


# R0000712F Rotary Trunking

Installation of rotary energy chain and back plates

 Difficulty **Medium**

 Duration **2 hour(s)**

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Comments

## Introduction

### Tools Required

Standard set Hex keys

Standard socket set  
Countersink bit and drill  
Copper/hide hammer  
Standard hss drill set  
Hack saw  
File

#### **Parts Required**

D0006210 pre assembled energy chain  
D0003929 Access panel  
D0003930 Circular guide  
D0003985 Upper circular guard  
D0007817 Circular guard  
D0001171 plug bracket

## Step 1 - Adhesive

All bolts must have Loctite 243 adhesive applied unless otherwise stated.

All bolts must be marked with pen once completed to indicate adhesive and correct tension has been applied

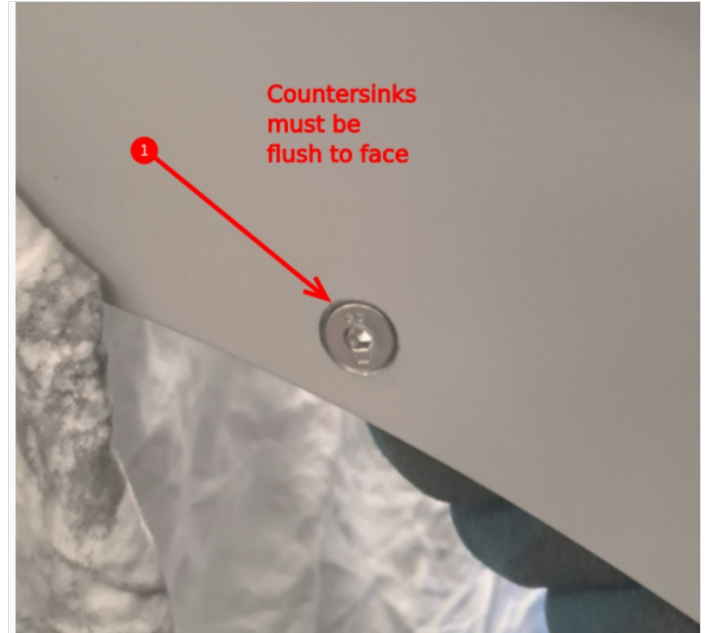


## Step 2 - Prepare 1st guide Section

D0003985 needs preparing before fitting

1 All back plates for the rotary trunking need to be checked for correct countersink depth. Any protrusion from main face will cause energy chain failure

Check and if proud, use a countersink to increase depth



## Step 3 - Fit Energy chain mounting bracket

1 Measure position of bracket onto circular guard (291mm)

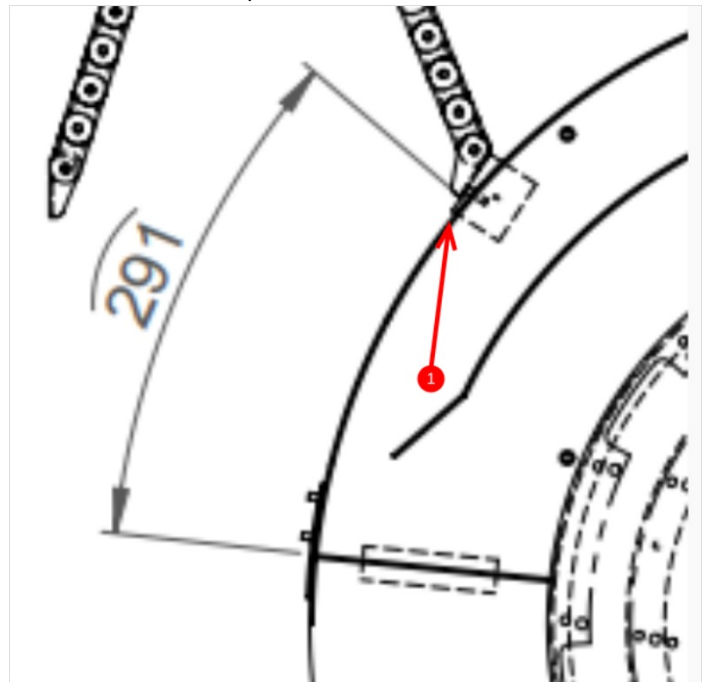
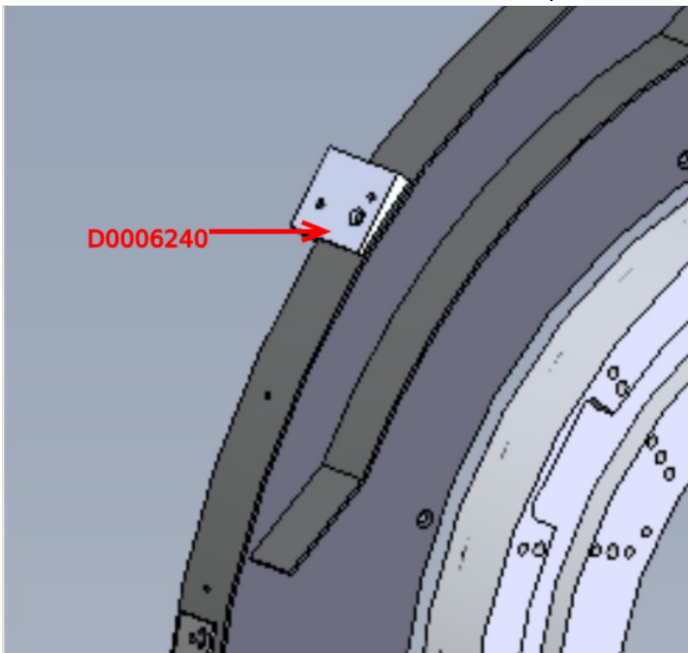
2 Use a pointed m5 grub screw screwed into bracket hole indicated, hold in position on guard, and use hide hammer to transfer position mark

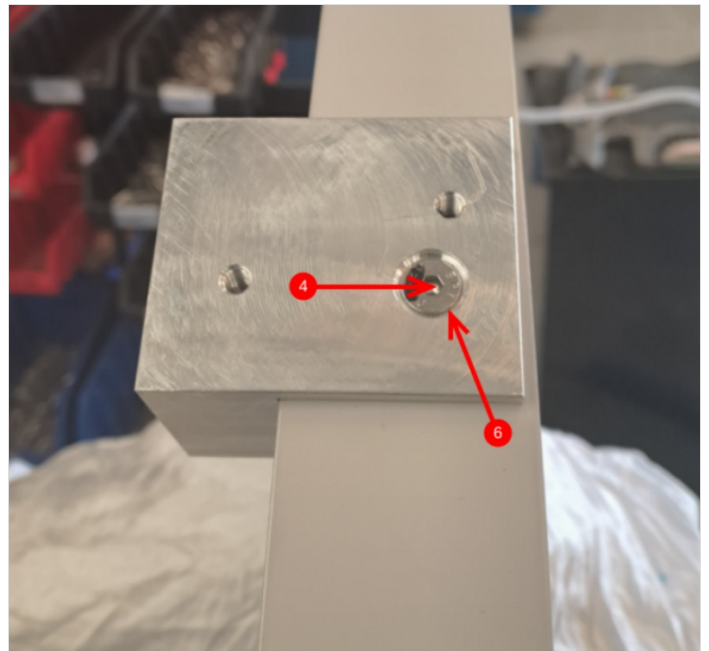
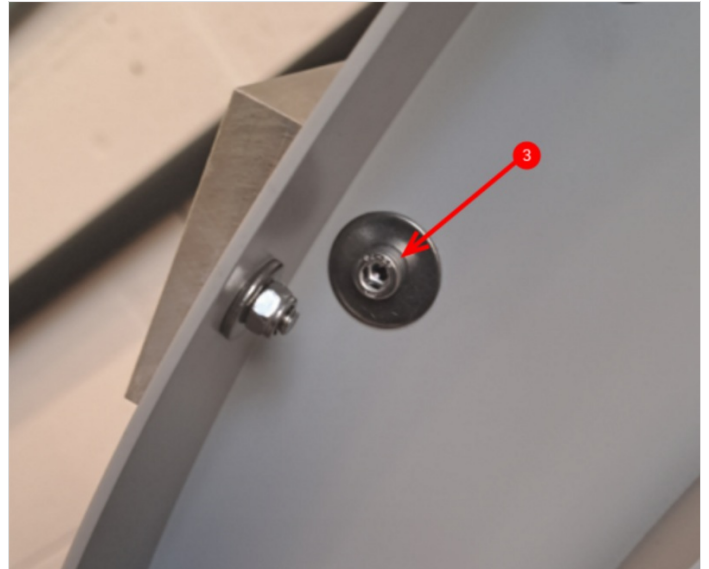
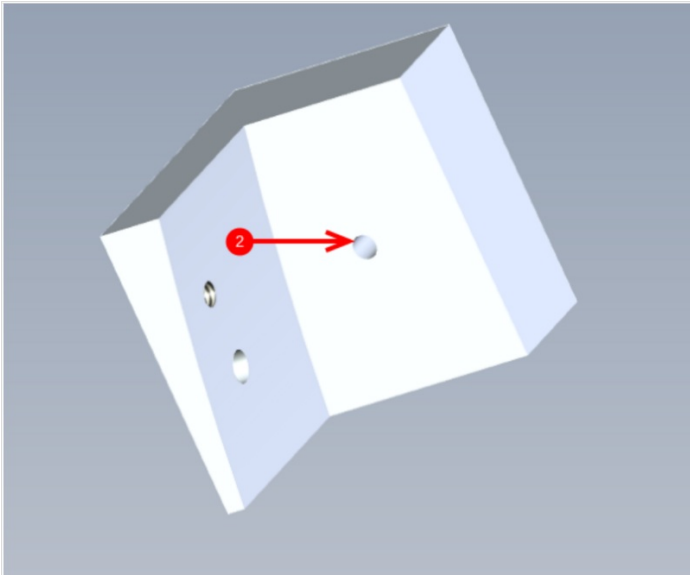
3 Drill to 6mm and fix bracket with m5x 16 cap head and large m5 washer

4 Drill 6mm through indicated hole

5 Fix with M5 x 16 countersink, large m5 washer and nyloc nut

6 This countersink bolt head must be flush to block. If proud, use a countersink bit to increase depth

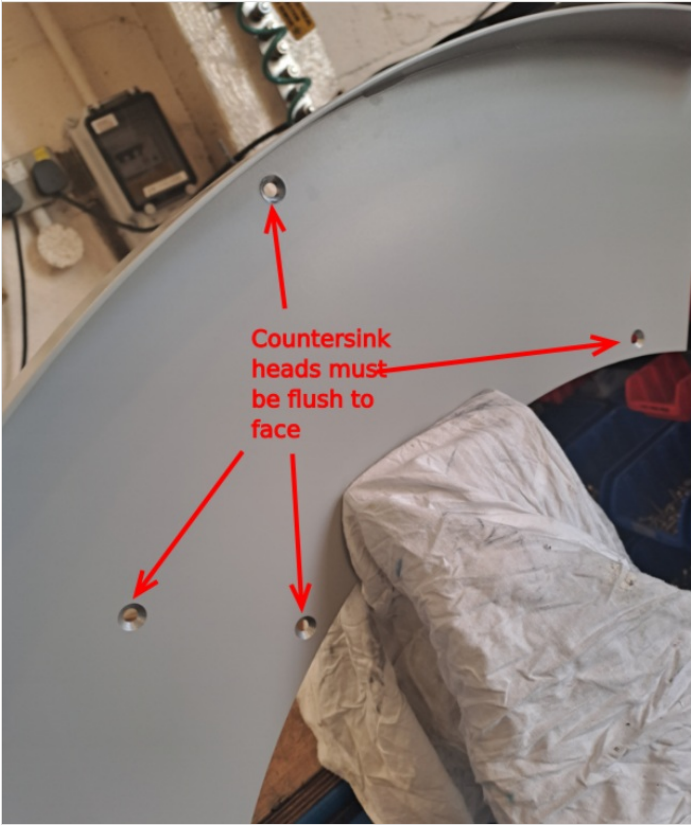




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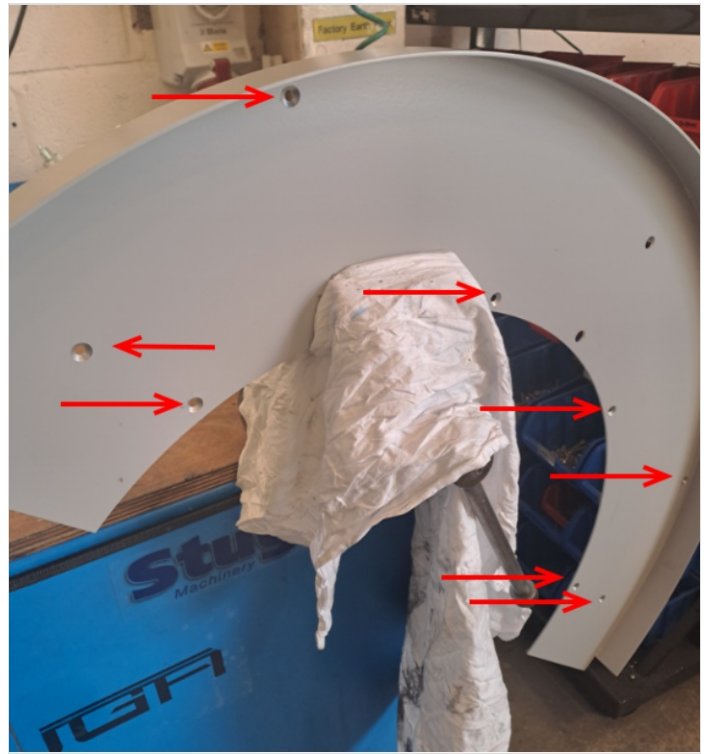
## Step 4 - Prepare second section

Check countersink holes in D0003930 are to the correct depth.  
Rework with countersink if fasteners sit proud.



## Step 5 - Prepare 3rd section

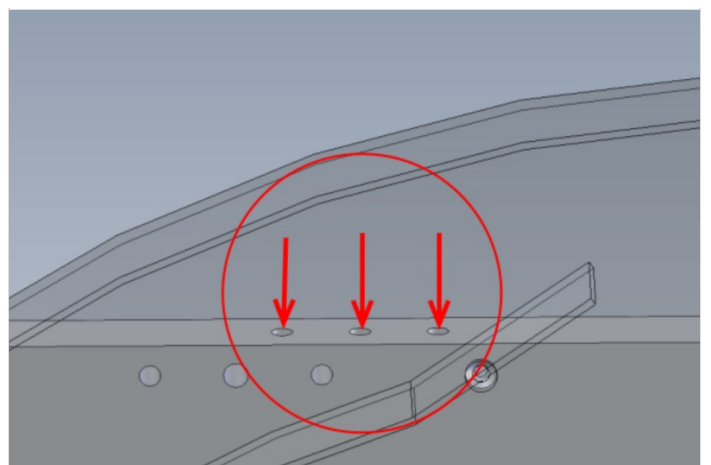
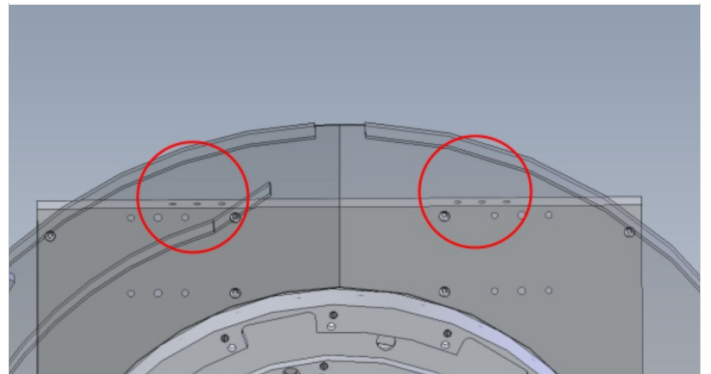
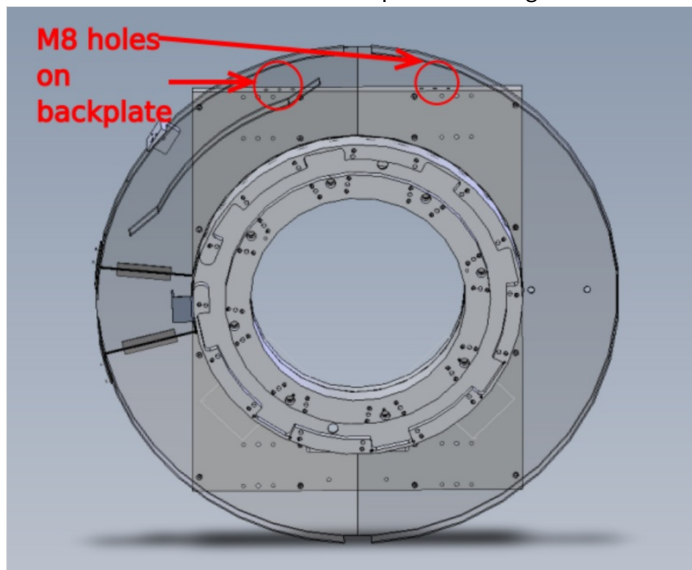
Check countersink holes in D0007817 are to the correct depth .  
Rework with countersink if fasteners sit proud.



## Step 6 - Orientation

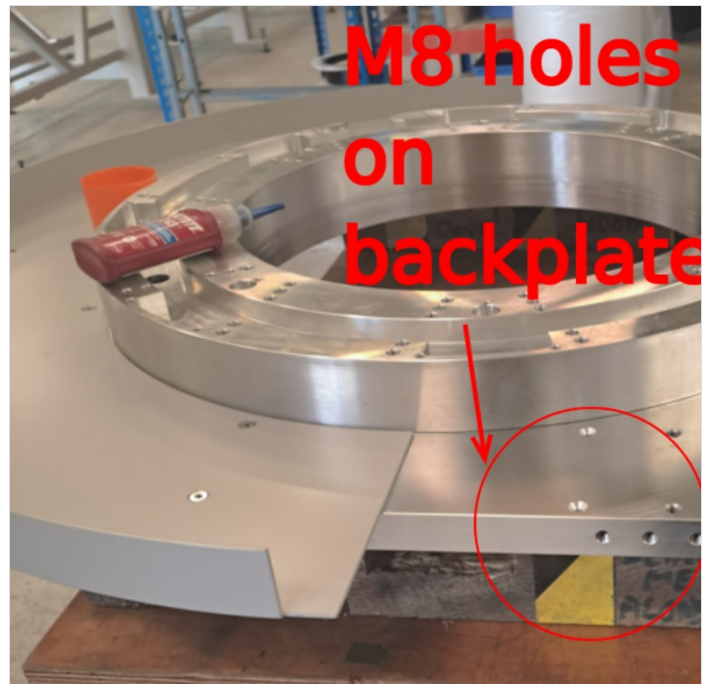
It is vital to achieve correct orientation of above parts

Use M8 holes indicated as reference point for fitting



## Step 7 - Fit D0007817

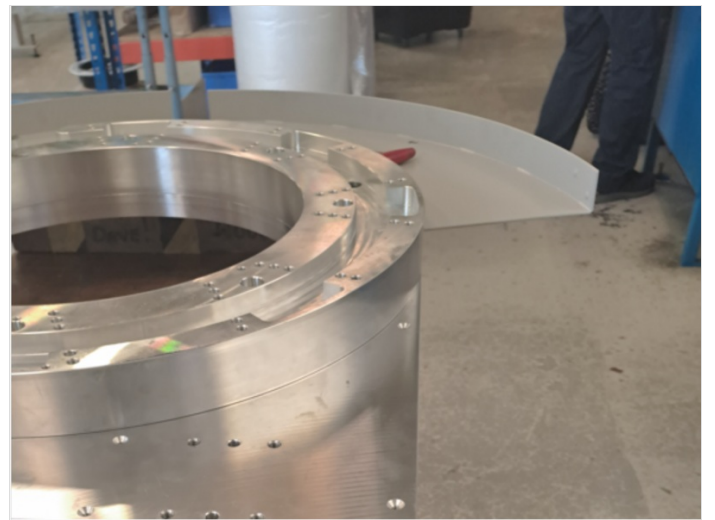
Mount D0007817 to main rotary base and fix with m5 x 10 countersink bolts



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## Step 8 - Fit D0003930

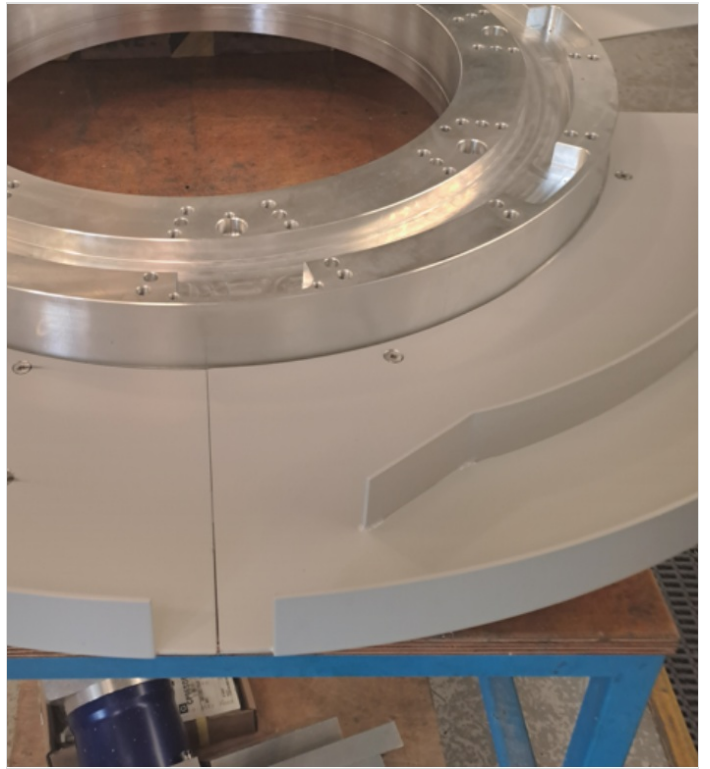
Mount D0003930 to main rotary base and fix with m5 x 10 countersink bolts



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## Step 9 - Fit D0003985

Mount D0003985 to main rotary base and fix with m5 x 10 countersink bolts




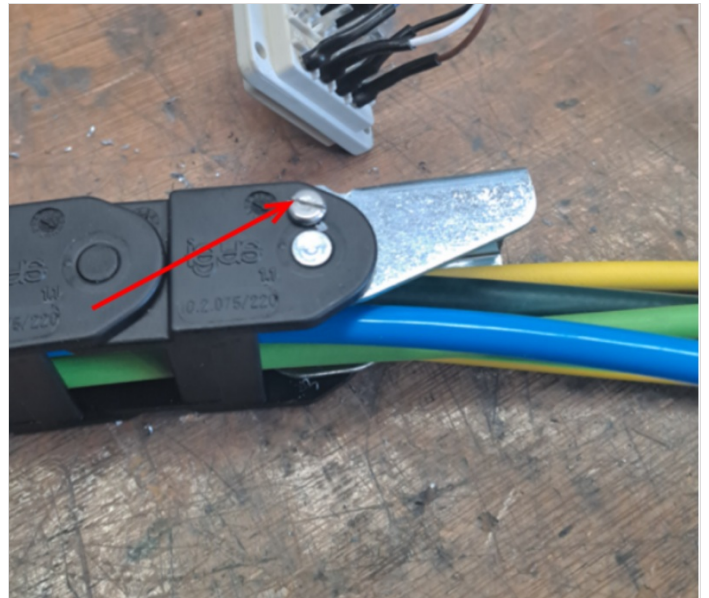


## Step 10 - Fit locking screw to energy chain

Drill and tap m3 to plugged end **ONLY** of energy chain assembly

Use m3 x 6 pan head bolt to secure

 ...Caution damage to cables is possible Use a shield over cables to protect

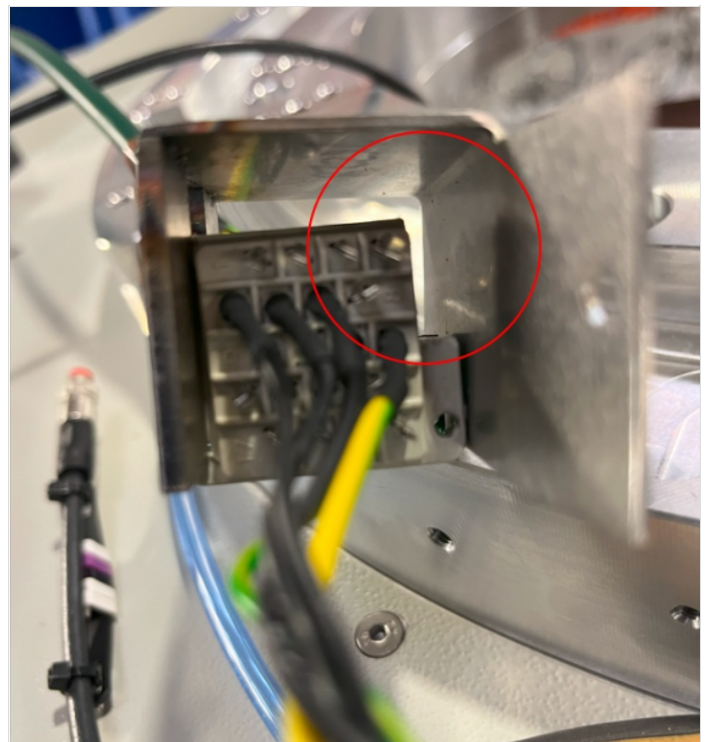


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## Step 11 - Clarification added to next step on position of cut out on connection plug

Please ensure the following step is noted and replicated

This is to ensure the cable and 6mm pipe are located in the correct area on assembly



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## Step 12 - Mount and mark Connection plug

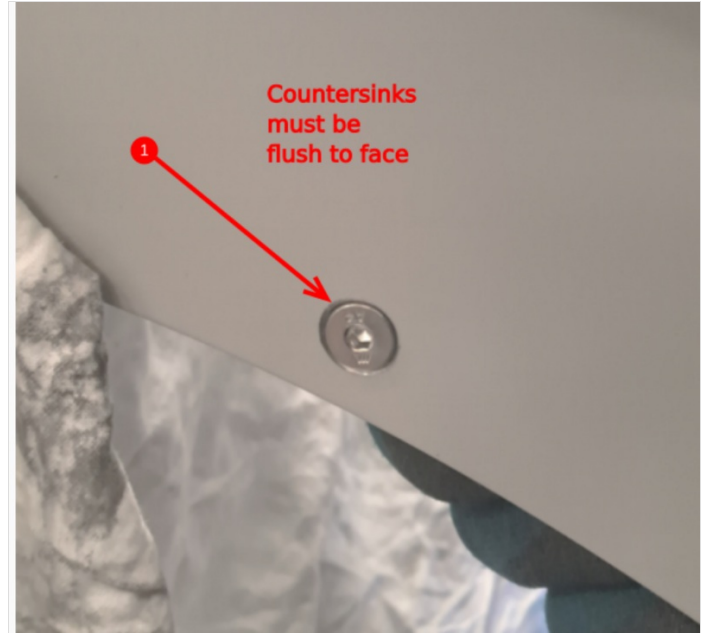
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# Step 13 - Prepare 1st guide Section

D0003985 needs preparing before fitting

1 All back plates for the rotary trunking need to be checked for correct countersink depth. Any protrusion from main face will cause energy chain failure

Check and if proud, use a countersink to increase depth



# Step 14 - Fit Energy chain mounting bracket

1 Measure position of bracket onto circular guard (291mm)

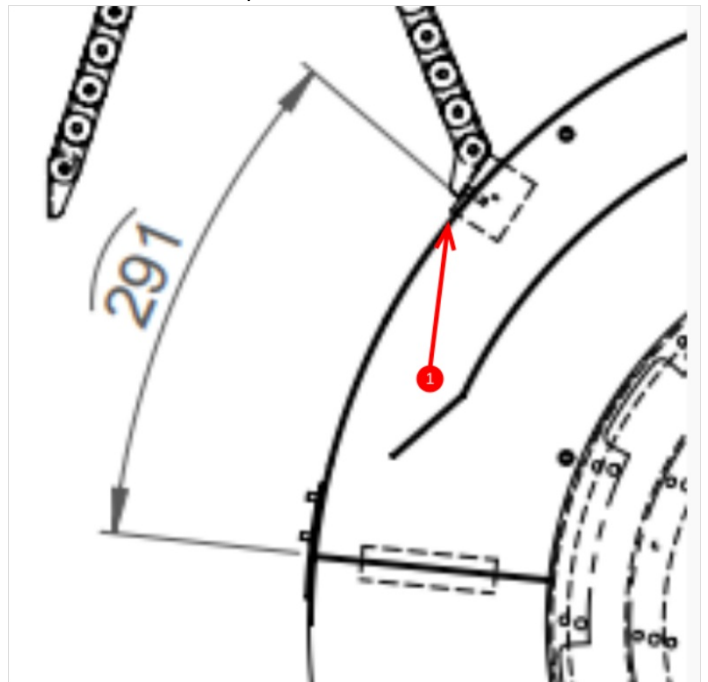
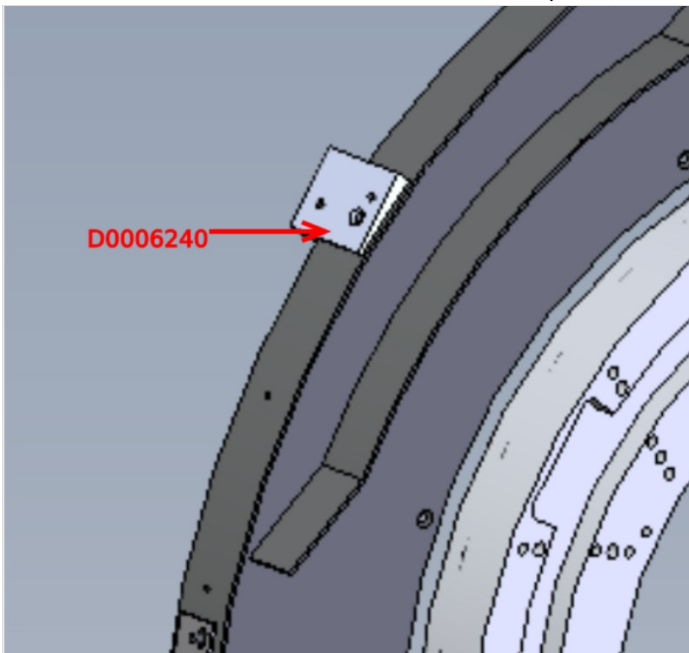
2 Use a pointed m5 grub screw screwed into bracket hole indicated, hold in position on guard, and use hide hammer to transfer position mark

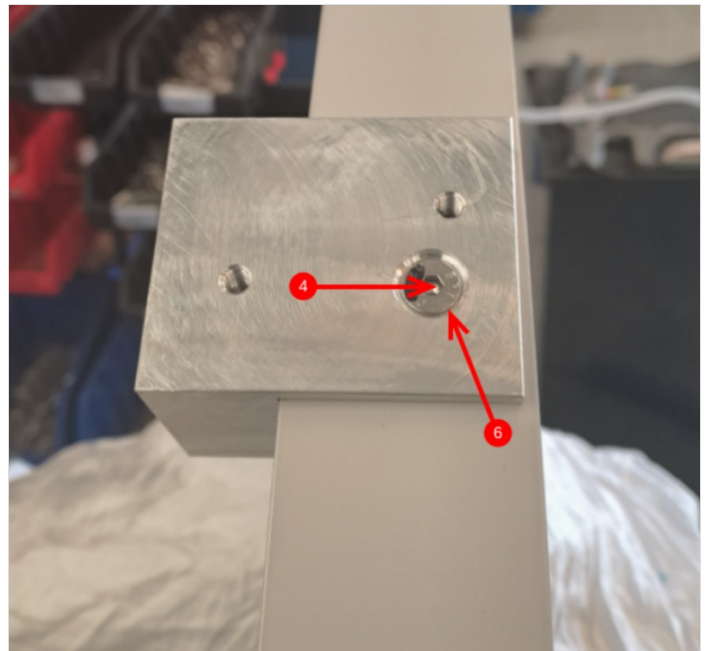
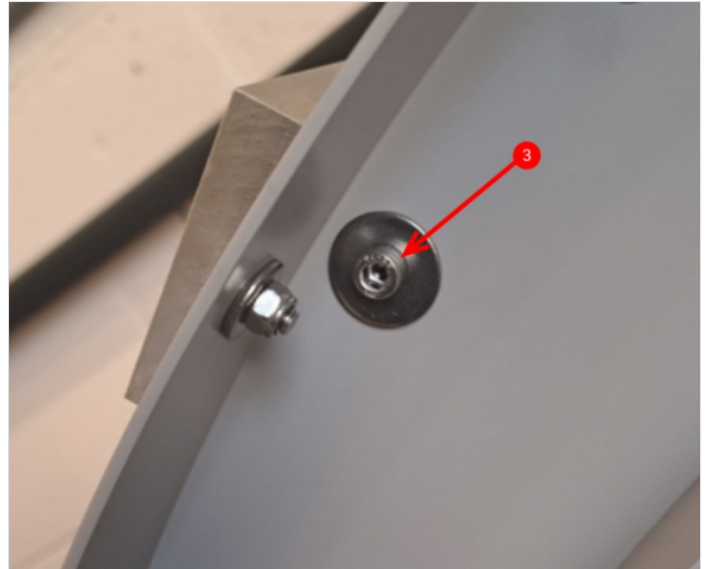
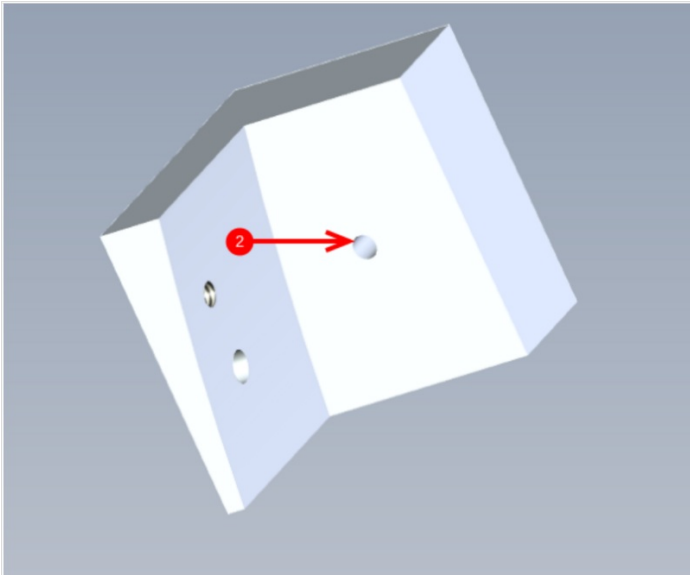
3 Drill to 6mm and fix bracket with m5x 16 cap head and large m5 washer

4 Drill 6mm through indicated hole

5 Fix with M5 x 16 countersink, large m5 washer and nyloc nut

6 This countersink bolt head must be flush to block. If proud, use a countersink bit to increase depth

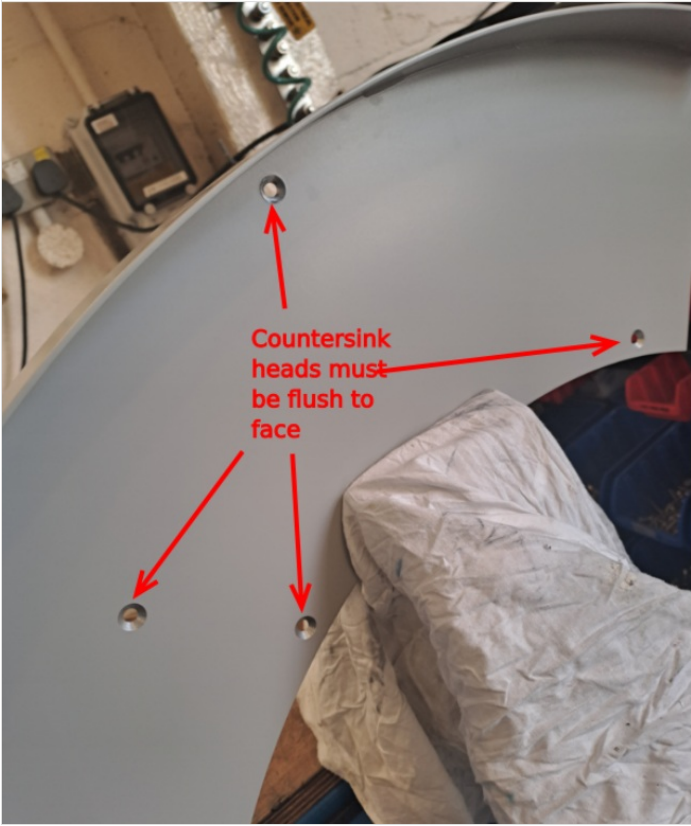




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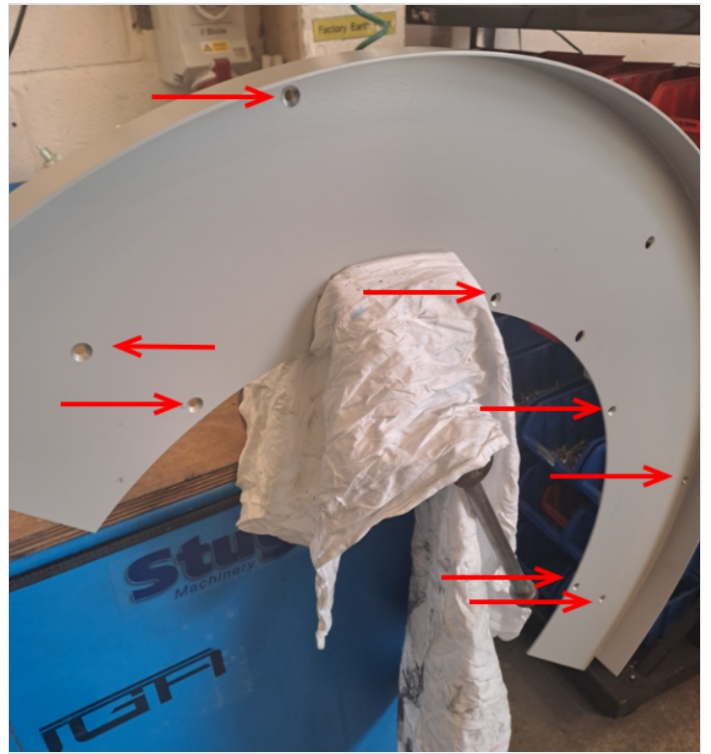
## Step 15 - Prepare second section

Check countersink holes in D0003930 are to the correct depth.  
Rework with countersink if fasteners sit proud.



## Step 16 - Prepare 3rd section

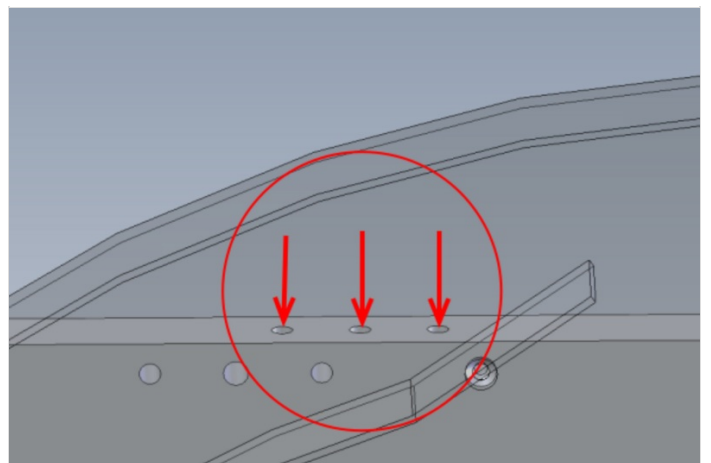
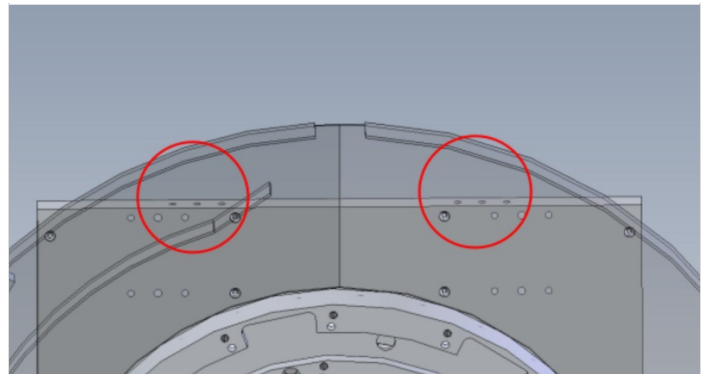
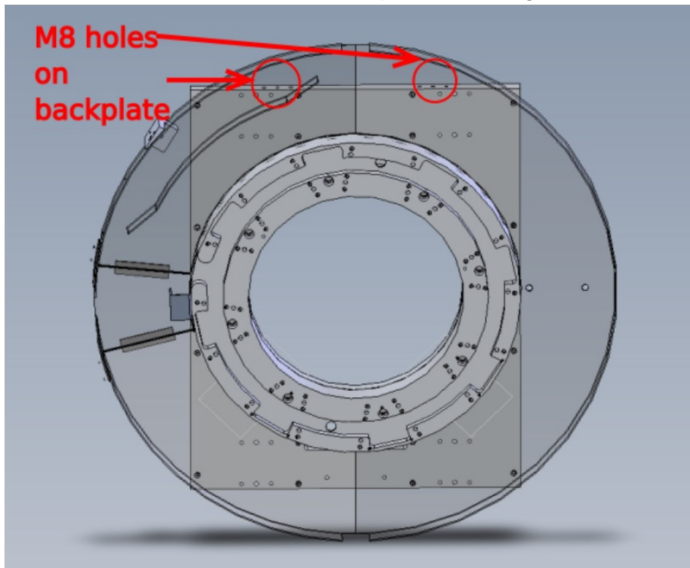
Check countersink holes in D0007817 are to the correct depth .  
Rework with countersink if fasteners sit proud.



## Step 17 - Orientation

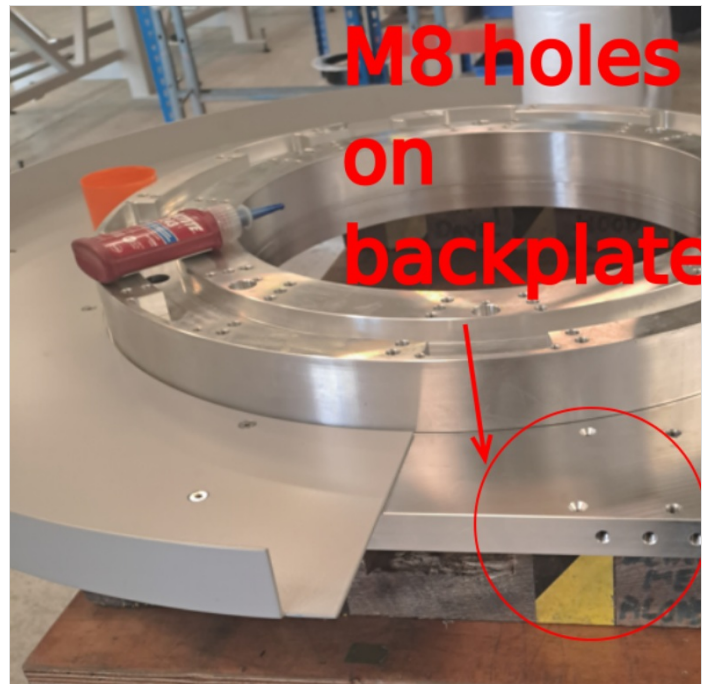
It is vital to achieve correct orientation of above parts

Use M8 holes indicated as reference point for fitting



## Step 18 - Fit D0007817

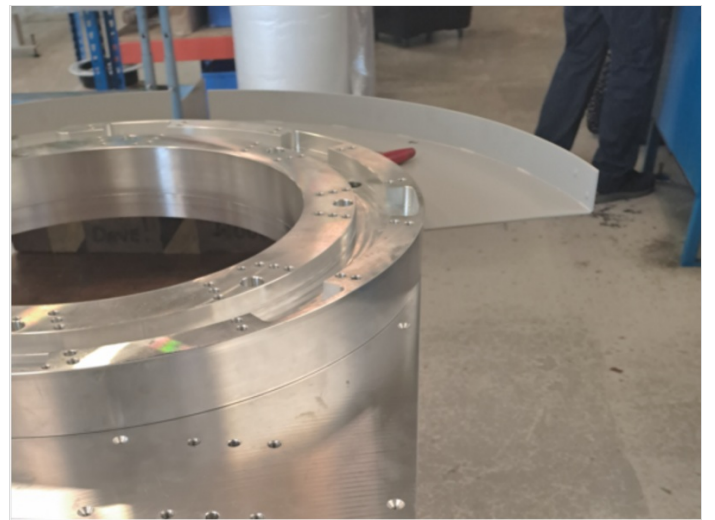
Mount D0007817 to main rotary base and fix with m5 x 10 countersink bolts



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## Step 19 - Fit D0003930

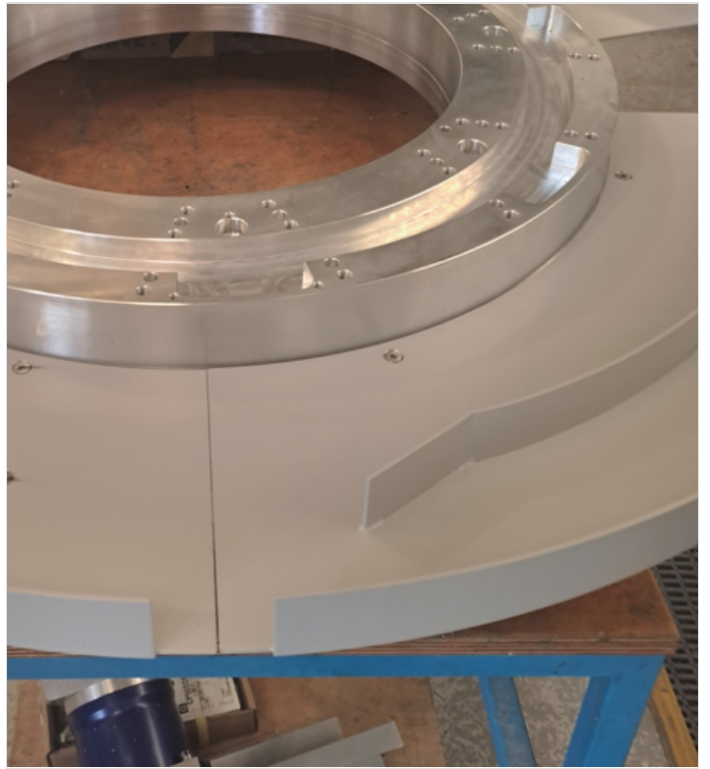
Mount D0003930 to main rotary base and fix with m5 x 10 countersink bolts



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## Step 20 - Fit D0003985


Mount D0003985 to main rotary base and fix with m5 x 10 countersink bolts

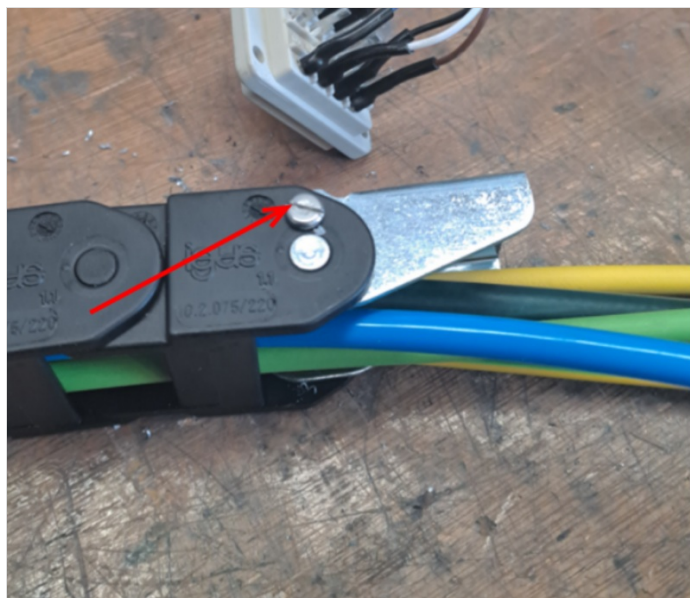


## Step 21 - Fit locking screw to energy chain

Drill and tap m3 to plugged end **ONLY** of energy chain assembly

Use m3 x 6 pan head bolt to secure

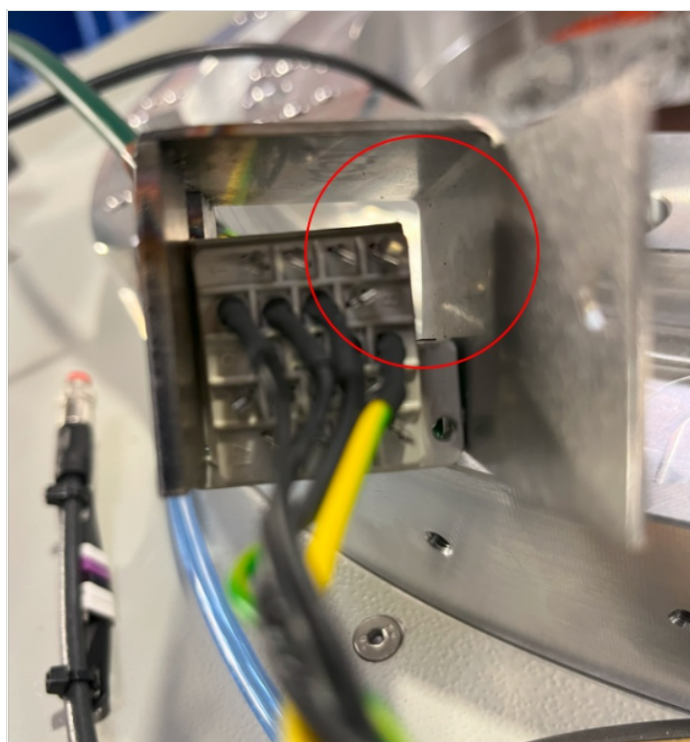
 ...Caution damage to cables is possible Use a shield over cables to protect



## Step 22 - Clarification added to next step on position of cut out on connection plug

Please ensure the following step is noted and replicated

This is to ensure the cable and 6mm pipe are located in the correct area on assembly



## Step 23 - Mount and mark Connection plug

1 Fit pre assembled R0015304B energy chain assembly plug connection into bracket D00001171 as shown. Note plug has 2 different widths, larger width must be captivated in bracket to ensure secure fitting

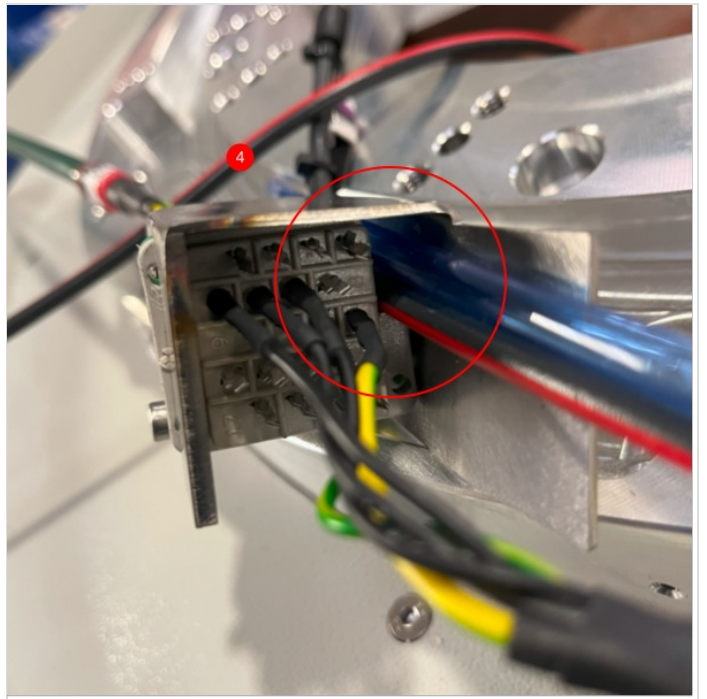
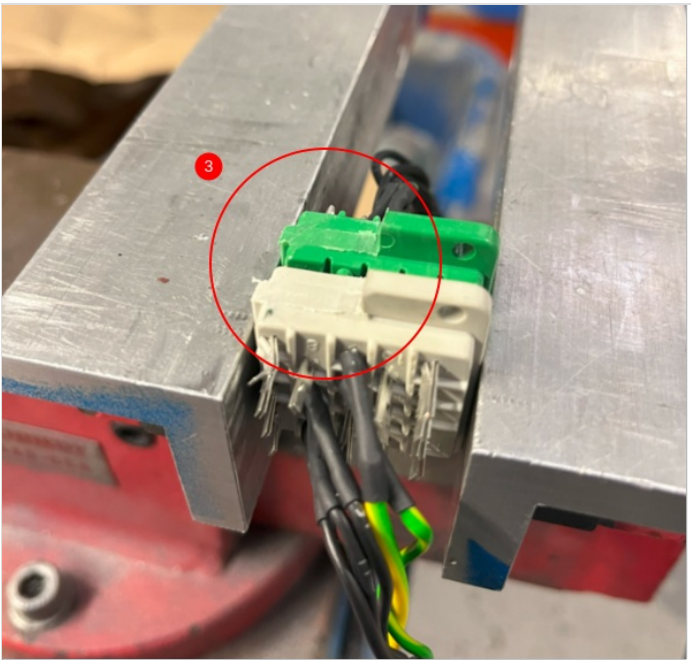
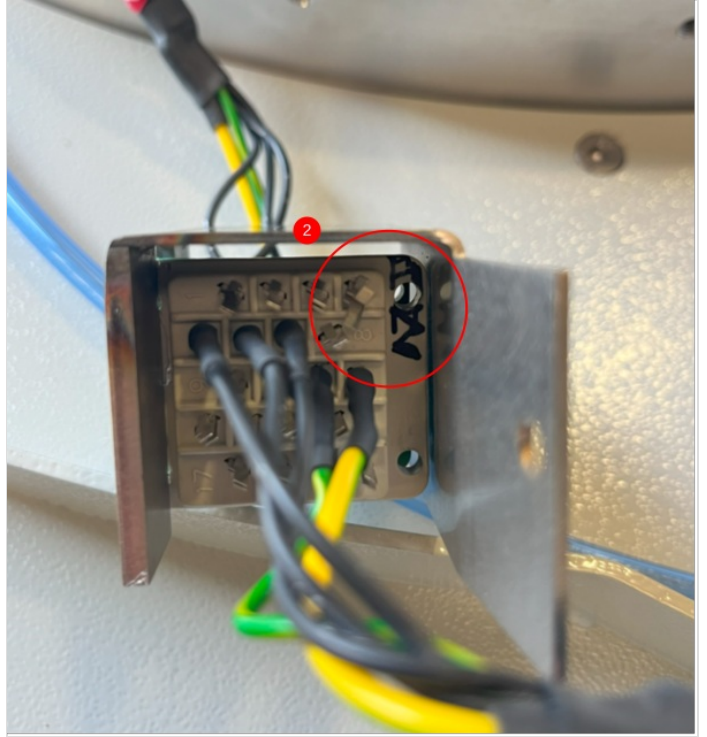
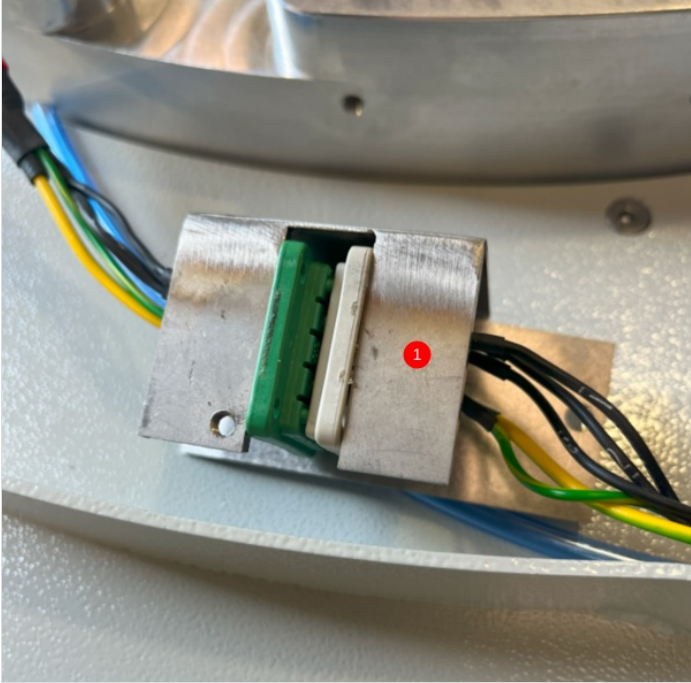
2 Mark the indicated area

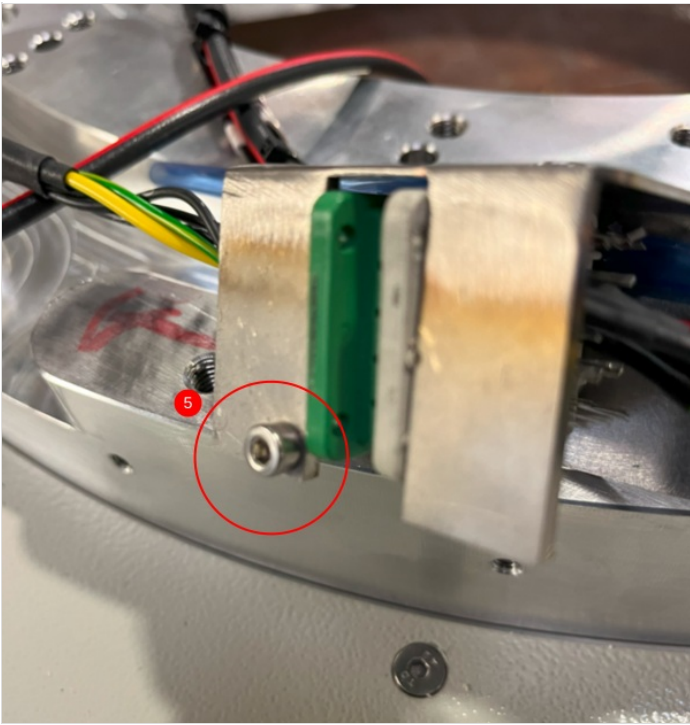
3 Remove plug connection from bracket and remove marked area using hacksaw and dress with file

4 Refit to bracket, captivating ethercat cable and 6mm blue pipe from energy chain assembly as shown

5 Secure with M4 x 12 socket cap

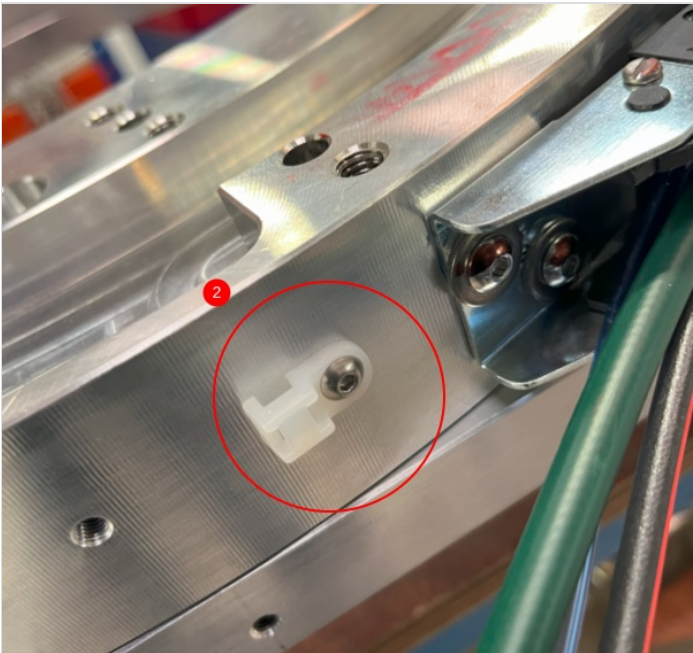
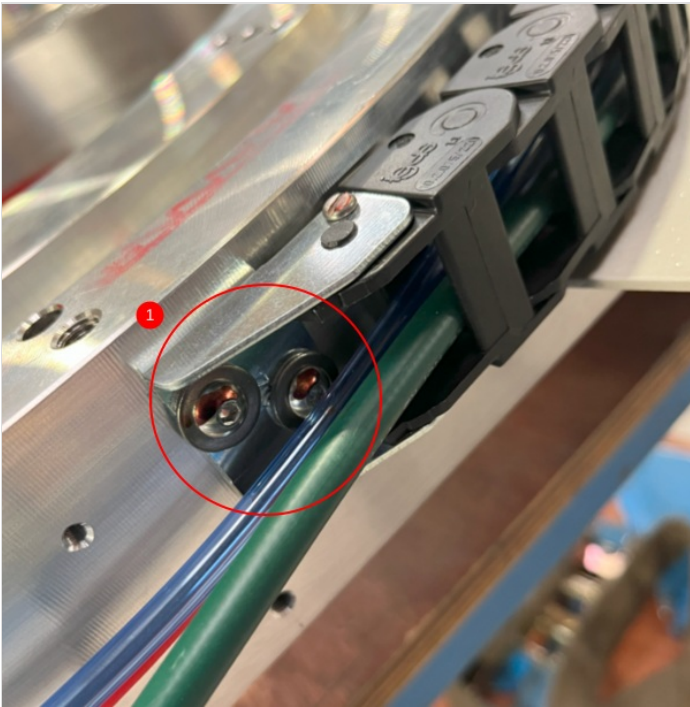






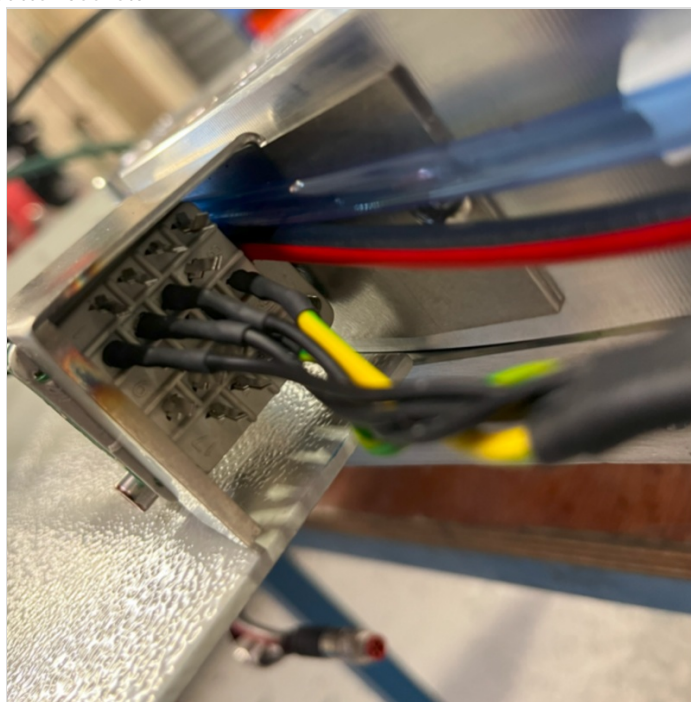
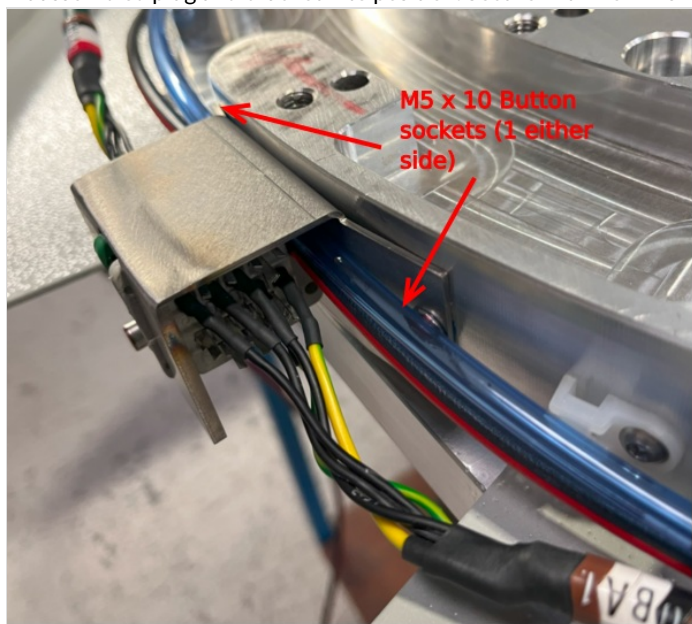
### Step 24 - Mount energy chain

- 1 Fix energy chain bracket as shown using 2 off m5 x 10 button heads and heavy washers
- 2 Add cable retention point. Fit small A0000248 tie base and secure with M4 x 6 button head



## Step 25 - Mount plug bracket

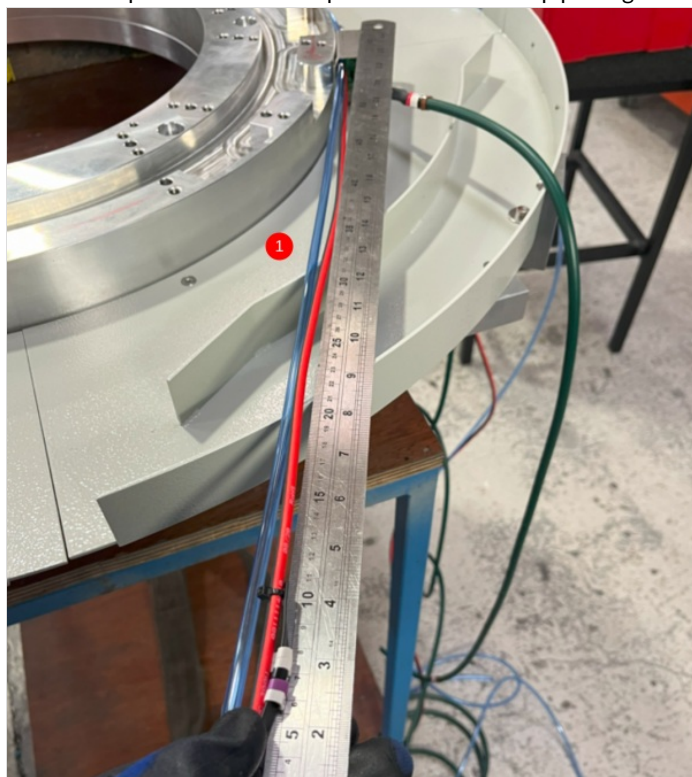
Fit assembled plug and bracket into position. Secure with 2 off M5 x 10 button sockets

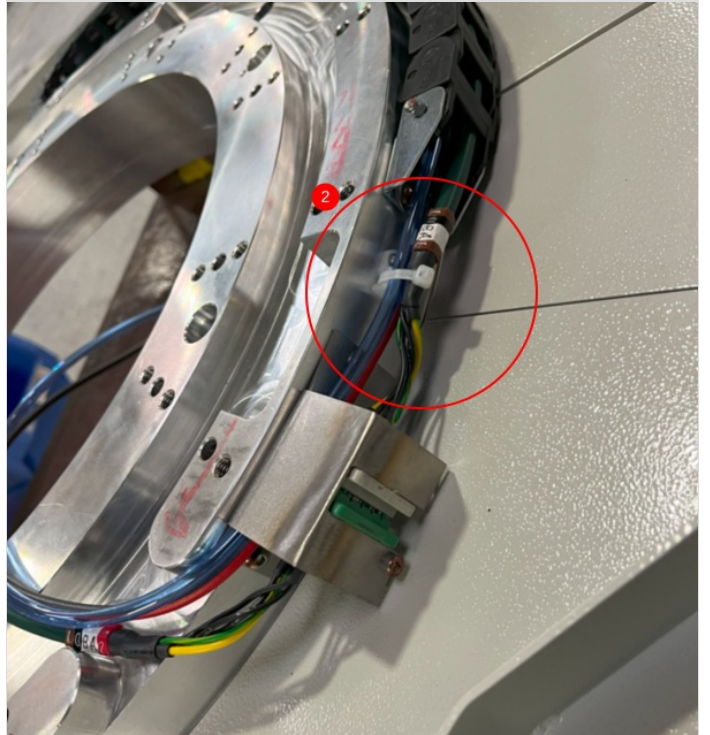


## Step 26 - Finalise energy chain cables

1 Set ethercat cable and 6mm blue pipe to the length shown of 580mm

2 Fit tie wrap to cable restraint point once cable and pipe length are set





## Step 27 - Fit Access panel

- 1 Slide access panel into position
- 2 Fix energy chain to panel with m5 x 16 button heads, washers and nyloc nuts

