



J0001000H Autoflow Mk4 Mechanical installation-Alignment

Installation and Alignment criteria for Autoflow Mk4

 Difficulty **Hard**

 Duration **2 day(s)**

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Comments

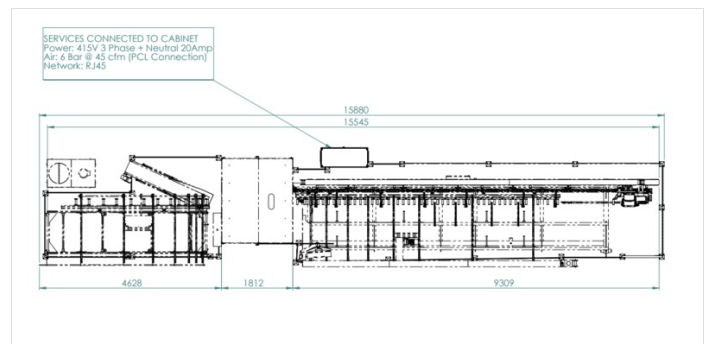
Introduction

Information to clarify correct process for installation of J0001000H Autoflow Mk4

Levelling tolerance of 0.004" /0.1mm over 300mm (1 division on engineers level) must be adhered to

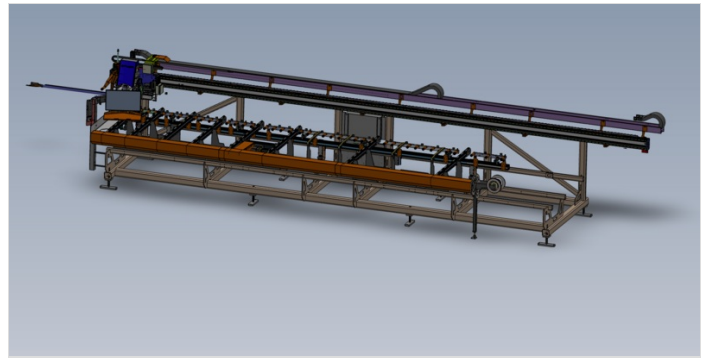
Step 1 - Machine Location/Position

Use footprint drawing to determine machine location for installation



Step 2 - Module A Infeed table

Identify correct position for installation of Infeed frame. Ensure consideration is given to walkways and installation of machine guarding at later part of installation

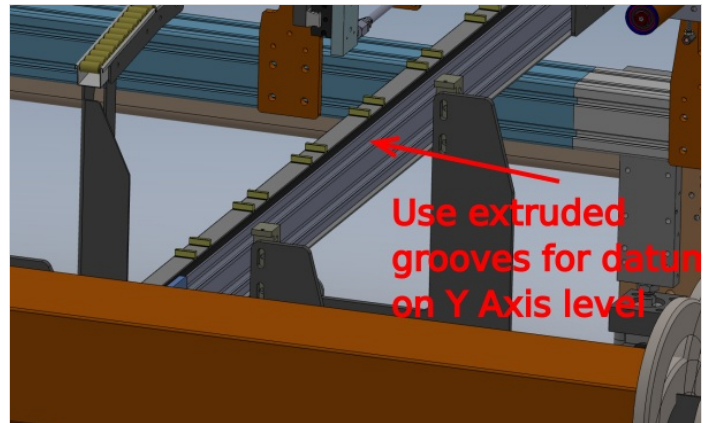
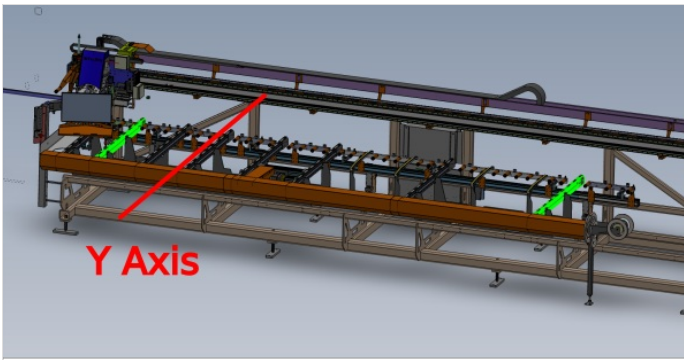
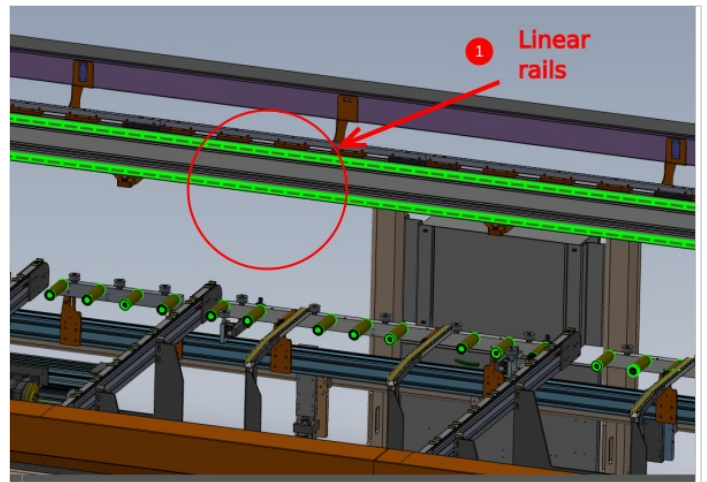
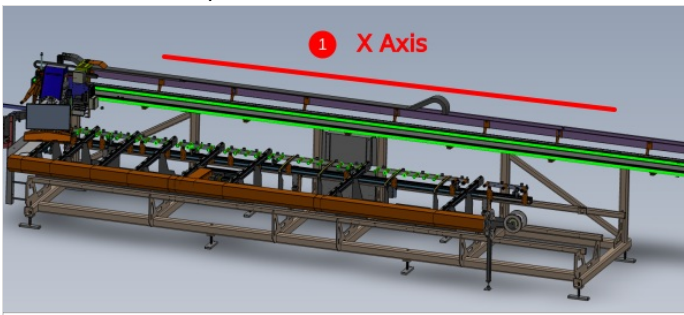


Step 3 - Levelling Datums

Indicated are the levelling datums for the Infeed table

X Axis as indicated by 1

Y axis as indicated by 2



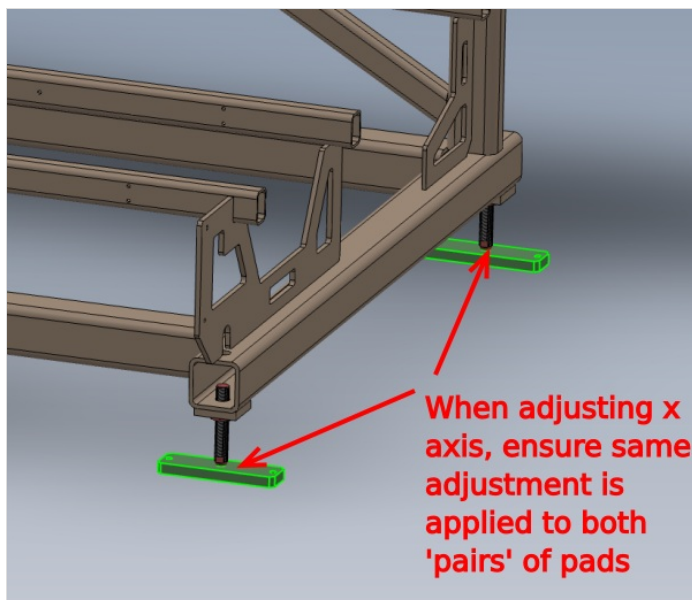
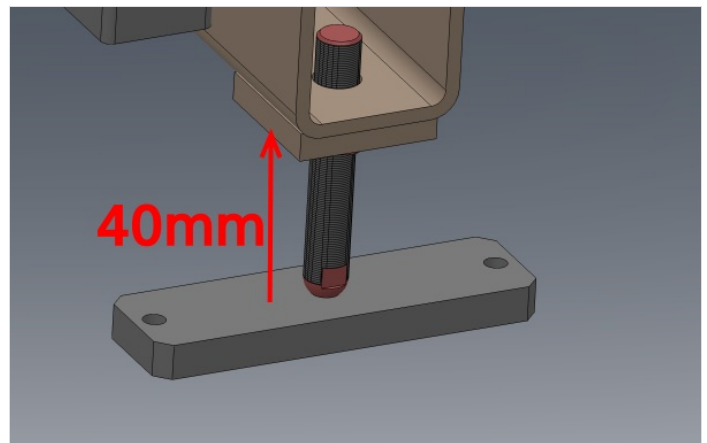
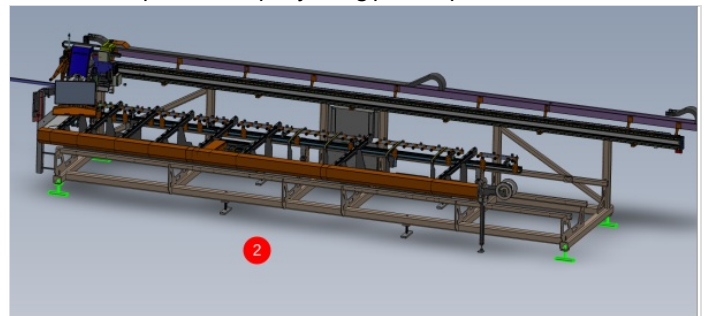
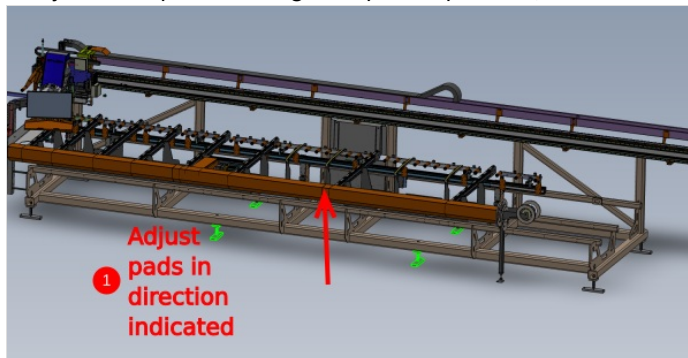
Step 4 - Infeed Table Levelling Process

1 Ensure indicated central 4 adjusting bolts/ pads are lifted out of the way , so they do not impede the levelling process

2 Set gap of indicated pads to the starting measurement shown of 40mm

3 Adjust Y axis position to read level at indicated points using pads indicated in number 2 only

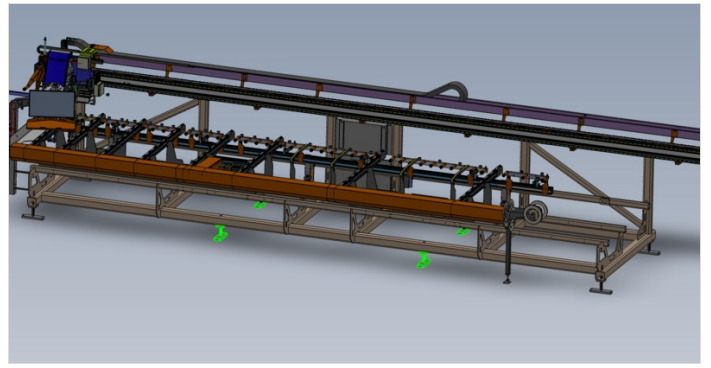
4 Adjust X axis position using same pads as previous,and ensure Y axis level is not compromised by adjusting pads in pairs



Step 5 - Adjust remaining pads

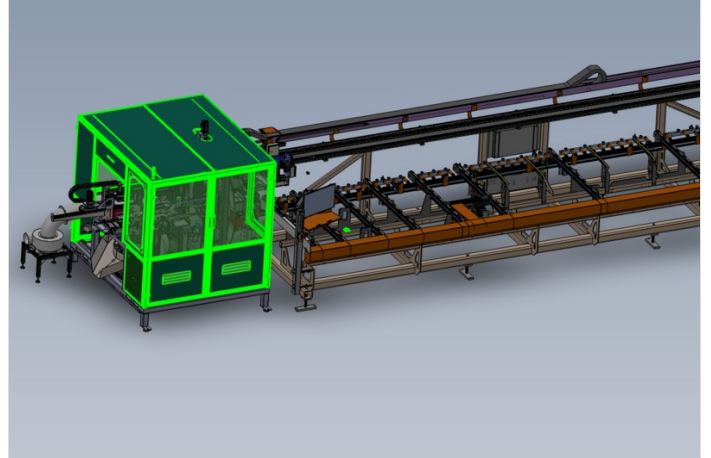
Remaining pads should now be adjusted down to touch floor.

Ensure no additional pressure is applied to them which will cause levels to be affected



Step 6 - Position Machining/Saw unit

Position Module B/F into the approximate area according to the floor plan

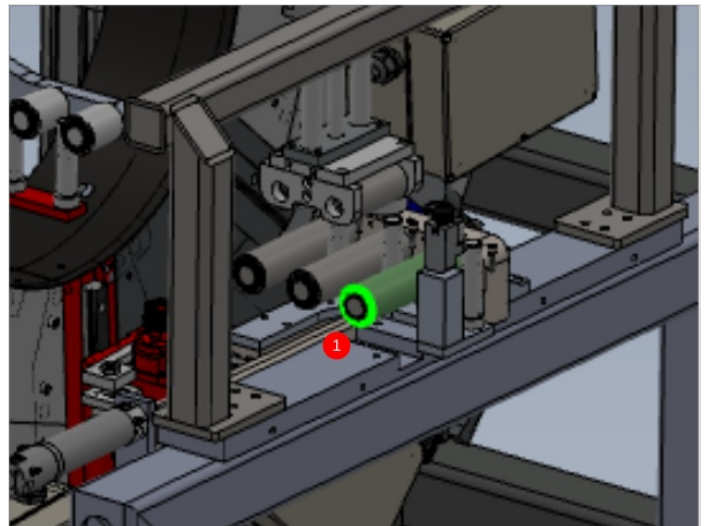
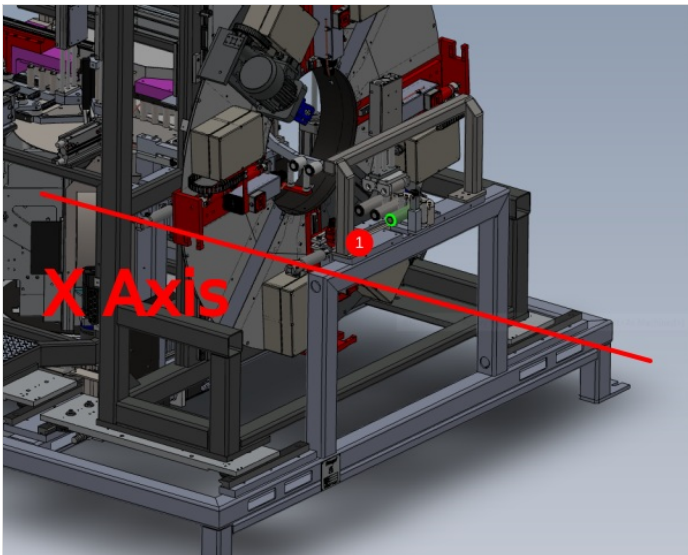


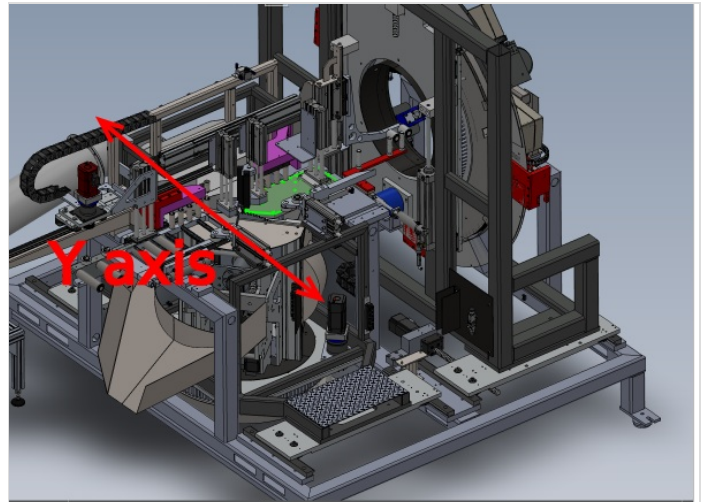
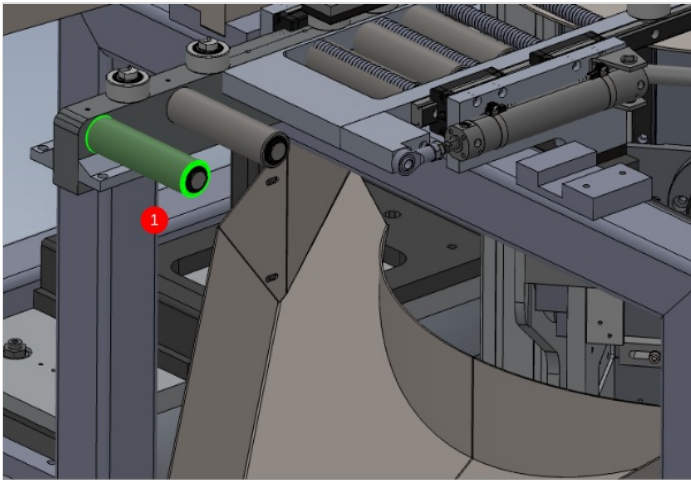
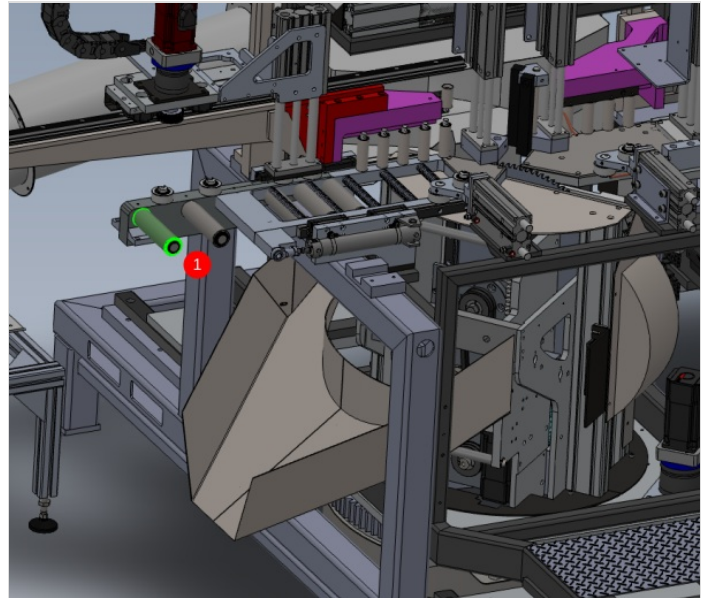
Step 7 - level datums

Datums for levels are as shown

1 X Axis . Only first and last datum rollers should be used initially for levelling

2 Y Axis should be set from fixed cut table



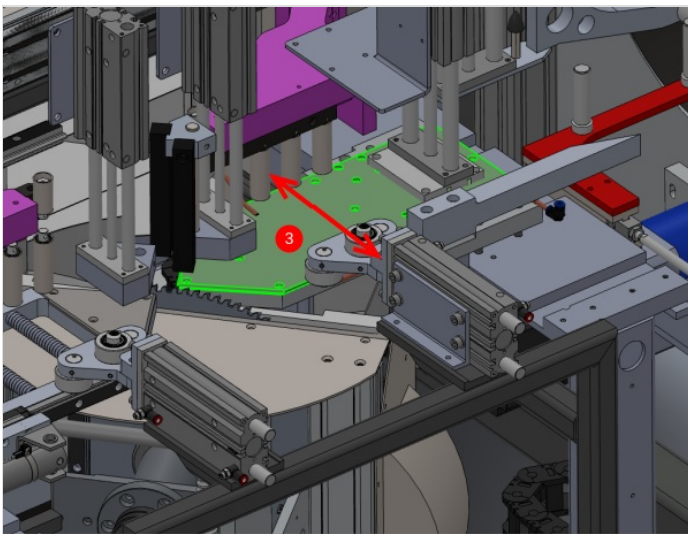
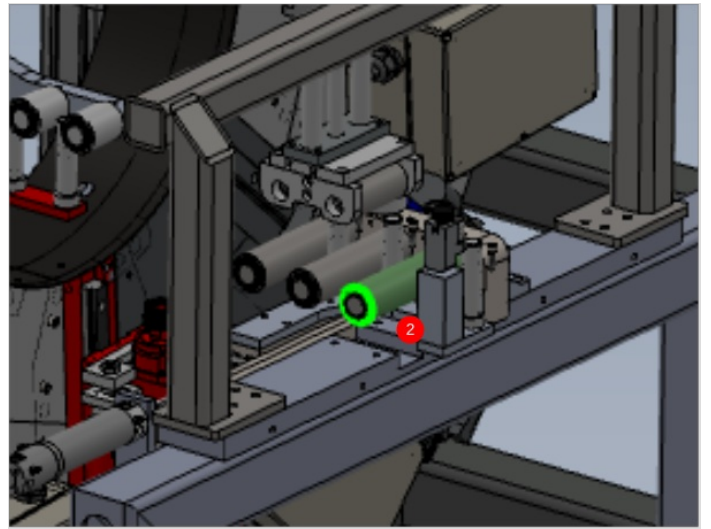
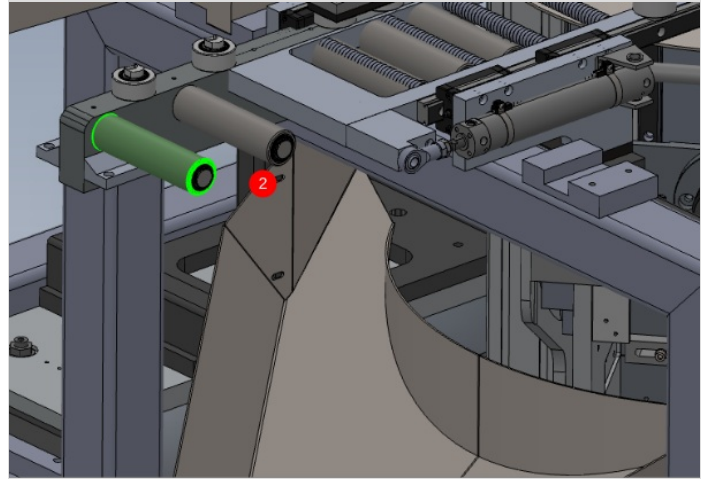
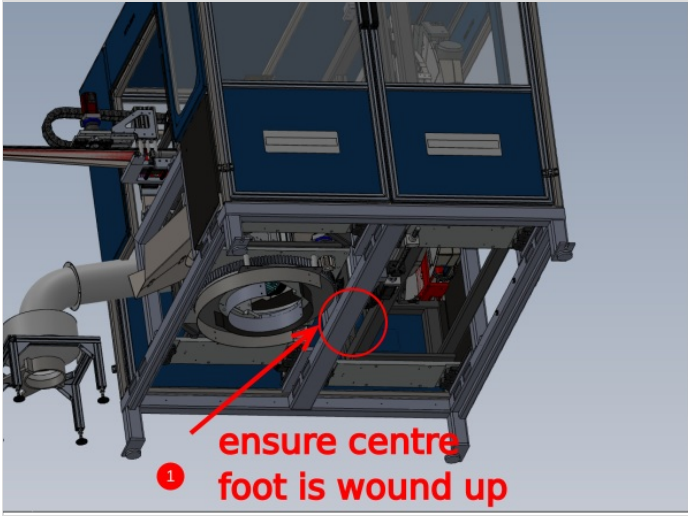


Step 8 - Set levels

1 Ensure centre support foot is wound up away from floor to not impede initial level setting

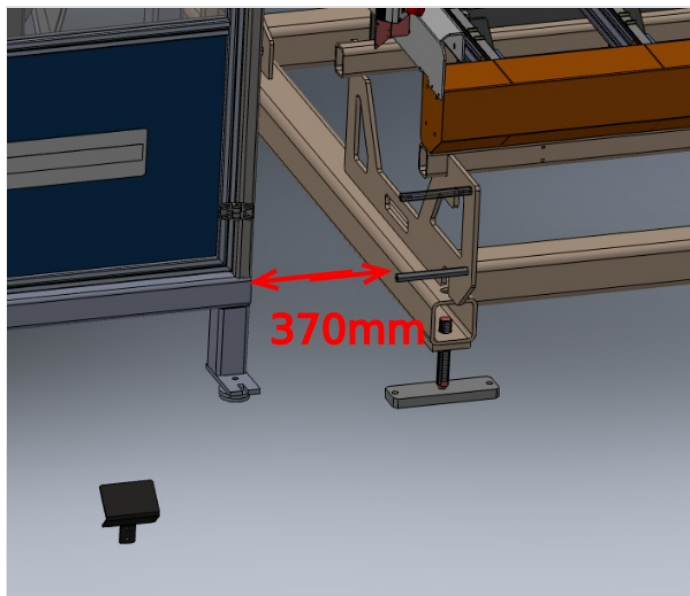
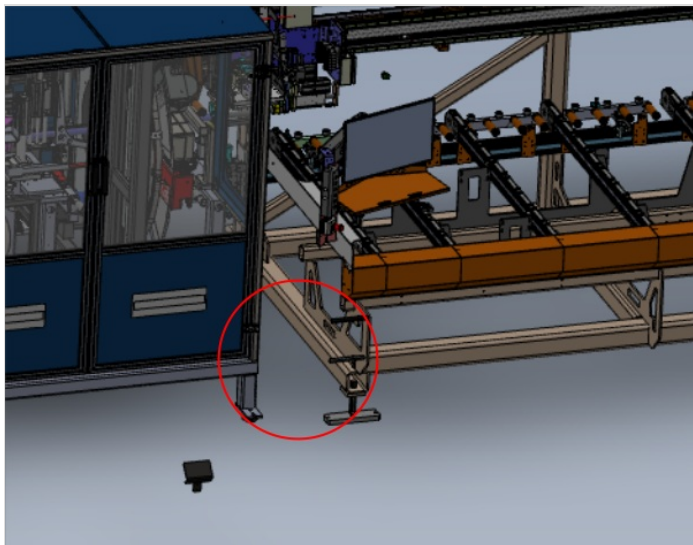
2 Use a 2 meter straight edge and engineers level to bridge between 2 indicated datum points for X axis datum . Adjust perimeter pads only to bring this level (centre rollers tables may appear low when straight edge is used. This is normal and will be adjusted out later)

3 Use engineers level on the indicated face to adjust Y axis level. Ensure floor pads are adjusted in pairs to maintain X axis level that has been set



Step 9 - Finalise Position Machining centre X axis

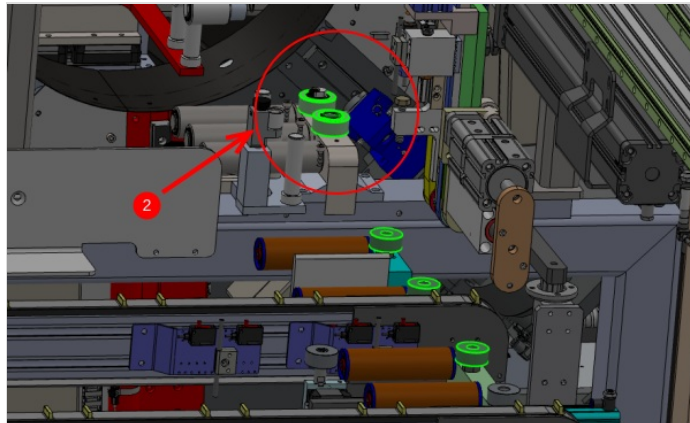
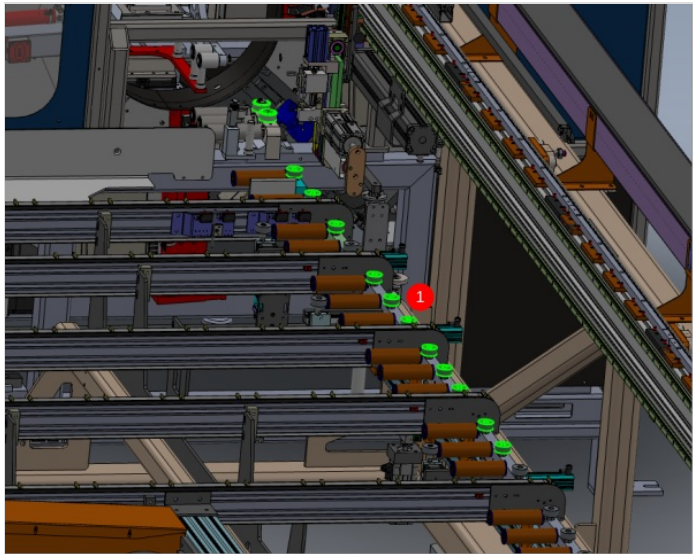
Spacing between Infeed and Machining centre should be set to 370mm as indicated. This measurement is taken from internal faces of frame box section.




Step 10 - Finalise Position Machining Centre Y axis

1 Use 2 meter straight edge against indicated rollers on infeed table .

2 Adjust position of Machining centre so indicated rollers align to straight edge set against infeed rollers



Step 11 - Finalise Machining centre height

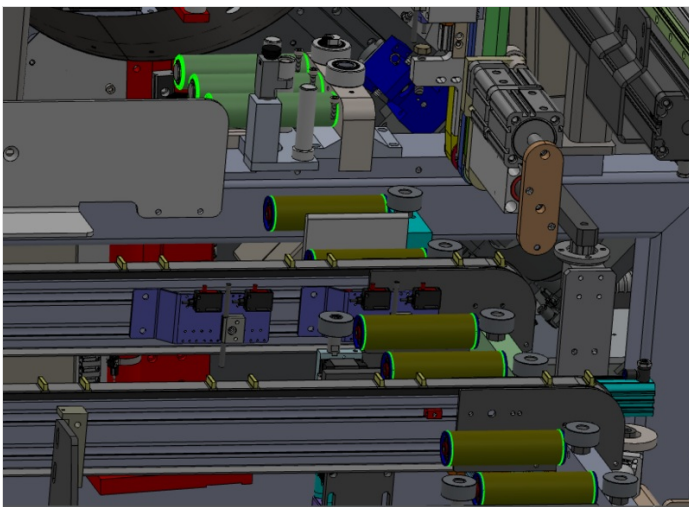
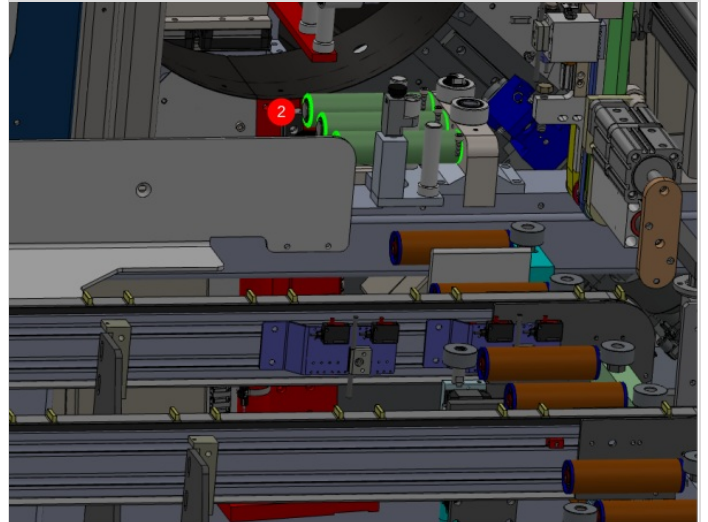
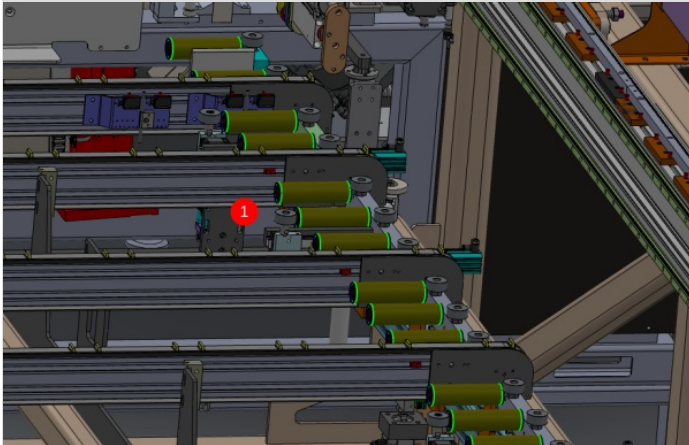
 ...Infeed table lift rollers are required to set height relationship to Machining centre. These must be set in the lifted position. Use temporary air supply

1 Use 2 meter straight edge on indicated rollers to project height to Machining centre

2 Use indicated rollers to accept projection from Infeed table

3 Adjust 4 corner pads of Machining centre equally to match height to straight edge .

4 Increase height of Machining centre by 0.5mm to allow slight bump up from Infeed rollers to Machining centre

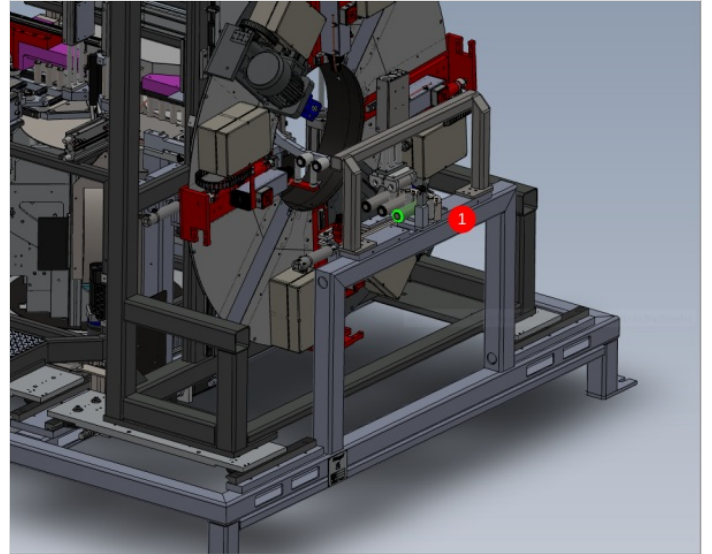
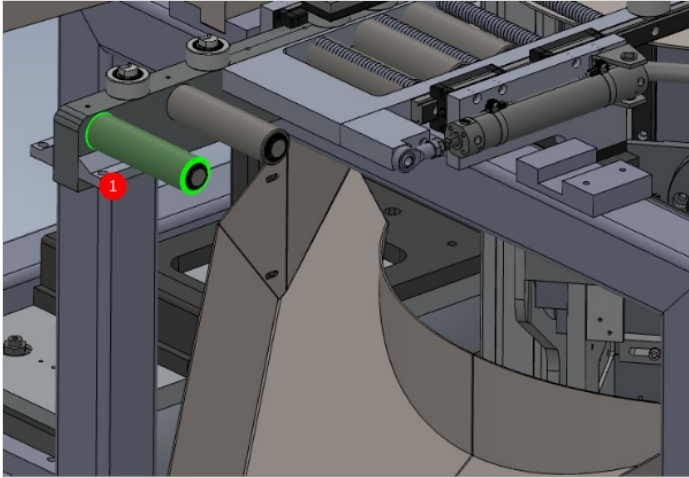


Step 12 - Adjust Centre support

1 Centre support foot can now be set on Machining centre. Insert 2 meter straight edge and bridge 2 datum points for x axis on the machining centre (same as previous step)

2 If all rollers are contacting straight edge, adjust centre support to take weight of Machining centre but not adjust roller position

3 If discrepancy is visible, centre support can be adjusted to align centre rollers to straight edge

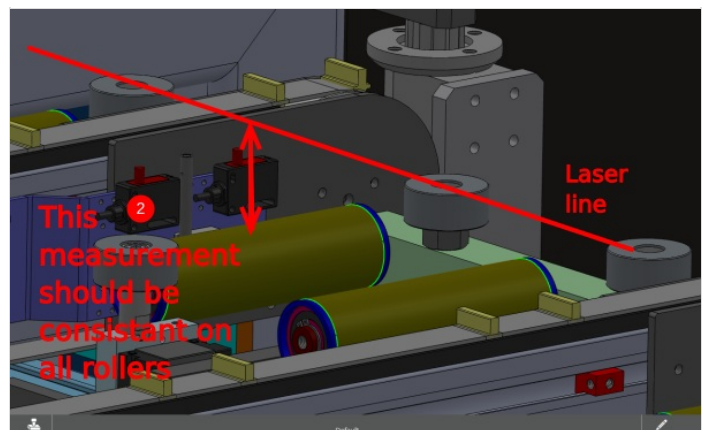
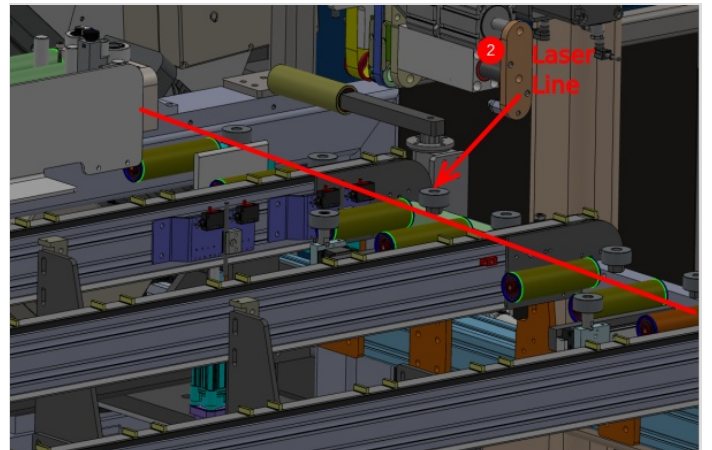
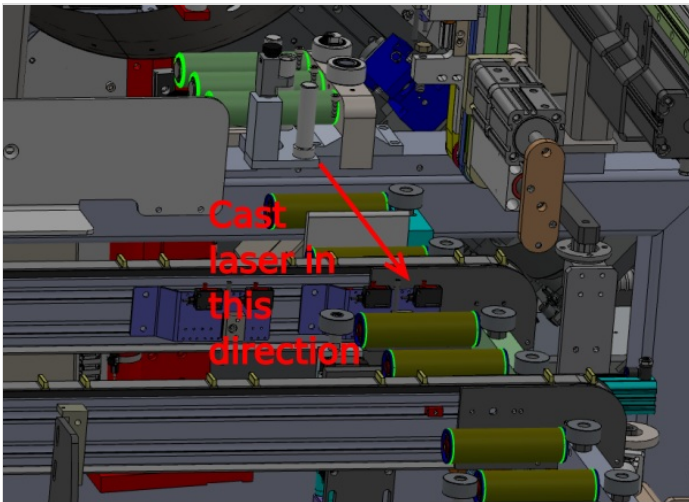


Step 13 - laser Alignment Height

Laser alignment is now required to ensure all alignment is correct

1 Use a laser to cast from indicated rollers in the direction shown

2 Ensure measurement indicated is constant on every roller on infeed table



Step 14 - Laser Alignment Backfences

1 Use a laser to cast from the indicated point in the direction shown

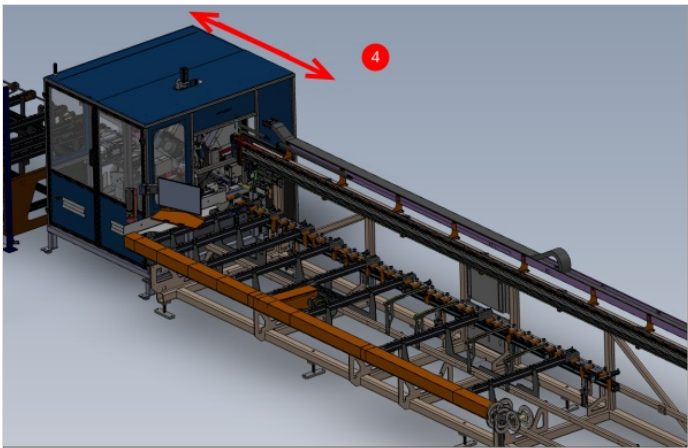
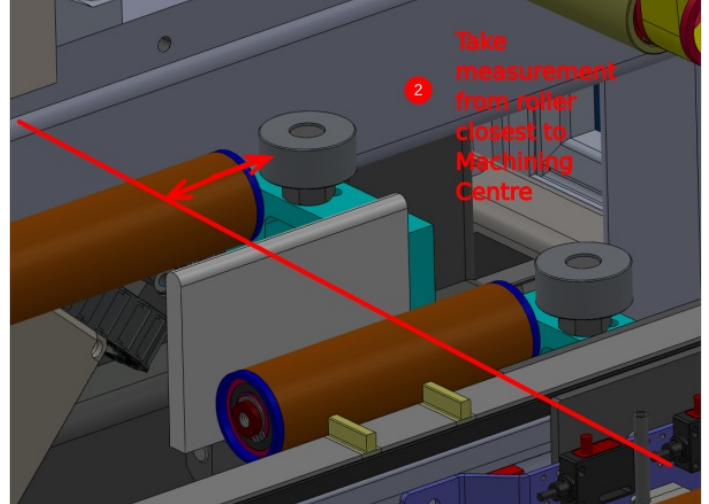
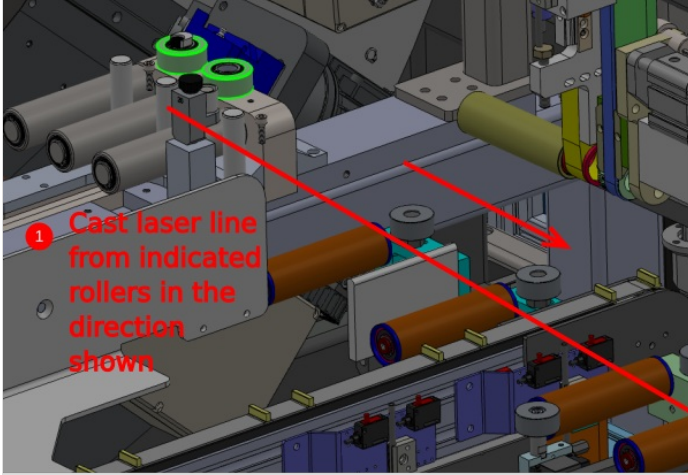
2 Take indicated measurement From roller closest to Machining centre

3 Take the same measurement at the last roller on the Infeed. These measurements need to be the same to ensure correct alignment

4 If the measurement is different, the Machining centre will require adjusting slightly to correct this pivot the Machining centre Rear in the indicated directions to correct laser error

5 Recheck Step 10 if adjustments are made

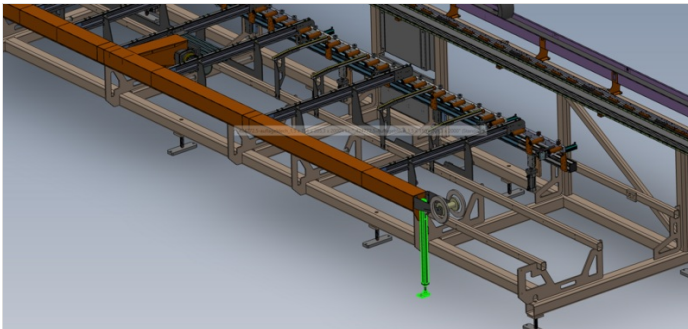
All Previous parameters for alignment must be rechecked (steps 7 to 13) once final adjustments have been done

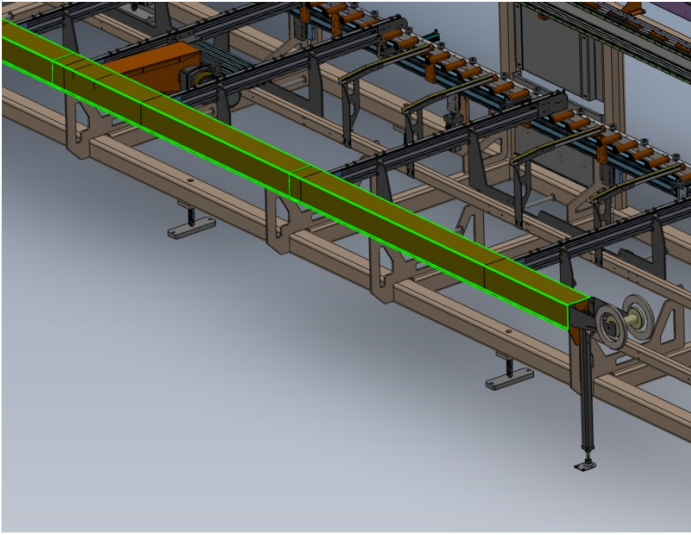
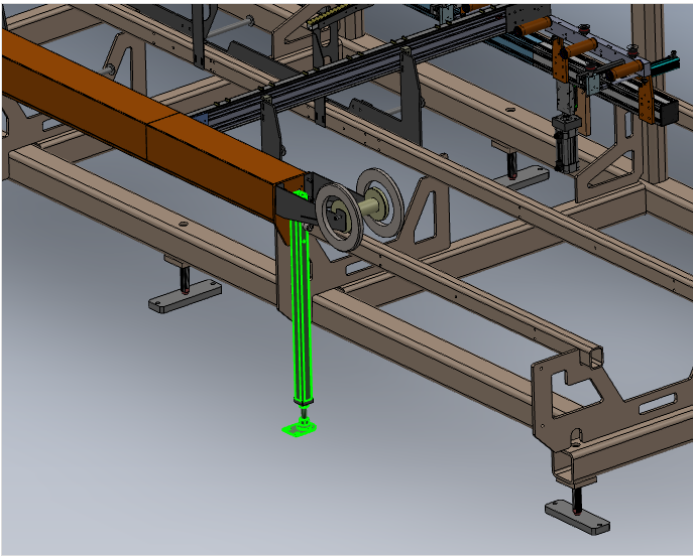


Step 15 - Finalise Front guard Support

Now alignment between Infeed table and Machining centre is complete , the front tray support can set

Adjust support so front tray is held level to rest of assembly





Step 16 - Assemble JX Axis

The JX axis requires assembling to allow setting of the outfeed table
