Decommissioning - Autoflow Mk4 1

How to safely decommission and load a Stuga Autoflow Mk4.1 machine

Difficulty **Hard** | Duration **1 day(s)**

Contents

Introduction

The Autoflow Mk4.1 machine has been designed to separate into modules for safe transport
The **infeed table** gripper carriage and conveyor split into two sections
The **machining head** and **saw** split apart like a cam shell. They are joined with a dowel system in joining blocks at the base
The **outfeed** splits in to a rear bed and front tray

> ...Please follow the process carefully and ensure you understand how the machine is connected together

See Also
Safe Moving of Top Heavy Machine Modules

Step 1 - Move axes to park positions

- X axis to machining side of lifting points
- Z axis to bottom of travel
- GZ axis to minimum

Step 2 - Power off

...Isolate power and air completely from the machine

Step 3 - Infeed Conveyor Module - Disconnect

Ensure the plugs are labelled

Step 4 - Infeed Conveyor Module - Move

Pull away from backfence towards front of machine

Step 5 - Infeed Gripper Module - Disconnect

Ensure the plugs are labelled

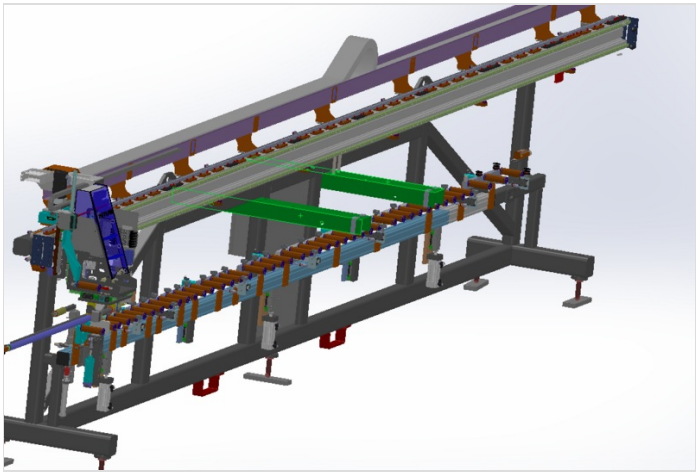
Step 6 - Infeed Gripper Module - Stowing

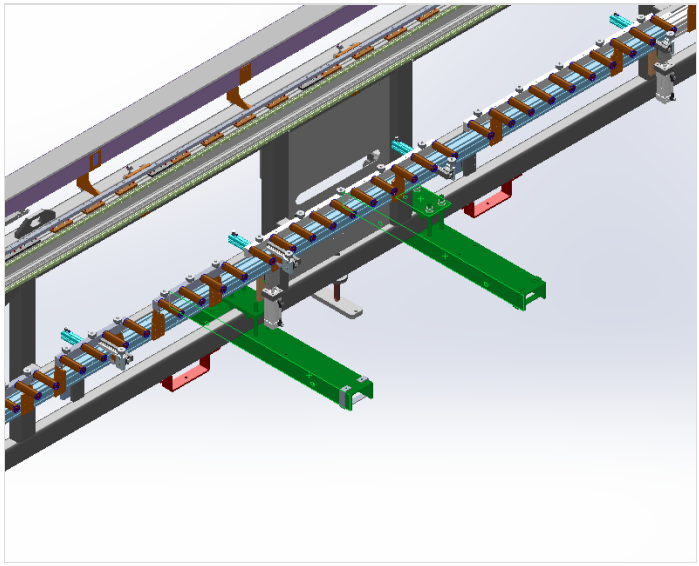
Tie gripper carriage to prevent axis movement in transit

Step 7 - Infeed Gripper Module - Attach lifting Equipment

Attach safe moving equipment - see R0019264 Autoflow Mk 4,1 Infeed Safe moving equipment

...The gripper table is top - heavy and the moving equipment is vital to move, and particularly lift the table safely





Step 8 - Outfeed table disconnect

Ensure the plugs are labelled

Step 9 - Machining Head and Saw - Disconnects

Locate and unplug the electrical and pneumatic interconnections.
Ensure the plugs are labelled

> ...The cables and plugs will need to be pulled through the frame holes during separation.

Front Side

1. X2F and X3F ILME Connectors. Pull one through one way, one through other way
2. Grease Lines - 2 off
3. Air Lines Red and Blue

Rear

1. ILME Connection
2. Network Connection - 2 Off

> ...The two front ILME plugged connections are located in different modules to ensure that cannot be plugged incorrectly. They physically cannot reach each other

Step 10 - Unlink Upper Guards

The guard shells are fastened with a plate internally.
Unbolt the Saw side front and rear, then bag and label the screws

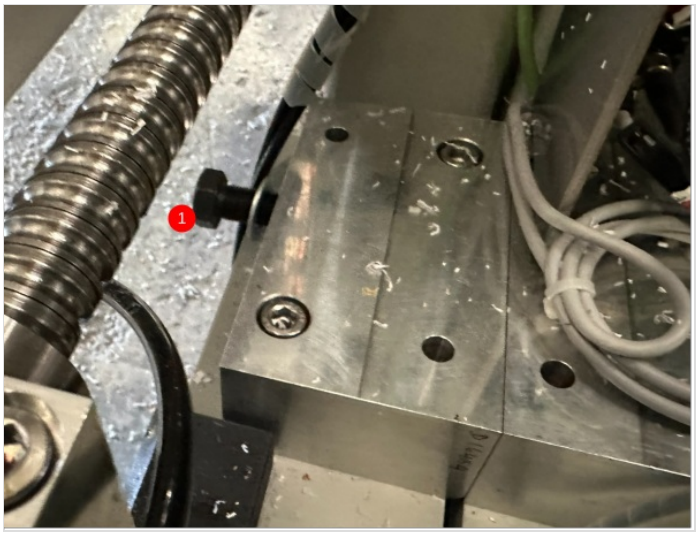
Step 11 - Split Machining Head and Saw

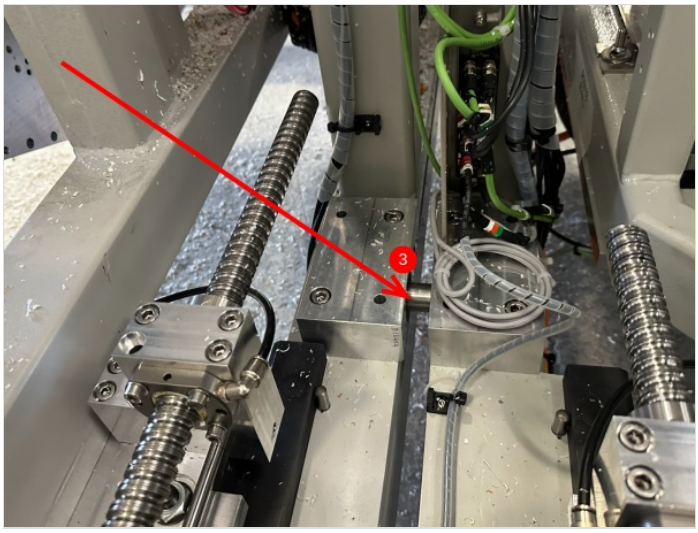
1. Remove the M16 front and rear hex head joining bolts, access from saw module. These are the only 2 bolts that fasten the machine together.

> ...Do not undo any cap head bolts

2. Using a crowbar, spit the main modules apart by around 100mm
Walk the front and rear by 23-30mm a time until the dowels are clear
3. You will see the location pin exposed in the joining blocks

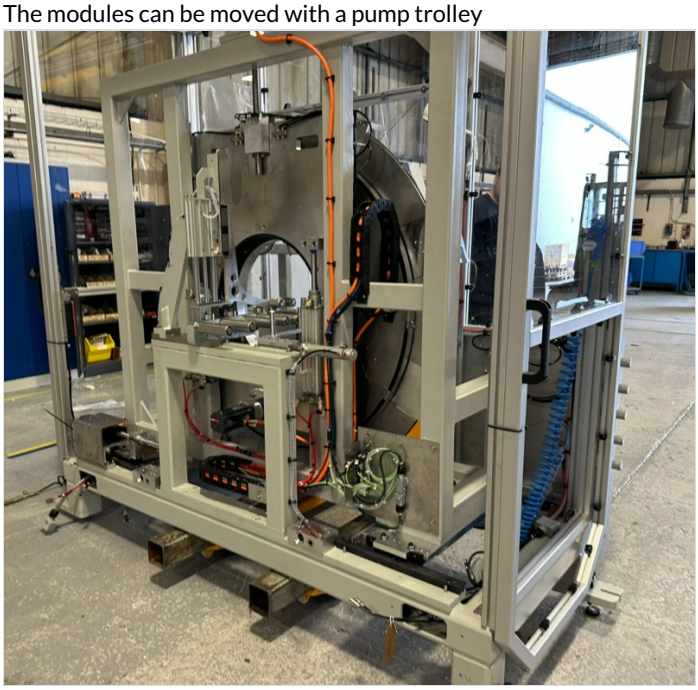
> ...Double check to ensure all interconnection pipes and cables are clear of the through holes





Step 12 - Complete the split

The modules can be moved with a pump trolley



Step 13 - See also

Safe Strop Positions - Autoflow Mk4 1
Safe Moving of Top Heavy Machine Modules