


# R0000706 Bench assemble Infeed Datum rollers

Correct build checks for assembly of R0000706 datum rollers

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

## Introduction

### Tools required

External circlip pliers

Standard hex key set

Pipe cutters

Pneumatic identification numbers

### Parts Required

B0000062 Circlip 20mm External x 6

D0001176 Washer : bearing shim x 3

D0001333 Roller Ø40 x 80 c/w bearing x 3

D0001334 Roller Ø40 x 102 c/w bearing x 3

D0003108 Shaft 20mm: 146mm Clamp Roller Shaft x 3

D0007677 Infeed Base Rail (D2972) x 1

D0007942 Shaft 20mm: 119.4mm ZX Datum Roller Circlip x 3

D0010896 Infeed Clamp Blower Vert x 1

D0010897 Infeed Clamp Blower x 1

P0000053 6mm T (P16) x 1

P0000160 Fitting: Flow Controller In Line 6mm x 1

## Step 1 - Unless otherwise stated

Use loctite 243 on all fasteners

Use loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



## Step 2 - Check fit of shafts in bearings

Check fit of following parts .

Shafts should pass through bearings with only slight resistance . All inner bearing faces should have contact to shaft and rotate when the shaft is turned

Proceed to step 4 if fit is correct

If shafts are tight check drawing and inspect size of shaft .

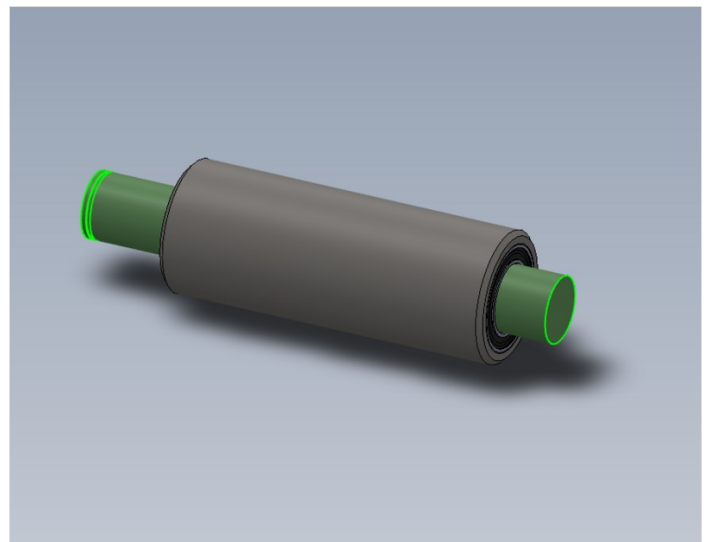
If shaft slides through easily, then follow step 3

D0001333 Roller Ø40 x 80 c/w bearing x 3

D0001334 Roller Ø40 x 102 c/w bearing x 3

D0003108 Shaft 20mm: 146mm Clamp Roller Shaft x 3

D0007942 Shaft 20mm: 119.4mm ZX Datum Roller Circlip x 3



## Step 3 - Degrease and bearing fit

**i** ...only follow this step is bearing/shaft fit is loose

Thoroughly degrease all parts with FE10 solvent

1 Fit 20mm external circlip to shaft

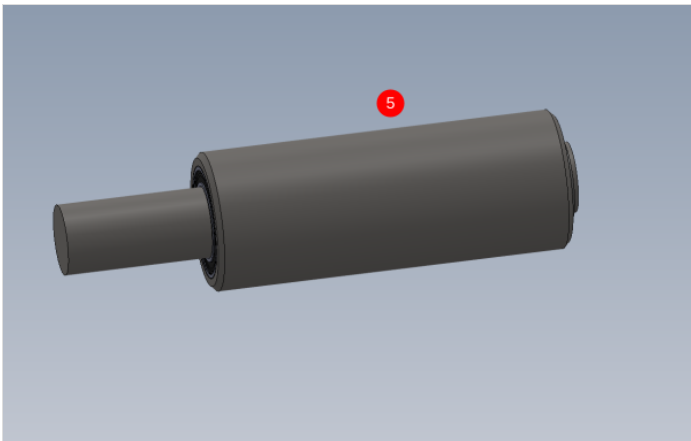
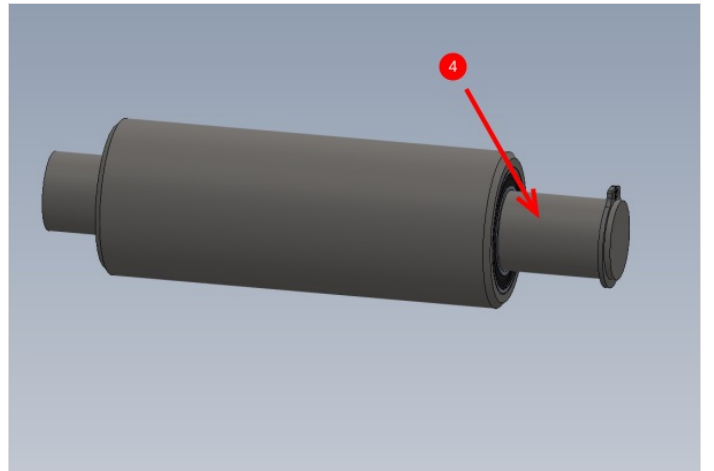
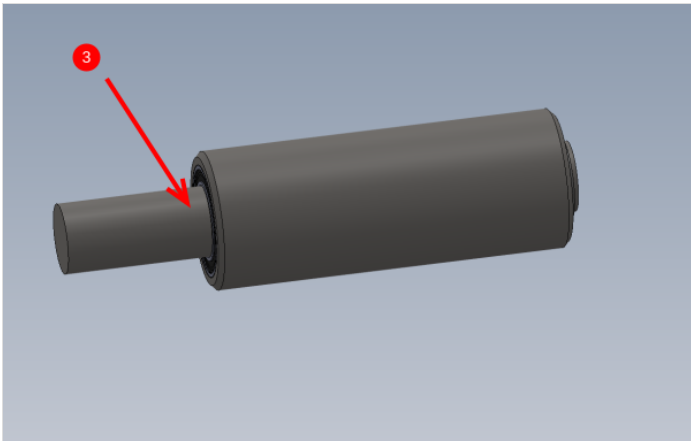
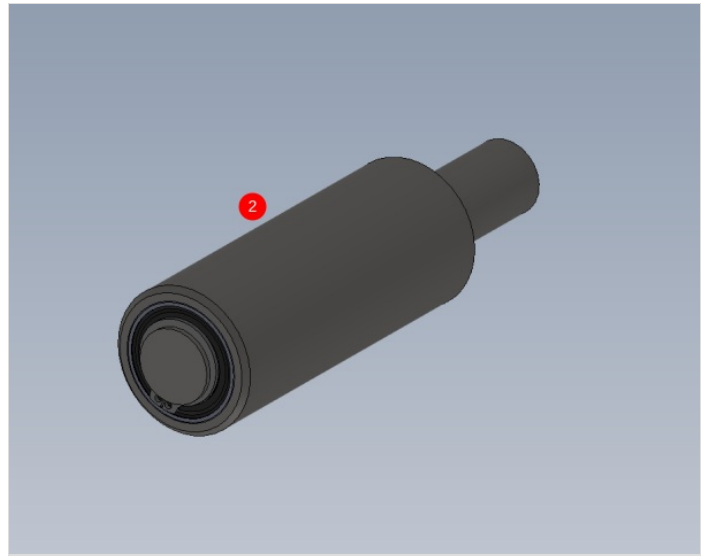
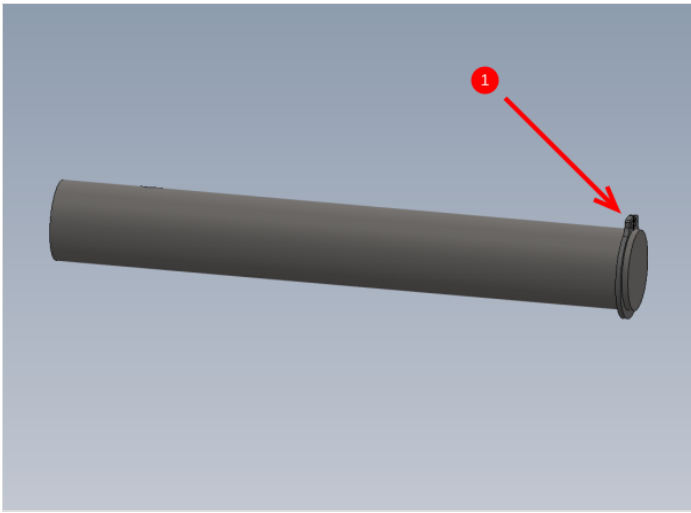
2 Fit roller to shaft

3 Add 3 drops of Loctite 641 bearing retainer to indicated area and smear around the shaft

4 Move shaft to shown position and add 3 more drops of bearing fit to indicated face and smear around

5 Position roller against circlip and remove any excess bearing fit with rag

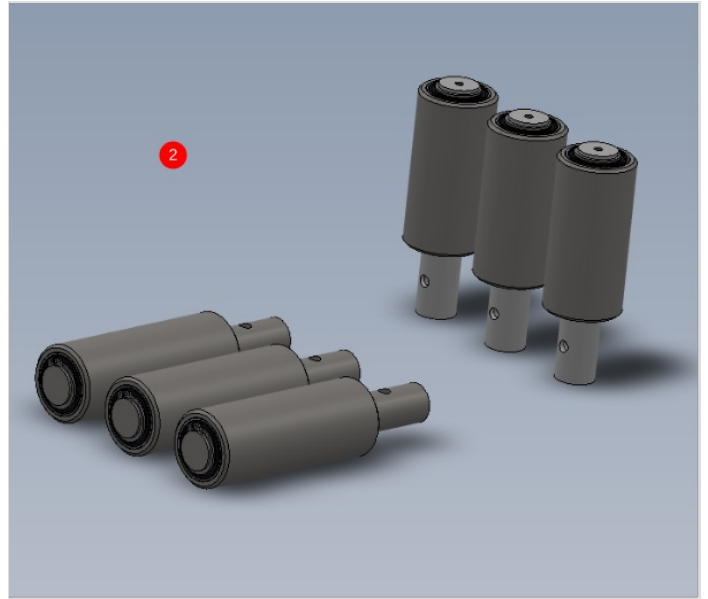
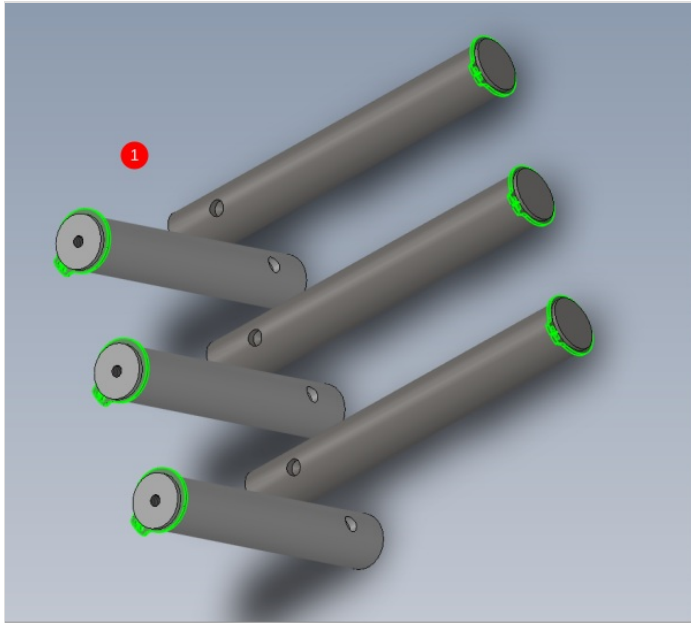
6 Leave roller in a vertical position to allow bearing fit to cure



## Step 4 - Add circlip and fit roller

1 Fit 6 off 20mm external circlips to shafts as shown

2 Fit rollers to shafts

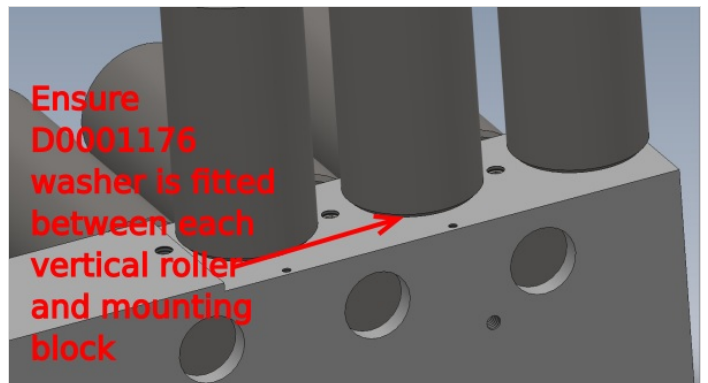
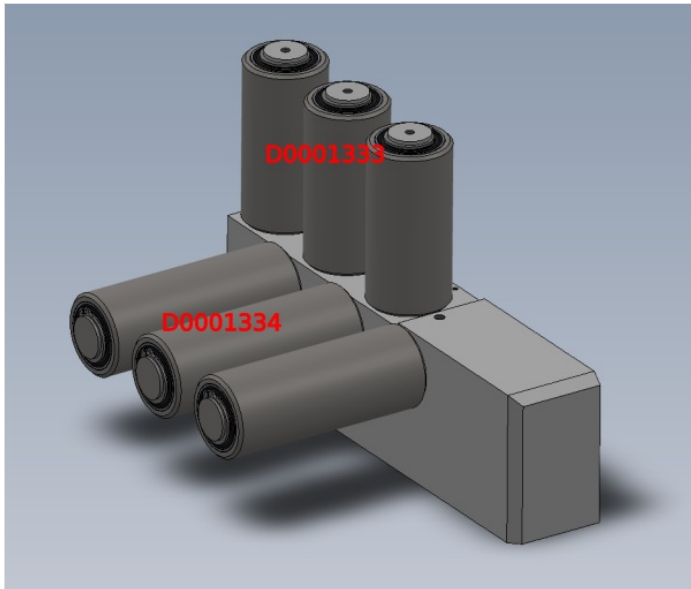


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## Step 5 - Mount rollers

Fit rollers to D0007677 Infeed Base Rail (D2972) x 1 as shown and secure with M6 x 10 KCP grub screws

Ensure dimples in shafts are located correctly to receive grub screws

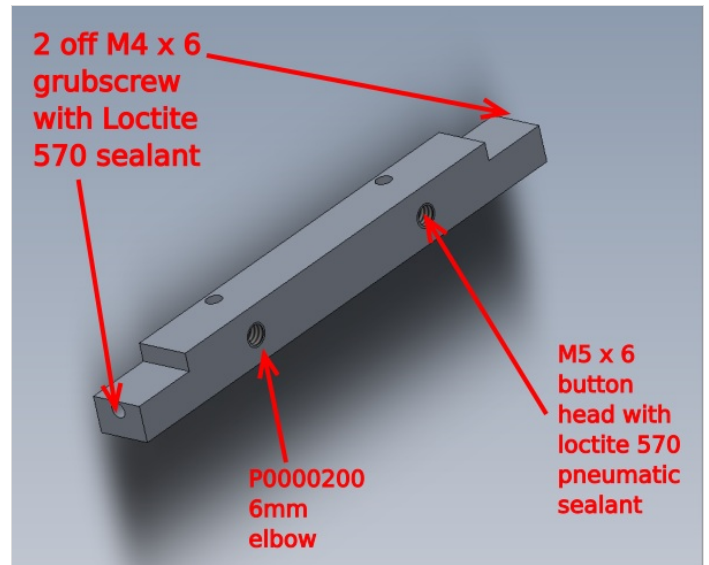
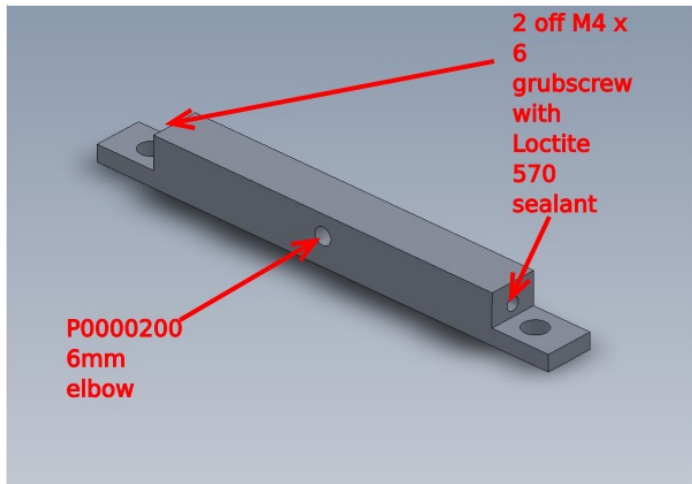


## Step 6 - Assemble Blower rails

Assemble blower rails as shown

1 D0010896

2 D0018097

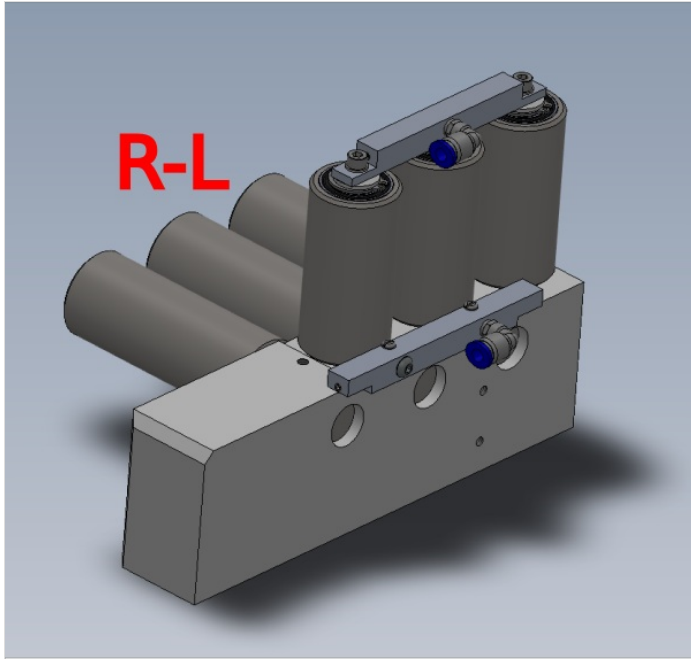


## Step 7 - Mount blower rails

Mount blower rails to roller assembly

Use m3 x 20 pan heads to mount D0010897

Use m5 x 12 socket caps and A form washers to mount D0018096 ( do not use adhesive on these fasteners )





## Step 8 - Fit pipe work

Attach pipework as shown

Pipe identification number is 3609

attach P0000160 flow regulator to pipe port shown

