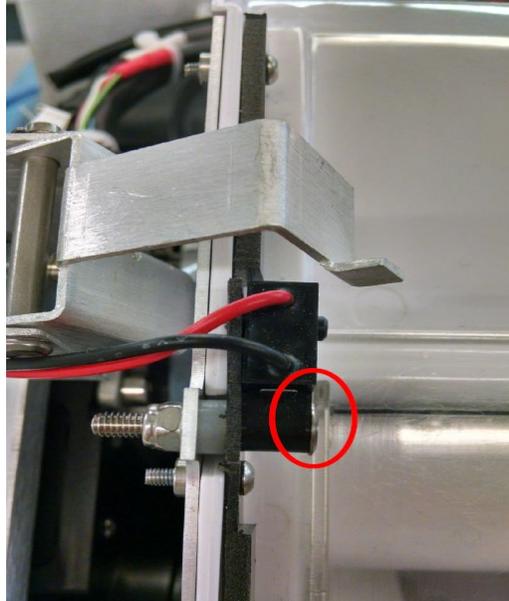
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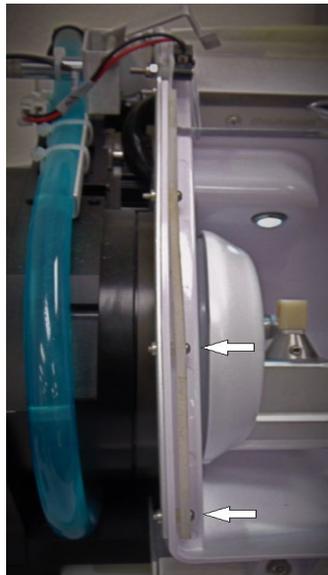
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- 10.6 Reinstall the bottom 2 screws, adding the washers between the new rail and the basin. Lightly tighten all the rail screws. Check for smooth movement of the door. When satisfied with the way it slides, tighten the screws.



- 10.7 Open the door enough so that you can adjust the new door wiper. Push on the bottom of the wiper at the center screw location so that it is lightly touching the door evenly across. Tighten the center screw and then tighten the other two screws. Open and close the door to check that the wiper is lightly wiping the full width of the door.



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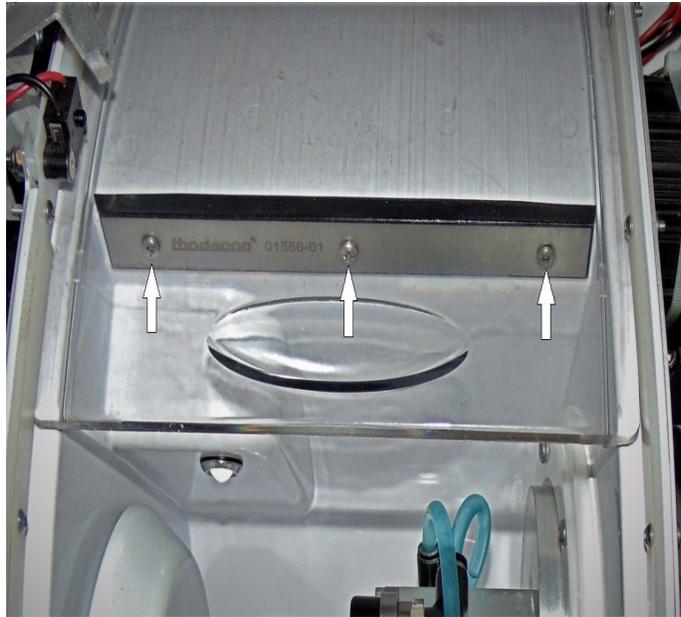
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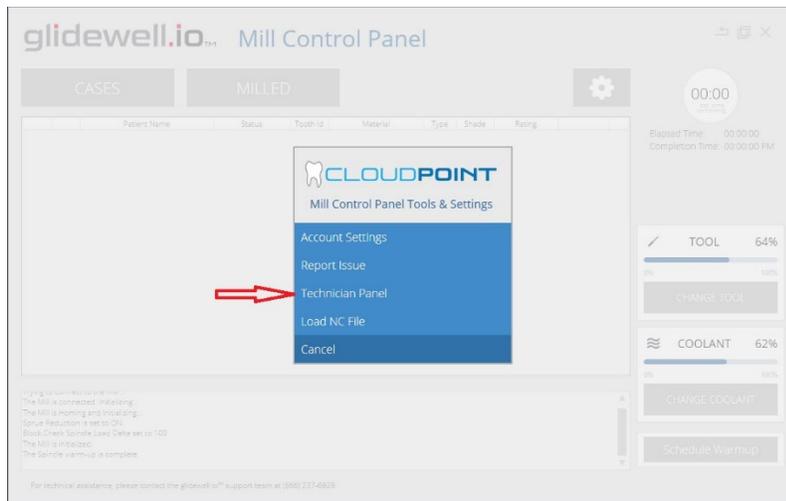
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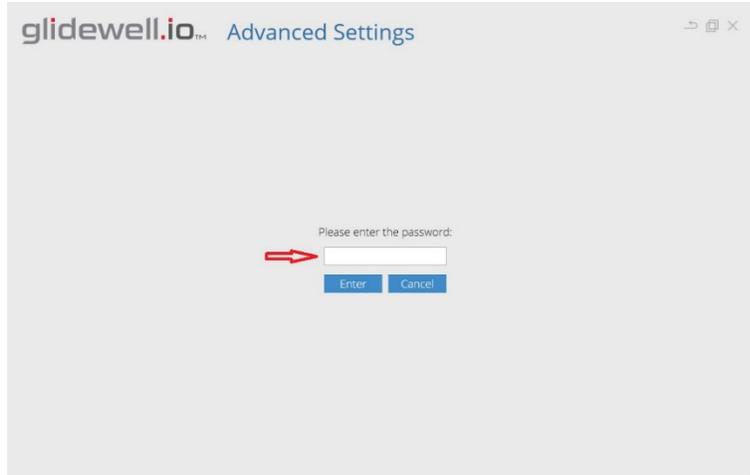
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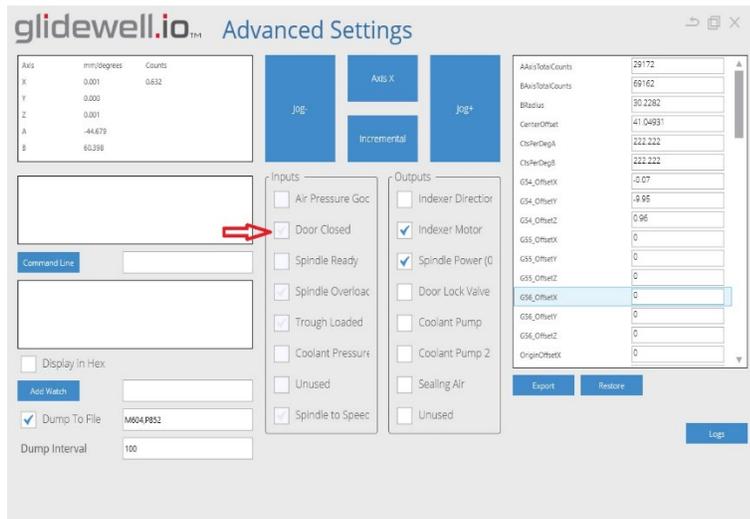
- 10.8 Before putting the front cover back on, it is best to test the door switch operation. Plug in and turn on the TS150e mill.



- 10.9 Go to settings and Log into Technician Panel, **password=1234**.



10.10 Advanced settings you will see a box of Inputs. The second box is the door switch. With the mill door closed, the box should have a check mark for TS150e.



10.11 When the door is open the box will be unchecked.



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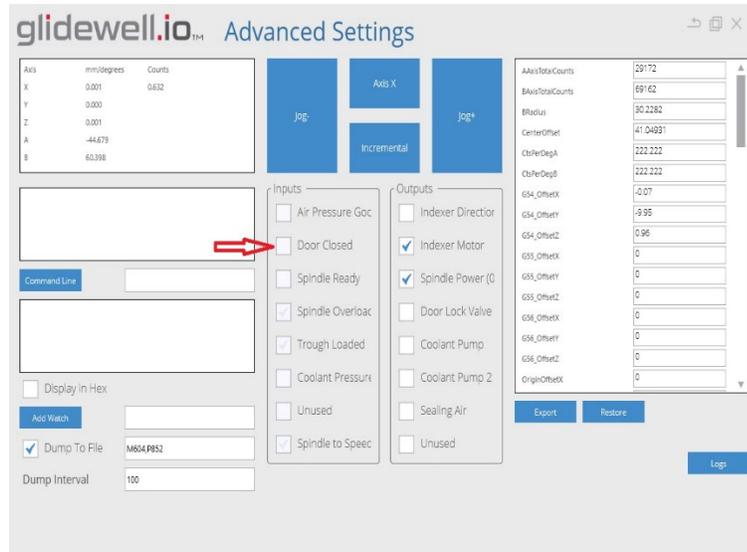
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10.12 If the door is closed and the box is not checked, loosen the screw holding the switch and move it up a bit until the box is checked. Tighten it down and verify that the box is unchecked when the door is open. When satisfied with the switch operation, make sure the screws are tight and power off the mill. Reinstall the front cover.

11.0 REQUIRED PROPERTIES

- 11.1 New door, door wiper, and left and right wipers were installed.
- 11.2 When the door is open, the door-closed checkbox remains unchecked on the MCP.
- 11.3 After the door replacement and switch check, the screws were tightened.

12.0 DOCUMENTATION

N/A

END OF DOCUMENT