


R0000713E Bench Assemble R Axis Limit Assembly

Bench assembly details for R axis limit stop

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set

38mm spanner

Parts Required

B0000122 Glacier Bush 12 D 14 D 15 Long x 4

D0007454 Stop Sub Base OH (D8377) x 1

D0007455 Stop Damper Housing OH (D8378) x 1

D0008377 Stop Sub Base (D7454) x 1

D0008378 Stop Damper Housing (D7455) x 1

D0008380E Stop Slide Finger ZX4 Mk5 x 1

D0008383 Cross Joiner x 1

D0010756 Proximity Switch Mounting Block Reduced Size x 1

E0000336 Sensor: M8; 2mm, PNP N/O, M8 conn x 1

H0008379 Shaft 12mm: 263mm R Axis Limit Stainless x 2

P0000235 MC Series self compensating Damper x 2

Step 1 - Unless otherwise stated

All bolts must have Loctite 243 adhesive unless otherwise stated.

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



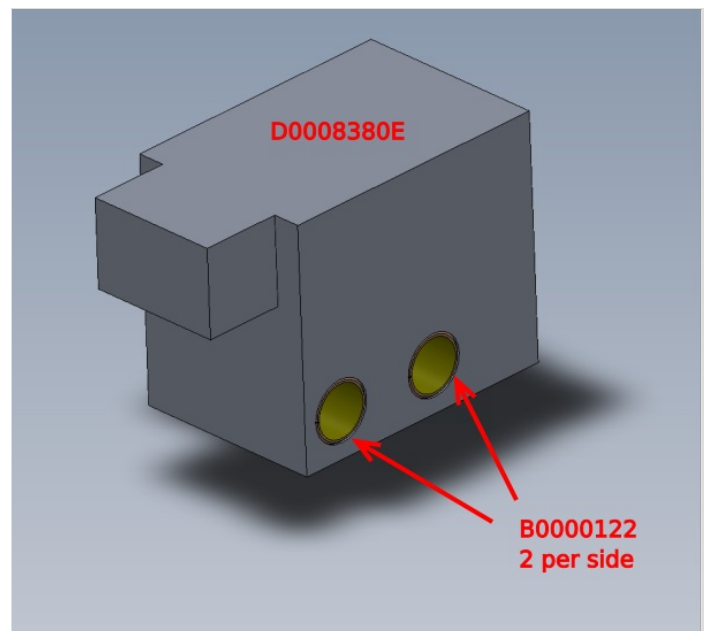
Step 2 - Fit bushes

Fit 4 off B0000122 bushes to block D0008380E as shown

Bushes must be pushed flush to face

Check internal diameter of bushes once fitted by using 1 off H0008379 Shaft 12mm

If fit is tight, use 12mm hand reamer to clean bore to 12mm



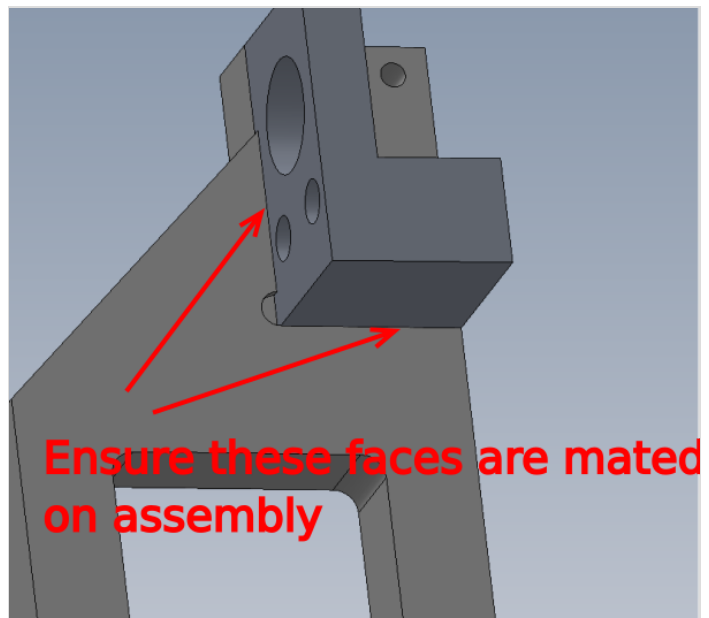
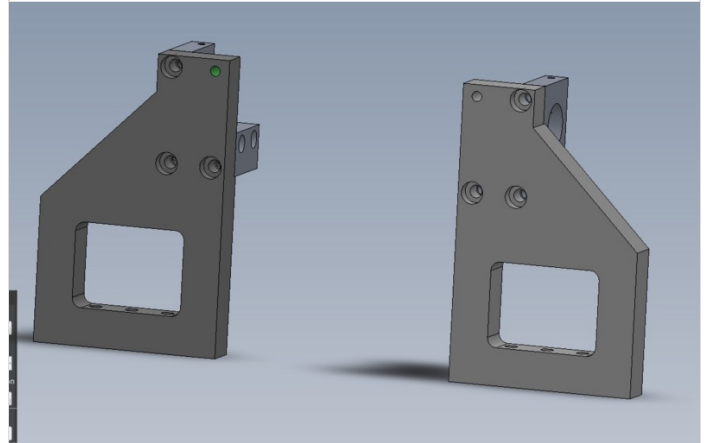
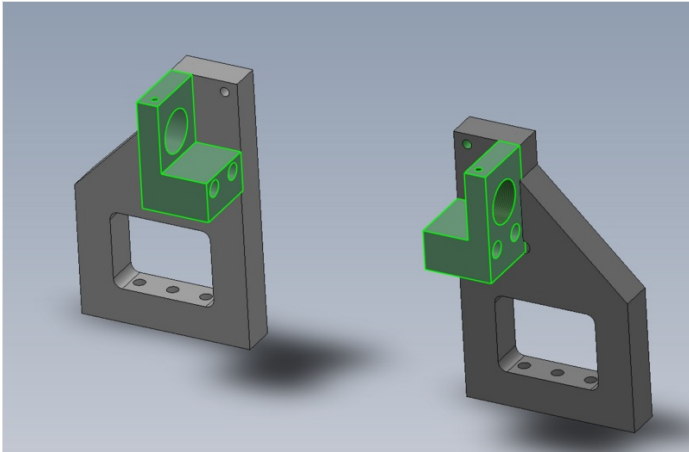
Step 3 - Assemble damper stop housings

Use 6 off M8 x 30 socket caps to fix

D0007455 Stop Damper Housing OH to D0007454 Stop Sub Base OH

D0008378 Stop Damper Housing to D0008377 Stop Sub Base

Ensure indicated faces are mated together on assembly

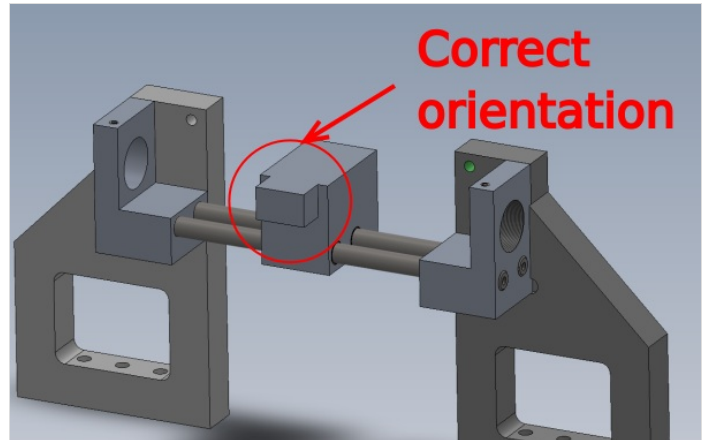
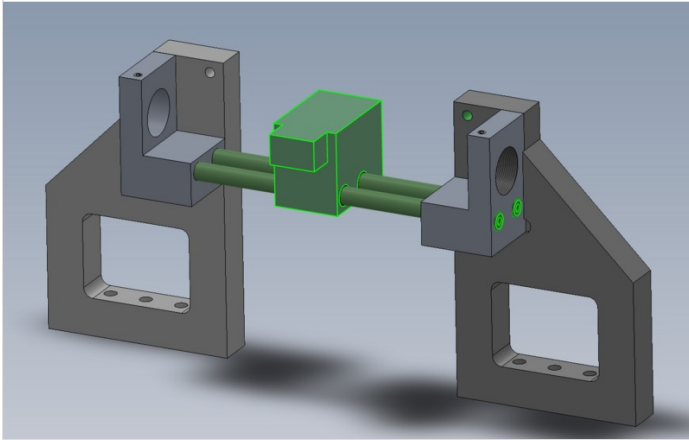


Step 4 - Insert shafts and slide finger

Assemble as shown 2 off H0008379 Shaft 12mm: 263mm R Axis Limit Stainless x 2 and pre assembled slide finger block

Do not add fixings yet

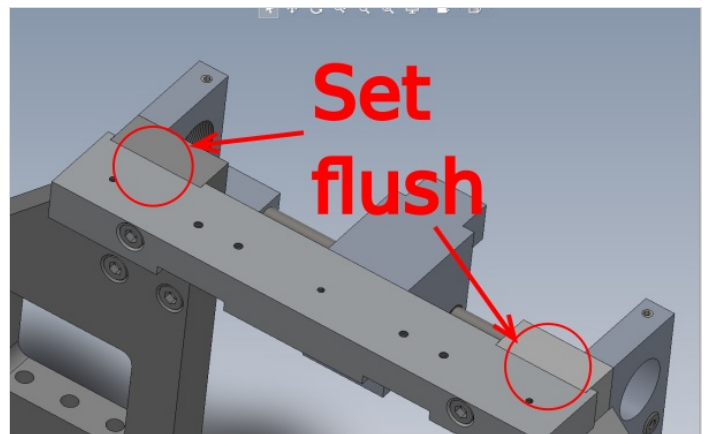
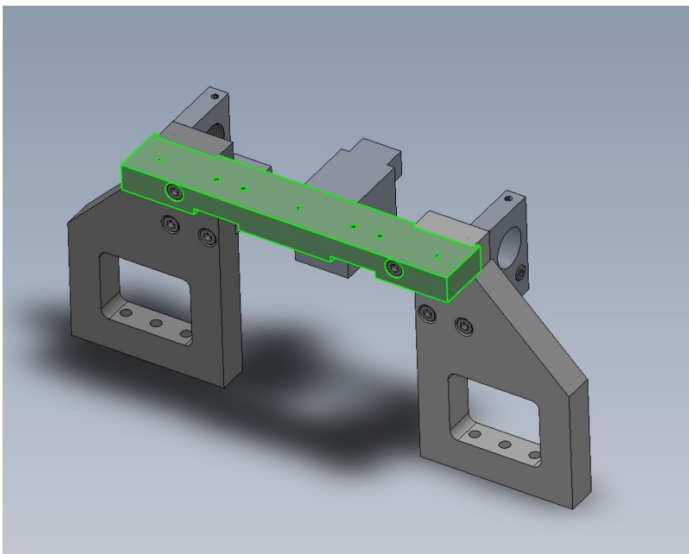
Ensure slide finger is orientated the correct way



Step 5 - Fit Cross joiner

Use 2 off M8 x 50 socket caps to fit D0008383 Cross Joiner as shown

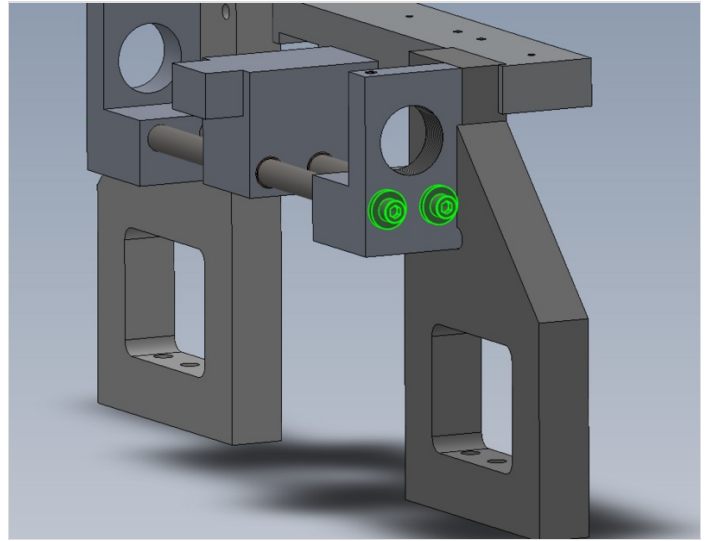
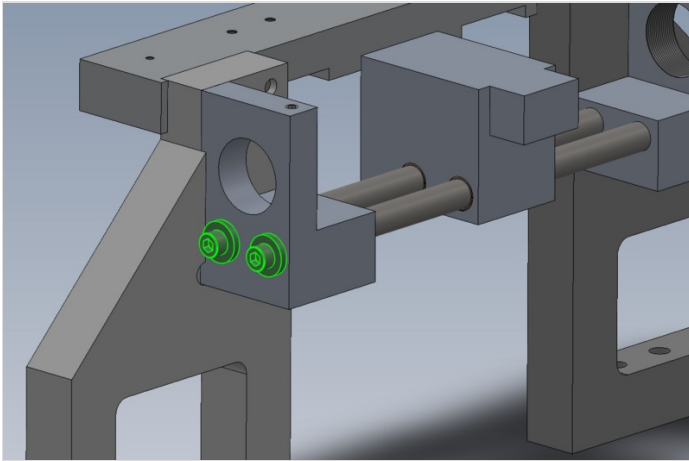
Ensure indicated faces are set flush



Step 6 - Fix shafts

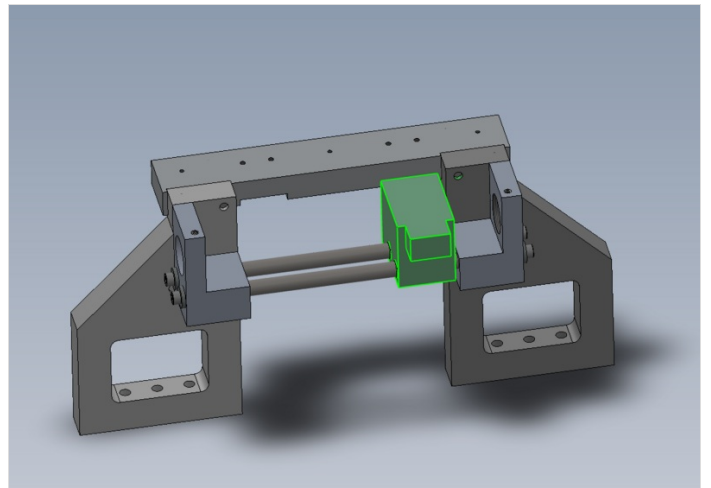
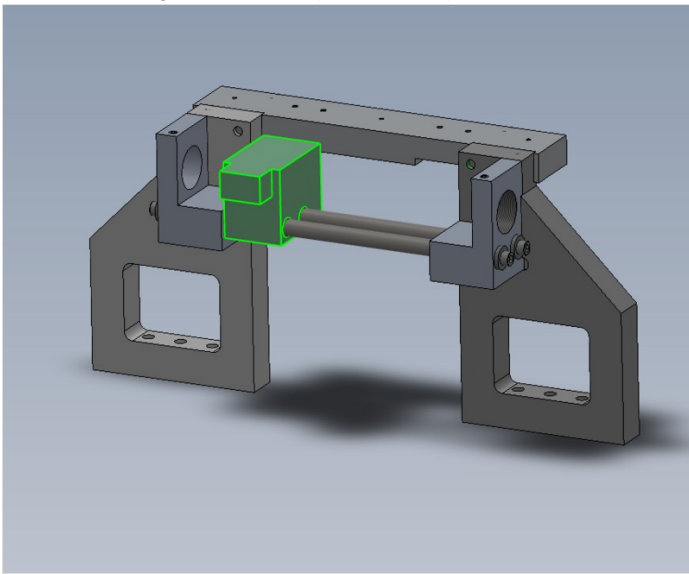
Use 4 off M6 x 16 socket caps and heavy M6 washers to fix shafts as shown

Note, slight shaft float will be present, this is normal



Step 7 - Quality check

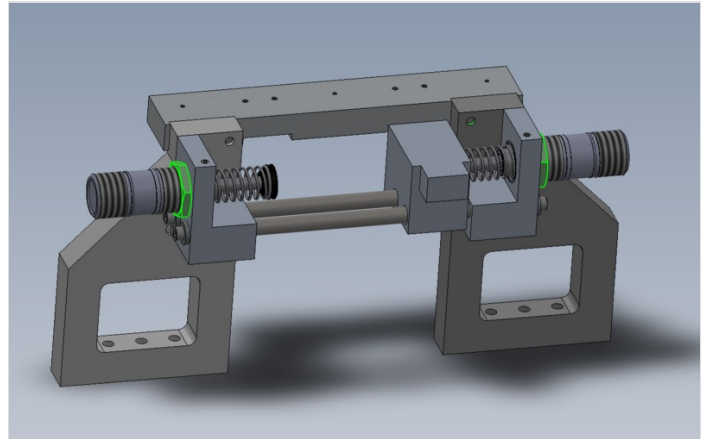
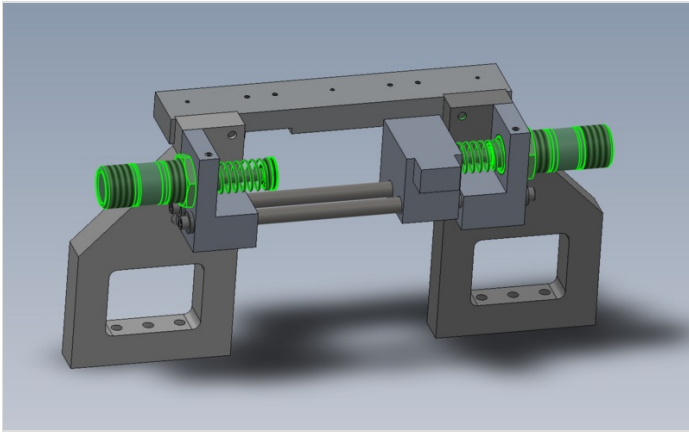
Ensure slide finger moves freely between 2 points indicated



Step 8 - Fit dampers

Fit 2 off P0000235 dampers as shown

Position lock nuts on the indicated faces

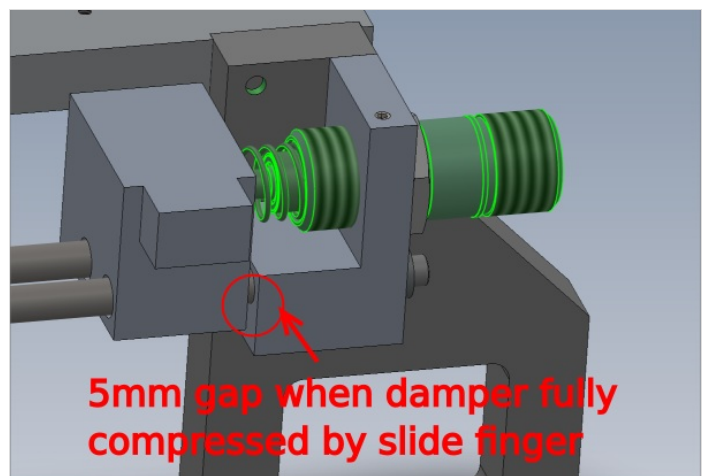


Step 9 - Damper setting

Set dampers to the following spec

With damper fully compressed, a 5mm gap should be present at the indicated point

Set both sides to the same setting



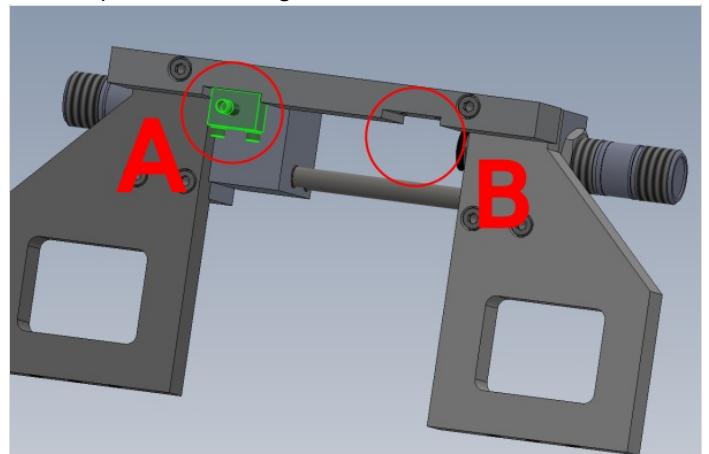
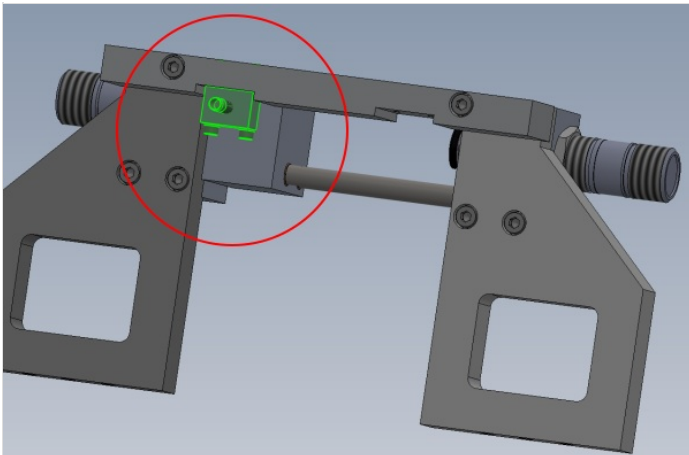
Step 10 - Fix datum sensor block

Orientation

For R-L machines fit to point A

For L-R machines fit to point B

Use 2 off M5 x 40 socket caps with A form washers to secure D0010756 Proximity Switch Mounting Block as shown

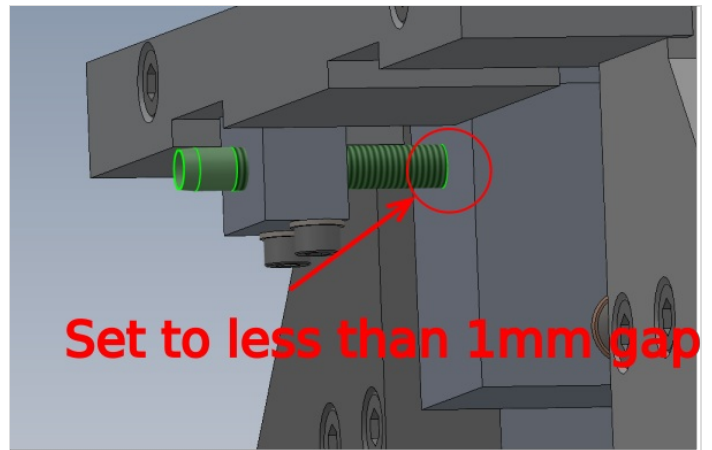


Step 11 - Set Sensor

Adjust sensor to read indicated face.

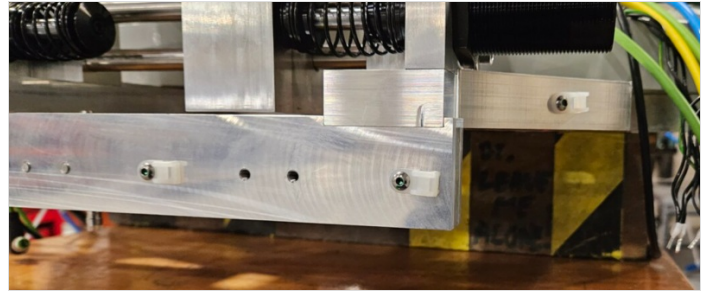
Set gap to -1mm

Ensure sensor lock nut is not over tighten when finalising



Step 12 - Fit tie bases

Fit cable tie bases with M4 x 6 button sockets



Step 13 - Ensure all bolts are finalised

Double check all bolts are tensioned and marked

