

# CRANE MERCHANDISING SYSTEMS FACTORY INSPECTION RECORD

Part No. 4551310  
Sheet 1 of 3

<b>ACCEPTED</b>	<b>REJECTED</b>	CHANGER NO. & MODEL ..... VALIDATOR NO. & MODEL ..... CARD READER NO. & MODEL ..... CUSTOMER ..... ADDRESS .....	MODEL ..... SERIAL NO. .... COMPRESSOR SERIAL NO ..... SOFTWARE VERSION NO. .... INSPECTION DATE: .....
↓	↓	<b>TEST AND INSPECTION TO BE IN ACCORDANCE WITH:</b>	
		Factory Test Procedure 4551170	
<b>SAFETY INSPECTION</b>			
		1	Wire harness routing and dressing. Harness dressed away from sharp edges and pinch points where monetary and outer door are opened and closed.
		2	Ground leads connected securely - 3 spots.
		3	Ground continuity test - see instruction sheet.
		4	Dielectric breakdown (HI POT) - see instruction sheet.
		5	Refrigeration switch operates correctly.
		6	Safety covers and guards in place.
		7	Metal components free of burrs and sharp edges (Cabinet, door, delivery pan).
<b>ELECTRICAL/MECHANICAL COMPONENT FUNCTION</b>			
		1	Electrical test for glass heater performed and passed at door table prior to assembly of door.
		2	Final production test complete, and HCF test data is recorded.
		3	Serial and control numbers on inspection sheet agrees with work ticket and serial plate.
		4	Work ticket affixed to cabinet and door.
		5	Unit tested with coin mech used by customer (when required) - or - with coin mech specified by engineering department.
		6	Correct configuration setting for machine - (language of destination)
		7	Cabinet appearance - exterior and interior.
		8	Display panels clean and mounted squarely in monetary door.
		9	All visible electrical connections securely in place (clamps and dressed harnesses).
		10	Delivery door operates properly and freely.
		11	Fluorescent lamp operates.
		12	Is the correct software installed, record the version # in the proper location above.
		13	Monetary door fits properly to cabinet and locks.
		14	Check seal on retractable vend door to verify that all sealing ribs of gasket are in contact with seal surface.
		15	Refrigeration runs smoothly without vibration or noise.
		16	Condenser fan motor operates.
		17	Evaporator fan motor operates.
		18	Main door opens/closes smoothly, Over-center latches adjusted properly and locknuts tightened.
		19	Main door is square to the foamed cabinet.
		20	Main door gasket compression must be adjusted such that a piece of paper is held securely when it is trapped between the gasket and the sealing surface on the cabinet. This condition is to exist on all four sides. Main door gasket is to be free of flash and or holes on mitered and welded corners. Both small rectangular sealing pads must be installed just below the main door gasket such that they seal the ends of the retractable door gasket when the main door is closed. Apply a small amount of SFL-1 , (white) low temperature food grade grease approximately 6 inches from each corner. Close the door, latch it, open it, now look at the impression made by the gasket and adjust accordingly. Wipe off grease after all adjustments are made. This task is to be done at the station on the assembly line when the main door is installed on the vending machine.
		21	Monetary door switch works.
		22	Remove the bottom tray. All wiring harnesses for retractable door are to be gathered neatly and secured with a wire tie. Retractable door automatically opens/closes smoothly without hesitation and there is at least 1 nylon washer on each of the sliding pins. The plastic slide tracks are to be lubricated with SFL-1 , (white) low temperature food grade grease.
		23	Retractable door drive link is perpendicular to the retractable door and the drive disk is in "home" position when the retractable door is closed.
		24	Retractable door opens/closes properly and all wiring harnesses are dressed properly.
		25	Selection buttons and coin pass through slots work properly.
		26	Both wire pass-through holes in the cabinet and the wire pass-through holes in the main door assembly must be filled and sealed with permagum.
		27	The access holes for the top hinge are to be completely filled with insulation plugs
		28	GFI Circuit Breaker on the main door assembly must be tested and reset to operating condition.

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ACCEPTED	REJECTED		
		<b>TEST AND INSPECTION TO BE IN ACCORDANCE WITH:</b>	Factory Test Procedure 4551170.
		<b>FACTORY SETTING</b>	
		1 Spirals properly oriented and in home position.	
		2 Hinge nuts and bolts are tight.	
		3 Correct tray configuration.	
		4 Correct spirals in trays and correct color identifications in place.	
		5 Trays move freely in and out.	
		<b>LUBRICATION</b>	
		1 Lift handle lock bar assembly.	
		2 Vend door arms.	
		3 Retractable vend door linkage	
		<b>VISUAL</b>	
		1 Merchandiser equipped per customer order.	
		2 All labels in proper location and installed straight.	
		3 Cabinet appearance: exterior and interior.	
		4 Properly painted and plated parts.	
		5 Correct trim panels installed and inserts installed - (language of destination).	
		6 Spiral retainers in place.	
		7 Adjustable product spacers in place.	
		8 Proper insert instructions plate installed.	
		9 Alignment of monetary panel and door frame.	
		10 Proper model identification tag installed.	
		11 Serial numbers on inspection sheet agree with shipping ticket.	
		12 Quality label signed and placed on door.	
		13 Electrical code tag attached to power cord.	
		14 Lock and key or retainer key (key in coin cup).	
		15 Price labels installed.	
<b>NOTE: A mark in both columns shows that the item was rejected, repaired, re-inspected, and found to be acceptable.</b>		Inspector's stamp	Initials
			Date

	NOTE: A mark in this column indicates completion of work.
	<b>PRE-PACKING</b>
	1 Clean inside of merchandiser - remove all debris, loose screws, etc.
	2 Install plastic miscellaneous components bag (containing manuals, price label rolls, etc.).
	3 Tape coin box.
	4 Tape protective packing on monetary frame and upper right door.
	5 Post card taped in place.
	6 Insert door leg hole plug.
	7 Install shipping bag over machine (when required).
Date:	Work performed by:

