



CRANE NATIONAL VENDORS

FACTORY ASSEMBLY PROCEDURES
SHOPPERTRON - MAIN DOOR ASSEMBLY

PURPOSE: The purpose of this qualification test is to insure the thermal integrity of the Shoppertron main door assembly.

ASSEMBLY

AFFECTED: Shoppertron domestic and foreign machine std door parts p/n 4312000 and 4312120.

USAGE: This procedure is used to fill out the Shoppertron Main Door Assembly Checksheet, part number 4310100.

REVISION DATE: C, AUGUST 25, 1998	
ISSUED BY: John P. Huffman <i>J.P. Huffman</i>	DATE ISSUED: <i>08/25/98</i>
DESIGN ENGINEERING - ELECTRICAL APPROVED BY: <i>N/A</i>	DATE APPROVED: <i>-</i>
DESIGN ENGINEERING - MECHANICAL APPROVED BY: <i>[Signature]</i>	DATE APPROVED: <i>08/25/98</i>
QUALITY ASSURANCE APPROVED BY: <i>[Signature]</i>	DATE APPROVED: <i>8-25-98</i>
MANUFACTURING ENGINEERING APPROVED BY: <i>[Signature]</i>	DATE APPROVED: <i>8/26/98</i>

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1. Assemble subassemblies and main door assembly in accordance with drawings and BOM structure. Specific work instructions for some part installations follow below.
 2. Seal all corners of welded door assembly on interior side, with clear silicone sealant. Sealant should be applied to entire length of overlapping sheet metal seams and smoothed out with a putty knife or similar tool. Apply a 33.5" length of aluminum tape p/n 4302210 to the horizontal seam in the bottom cavity of the door.
 3. Install foam insulation part insulation-door-left, p/n 4302098.
 4. Install the bracket and screen assembly p/n 4302139 onto the duct and caps assembly p/n 4302200. Install a 46" length of gasket p/n 4302214 across the duct above the last hole, down along the duct length (to face the external side of the door) and back across the duct below the last hole on the bottom. This gasket will provide sealing between the black duct cover and duct. Install a 50" length of foam tape p/n 4729000 along the duct length (to face the internal side of the door), by removing the green adhesive cover on one side and installing down the duct length. The green adhesive cover on the outer side of the foam tape should remain in place. Install the finished assembly (duct and caps with bracket and screen, gasket, and foam tape) into the door frame. Seal liberally along the duct length with adjacent parts with clear silicone sealant. Also seal at the ends of the duct assembly liberally with clear silicone sealant.
 5. Install foam insulation part insulation-door-bottom p/n 4312025 at top and bottom of door.
 6. Install foam insulation parts: insulation-door-top p/n 4302095, insulation-door-right p/n 4302097, and insulation-door-front p/n 4302150
 7. Install spacers p/n 9989649 into door through all foam insulation parts. Spacers must be soaked in in water for several hours prior to installation.
 8. Install liner-door-bottom p/n 4302029, liner-door-top p/n 4302028, liner-door-right p/n 4302030, and liner-door-left 4312208 (for black door p/n's 4302385, 4302384, 4302386, and 4312209). Seal seams between adjacent liner parts with clear silicone sealant.
 9. Install the extruded P-shaped door gasket p/n 4312207.
 10. Install retainer-door-top p/n 4302076, and retainer-door-bottom p/n 4302077.
 11. Install the duct cover p/n 4302142 and mech support angle 4302222.
 12. Install door center post p/n 4302236, center post angle p/n 4302034, center post support p/n 4302036, and center post stiffener p/n 4302136 (for black door p/n 4302391).
 13. Install the left door trim p/n 4302119, and top and bottom glass retainers p/n 4312082 and 4312084 (for black door 4312083 and 4312085).
 14. Install grommet strip p/n 1271081 on the top and bottom glass retainers. Install approximately 2 inches of black butyl sealing tape p/n 4312125, at the ends of the retainers on the interior side, to fill voids and gaps with mating parts.
 15. Install approximately 6 inches of black butyl sealing tape p/n 4312125 at the top of the center door post, filling in the gap between adjacent parts. Repeat this at the bottom of the post, where price display harness comes through, filling in the penetration.
 16. Install the PC board cover assembly p/n 4302129. While installing, visually check that the butyl sealing tape remains in place and seals the penetration around the harness. Add additional butyl sealing tape if required to maintain the seal.
 17. Install the validator housing (monetary cover) with gasketing, p/n 4302032.
 18. Install the monetary harnesses and trim components.
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19. Install the glass spacer p/n 4312123 on the bottom glass retainer and caulk in place with clear silicone sealant. Install a 7.5" piece of grey vinyl covered gasket p/n 3122154 along the length of the spacer.
 20. Install a 48" piece of grey vinyl covered gasket p/n 3122154 along the right hand side of the window glass frame/opening. Install a 48" piece of foam tape p/n 4729000 along the left hand side of the window glass frame/opening, with the green tape on the outer surface remaining in place.
 21. Install the door glass gasket p/n 4312081 onto the insulated glass assembly p/n 4312080. Wet the outer surface of the gasket lightly with water and install the glass with gasket into the frame/opening.
 22. Install 21" of .5 inch insulation rod p/n 4241148 at the top of the window and seal in place liberally with clear silicone sealant. Install the glass angle p/n 4312082 (for black door p/n 4312083) at the top of the glass assembly. Seal along the top and left side of the glass gasket also, and install the glass angle p/n 4312082 (for black door p/n 4312083) at the bottom of the glass assembly.
 23. Install the light bracket, sockets, covers, etc. for the light assembly left side.
 24. Install approximately 11" of foam gasket p/n 4311211 on the interior surface of the top and bottom door retainers p/n 4302076 and 4302077. Install the top and bottom door retainers onto the door, leaving the screws loose.
 25. Locate the cavity below the top door liner, between the duct and center post. Seal this area liberally with black silicone sealant. Next, install a 22" long piece of .5 inch insulation rod, p/n 4241148. Caulk the insulation rod in place liberally, with clear silicone sealant and install the top insulation retainer p/n 4302081 (for black door 4302388). Locate the cavity above the bottom door liner between the duct and center post. Seal this area liberally with black silicone sealant. Install the insulation-door-filler p/n 4302099 in this location. Caulk the insulation-door-filler in place liberally with clear silicone sealant and install the bottom insulation retainer p/n 4302082 (for black door 4302389).
 26. Install the top and bottom vend door guides p/n 4302269 and position properly with respect to retainers and tighten screws for door guides. Next tighten all screws for insulation and door retainers.
 27. Install remaining vend door guides p/n 4302269 leaving screws loose, and position vend doors p/n 4302372 into guides. Next tighten all screws for door guides, making sure all doors can slide freely.
 28. Install the door mech assembly p/n 4312064.
 29. Seal the light harness penetration through the door with clear silicone caulk. Also seal the monetary harness penetration through the door liner with clear silicone caulk, on the door internal and external sides.
 30. Complete remaining door assembly.