

R0002916 Install Machine Trunking

Fitment of trunking to main frame

 Difficulty **Medium**

 Duration **6 hour(s)**

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Clean threads

Step 3 - Mount lower trunking

Step 4 - Assemble upright 1

Step 5 - Assemble upright 2

Step 6 - Drill assembled uprights to frame vertical face

Step 7 - Fix horizontal section

Step 8 - Assemble upright 3 and 4

Step 9 - Fix to frame

Step 10 - Cut lids

Step 11 - Fit wire basket to rear

Step 12 - Additional holes Upright 1

Step 13 - Additional holes Upright 2

Step 14 - Additional holes Upright 3

Step 15 - Additional holes Upright 4

Step 16 - Additional holes Lower section 1

Step 17 - Fit edging strip M0000031

Step 18 - Fit A0000234 20mm grommits

Comments

Introduction

Tools Required

Standard hex key set

Standard spanner set

Standard HSS drill set

Standard tap set

Disc cutter

Parts Required

A0000068 Top lid gusset 50x50 bend 90° Armorduct x 4

A0001065 wire basket x 0.5

A0001061 Retainer: Wire Basket Cable Tray x 2

D0000301 M/C centre trunking front lower ZX4 x 1

D0000305 M/C centre trunking rear lower ZX4 x 1

- D0000306 M/C centre trunking infeed lower (D8736) x 1
- D0000307 M/C centre trunking infeed front offset x 1
- D0000308 M/C centre trunking infeed rear offset x 1
- D0000309 M/C centre trunking outfeed front offset x 1
- D0000313 M/C centre trunking outfeed rear offset x 1
- D0000324 M/C centre trunking outfeed front upper x 1
- D0000325 M/C centre trunking infeed front upper x 1
- D0000326 M/C centre trunking front drop x 2
- D0000327 M/C centre trunking outfeed lower x 1
- D0000329 M/C centre trunking infeed rear end x 1
- D0000694 M/C centre trunking outfeed rear end x 1
- D0007996 Trunking support pillar 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 - Clean threads

All holes on machining centre frame require threads cleaning to remove debris from coating process



Step 3 - Mount lower trunking

Use the following parts

D0000301 M/C centre trunking front lower ZX4 x 1

D0000306 M/C centre trunking infeed lower (D8736) x 1

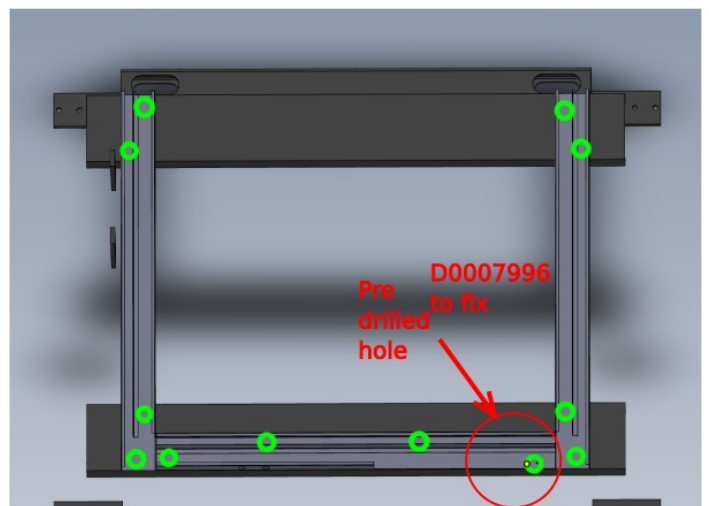
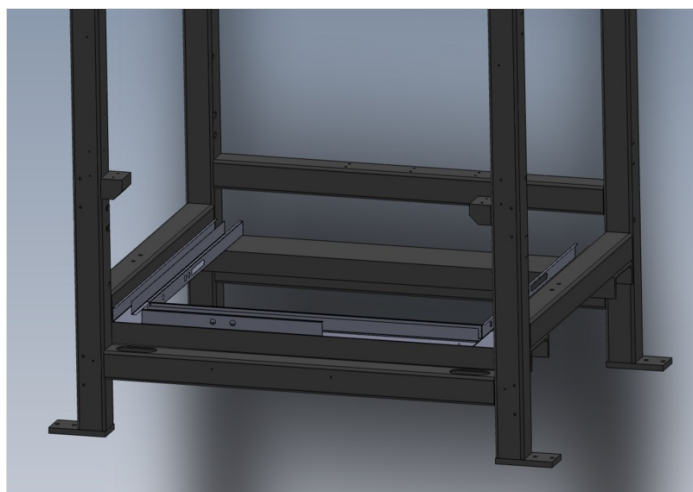
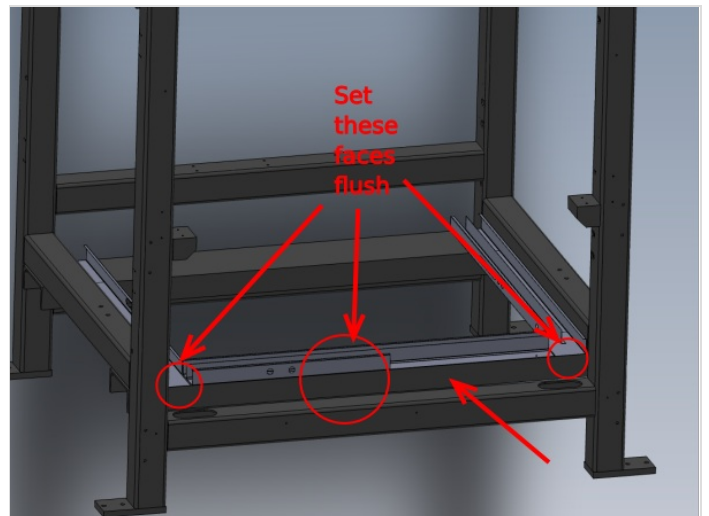
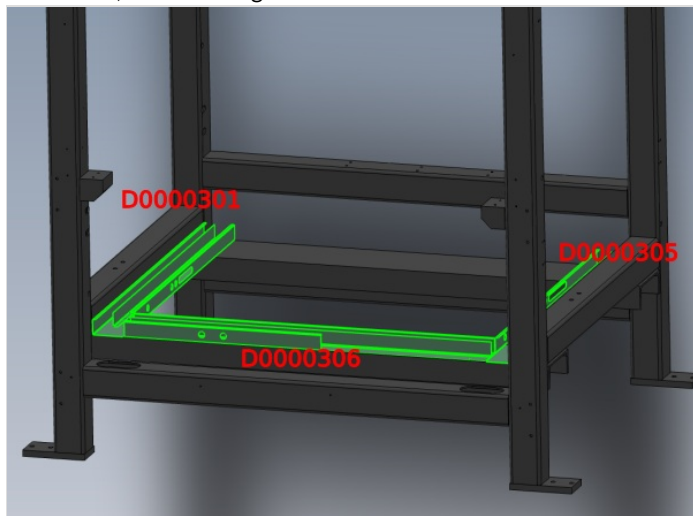
D0000305 M/C centre trunking rear lower ZX4 x 1

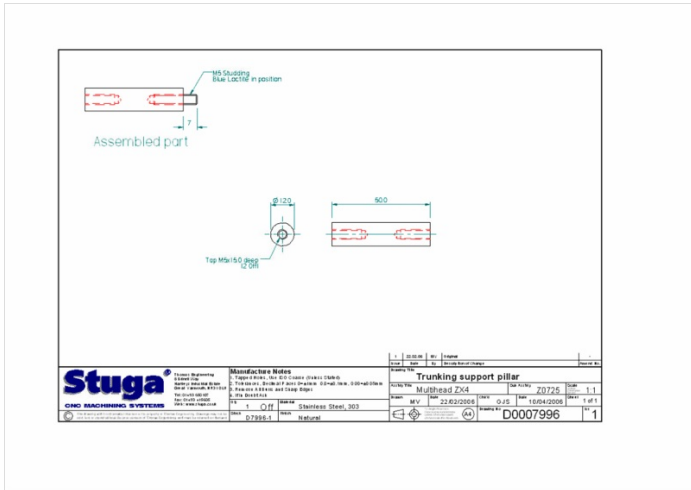
Add 6mm clearance holes to each piece of trunking as indicate to allow M5 fixings to be added to frame frame . Note hole indicated is pre drilled in trunking

Once clearance holes are added to trunking, position trunking as shown and drill and Tap M5 . Use M5 x 16 button sockets and penny washer to fix.

On the pre drilled hole use D0007996 Trunking support pillar x 1 to fix to frame

Once fixed, refit trunking lids to mounted sections

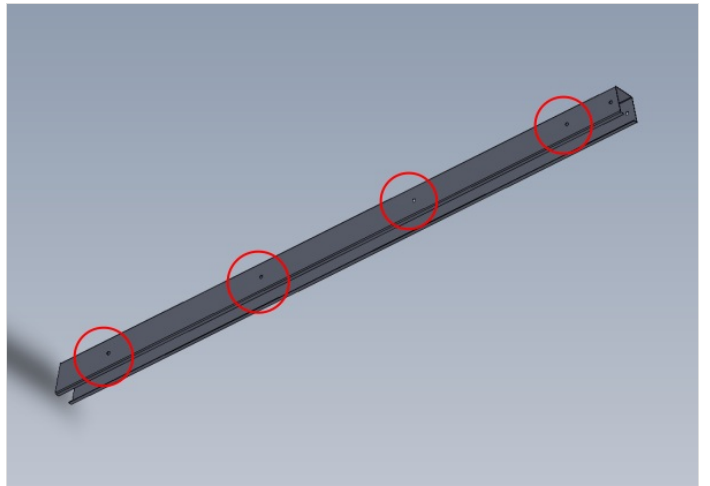
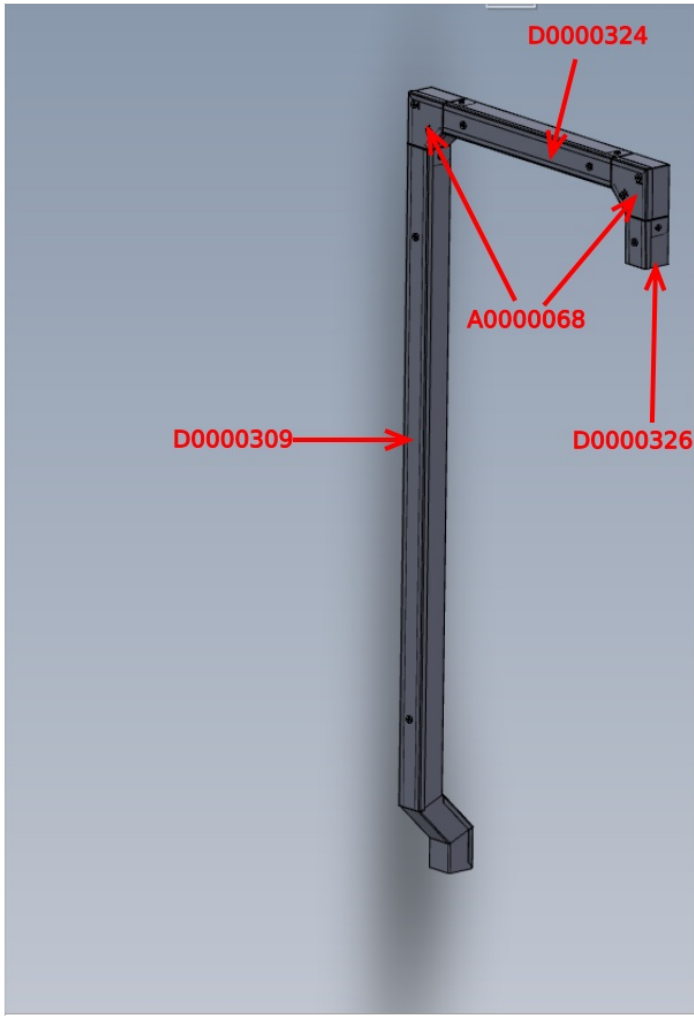




Step 4 - Assemble upright 1

Bench assemble trunking as shown

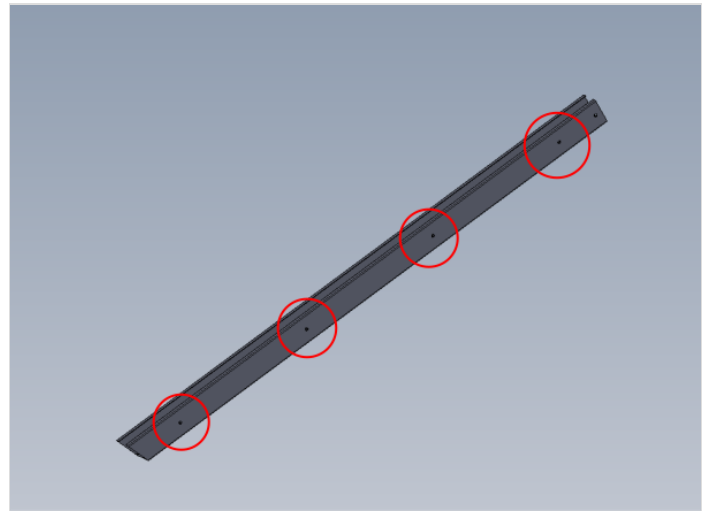
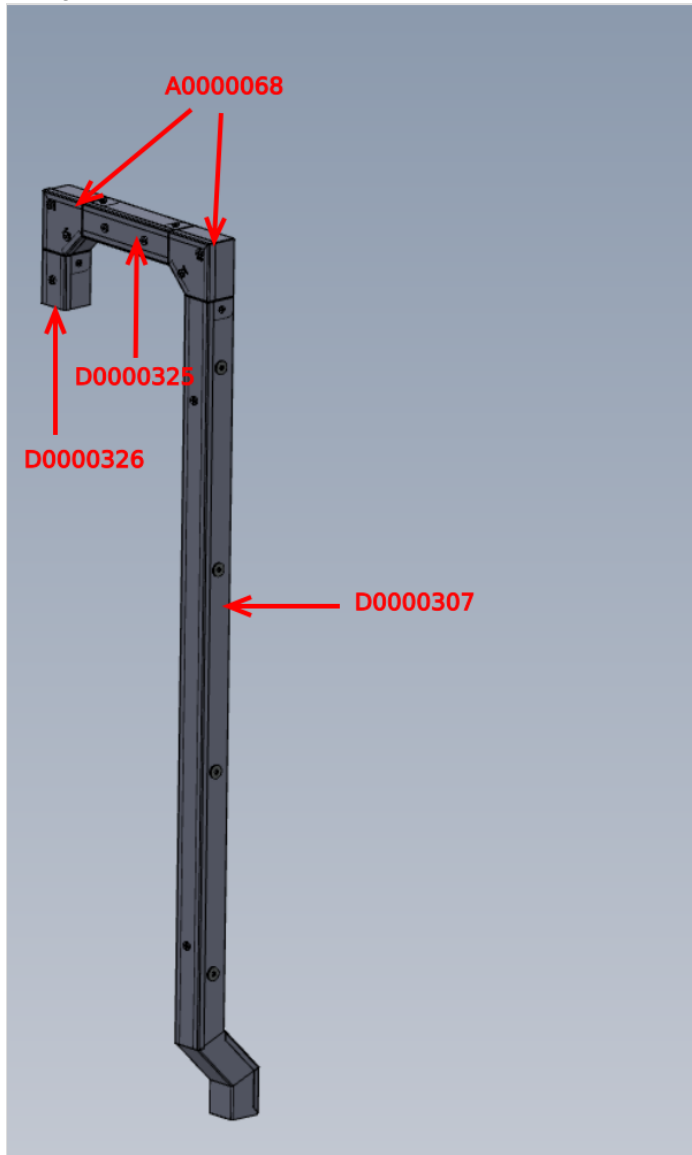
Enlarge holes indicated to 7mm diameter



Step 5 - Assemble upright 2

Bench assemble trunking as shown

Enlarge holes indicated to 7mm diameter



Step 6 - Drill assembled uprights to frame vertical face

Position as shown

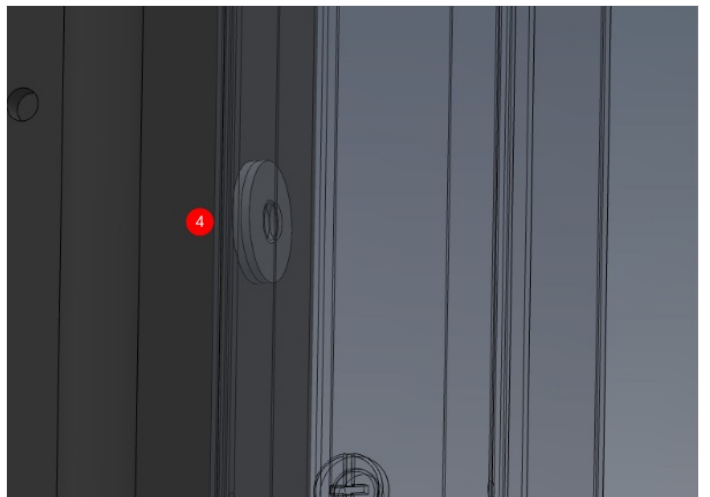
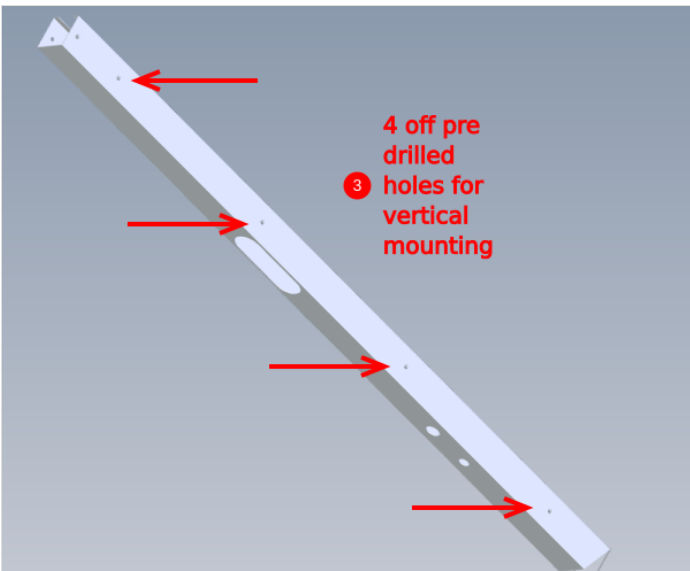
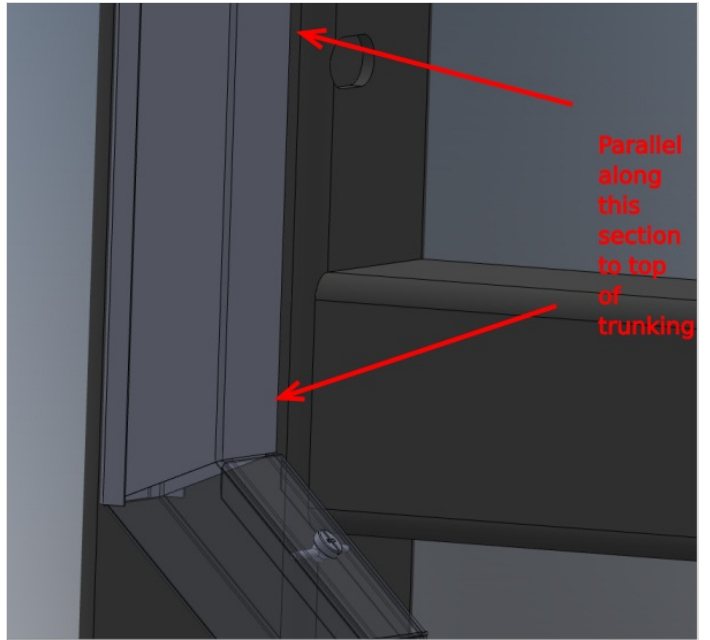
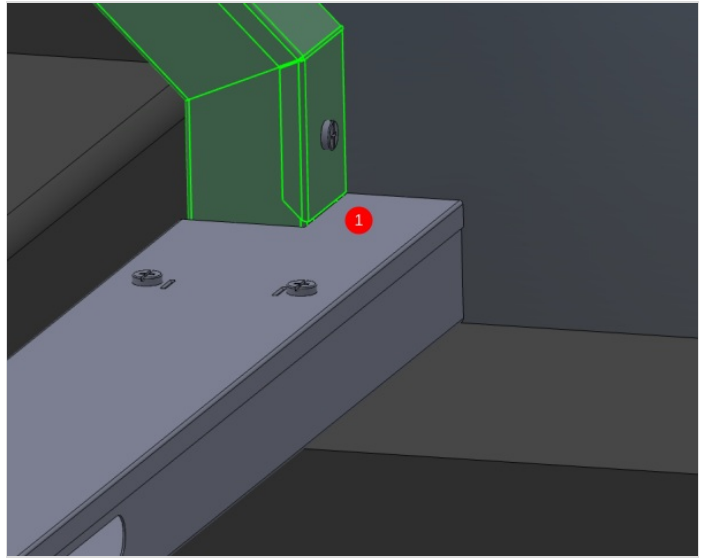
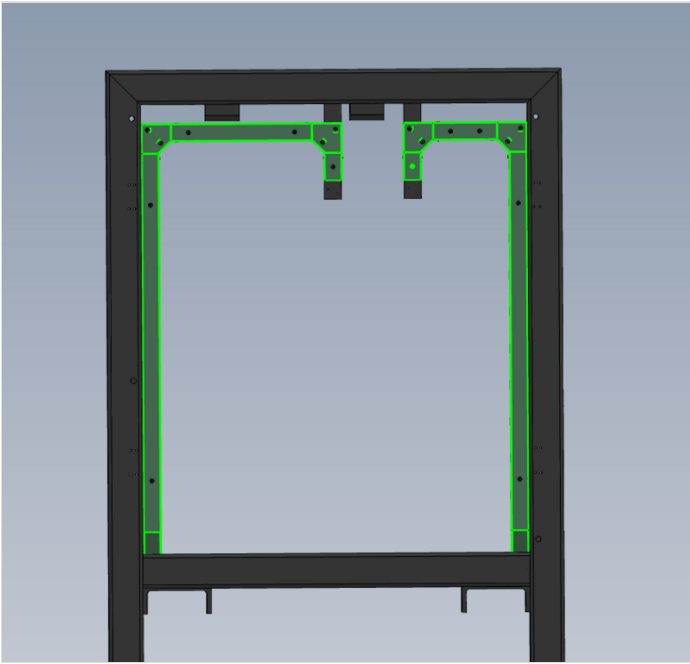
1 Align to lower trunking cutout

2 Ensure indicated face is parallel along upright

3 Mark off through trunking and then drill 4 off M6 tapped holes into frame

4 Secure trunking to vertical face using M6 hex sets and penny washers. Use a M6 motor plate between trunking and frame to space trunking away from frame to allow lid fitment

Repeat for both assembled uprights



Step 7 - Fix horizontal section

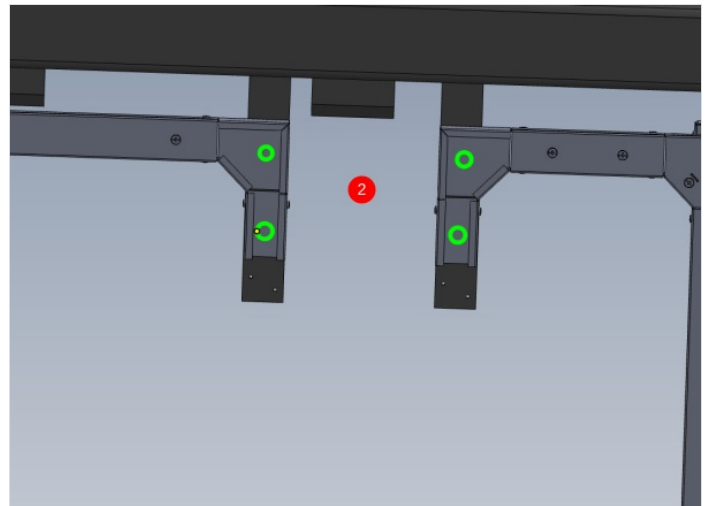
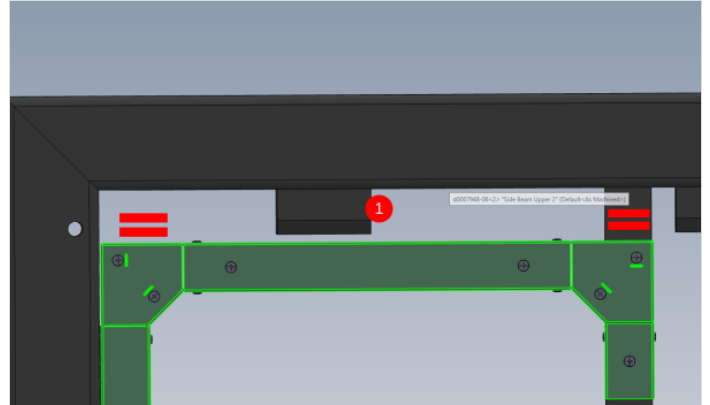
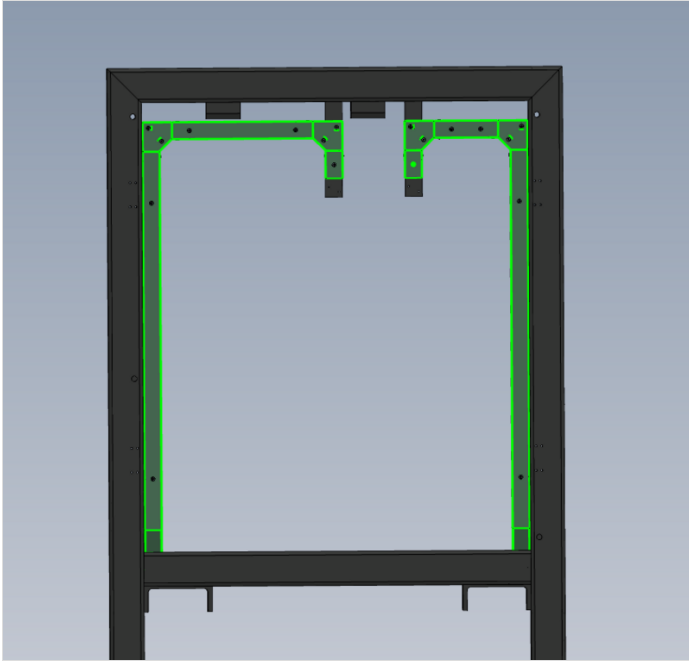
1 Ensure indicated faces are set to equal measurement

2 Drill 4 off indicated holes to secure trunking to vertical frame drops.

Drill trunking 6mm diameter clearance

Tap vertical drops M5

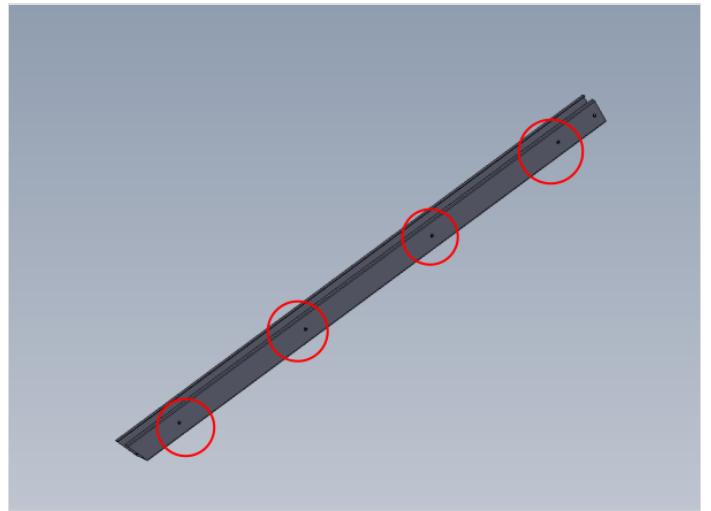
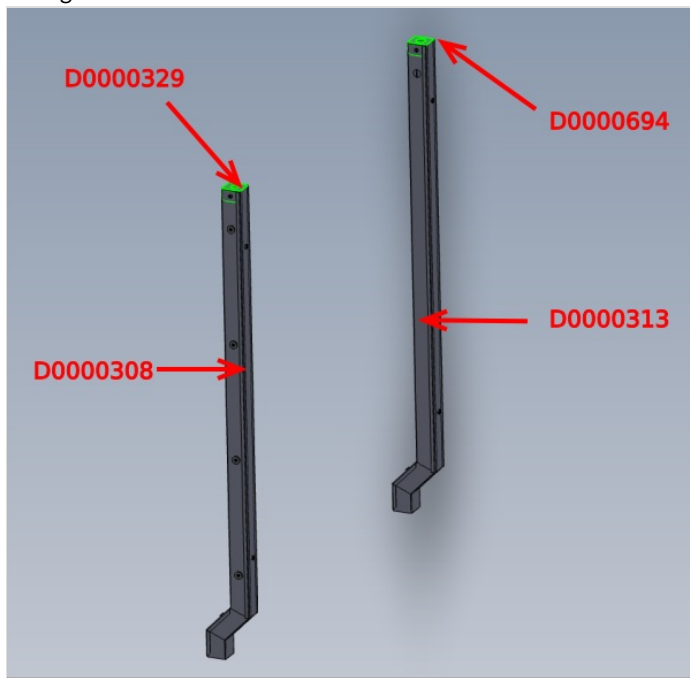
Secure with M5 x 10 button sockets and penny washers



Step 8 - Assemble upright 3 and 4

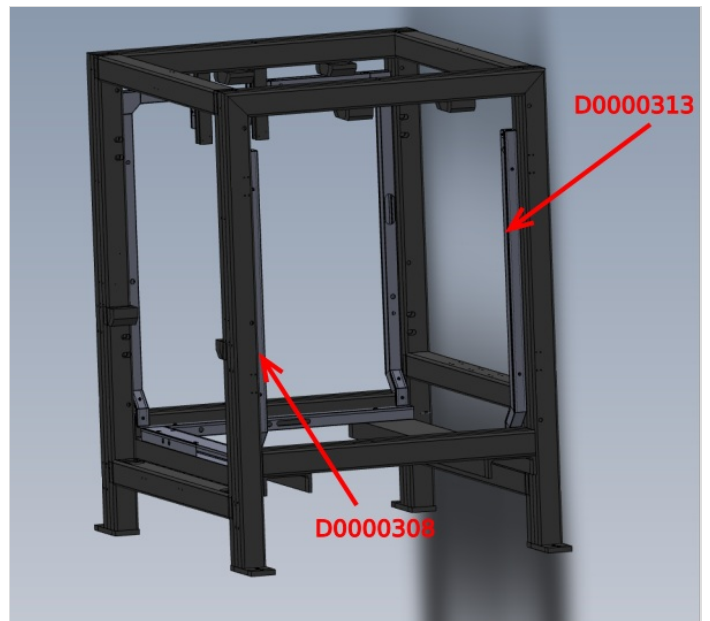
Assemble as shown

Enlarge holes indicated to 7mm diameter



Step 9 - Fix to frame

Use same alignment and fasteners as previous upright mounting (step 6)



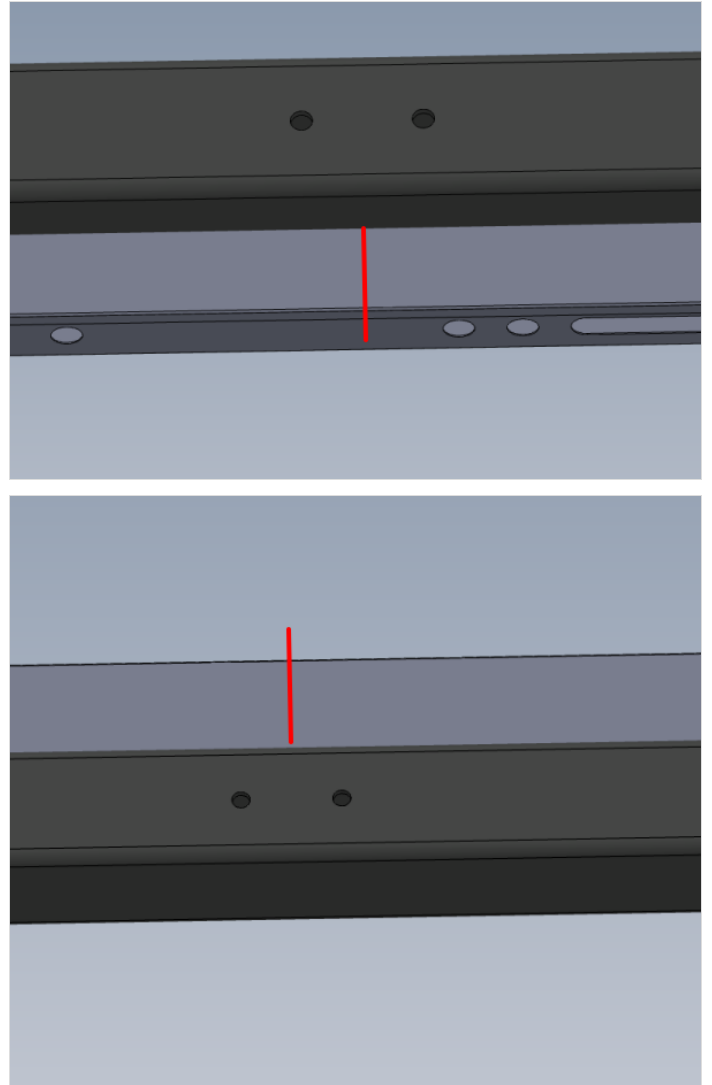
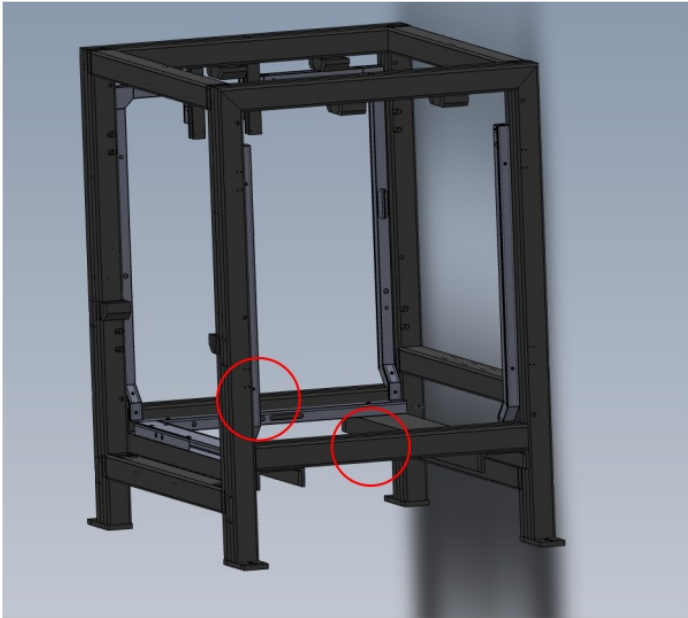
Step 10 - Cut lids

Use disc cutter to cut lids as indicated

Mark position on machine

Remove and cut

Refit

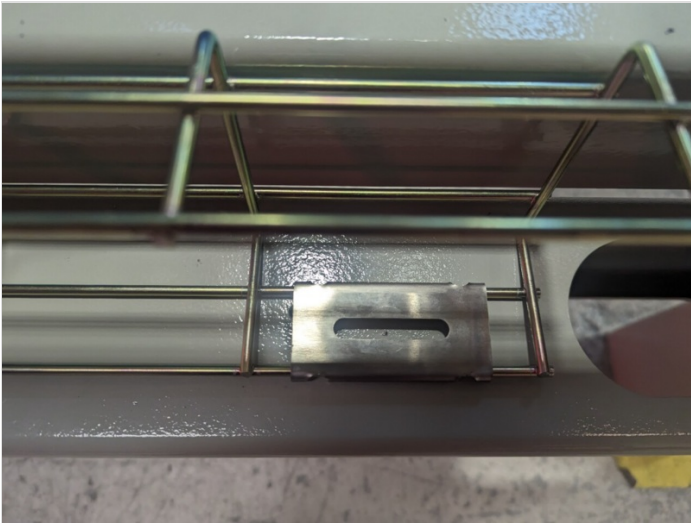
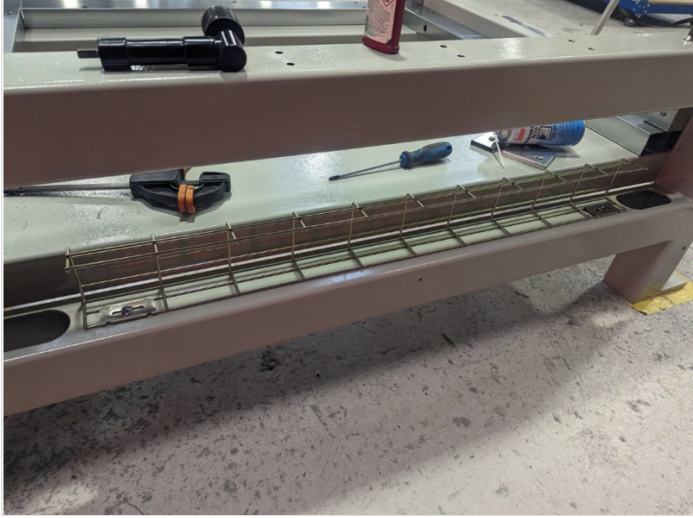
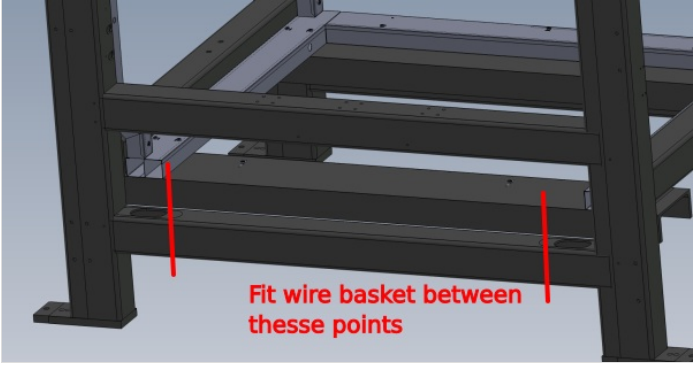
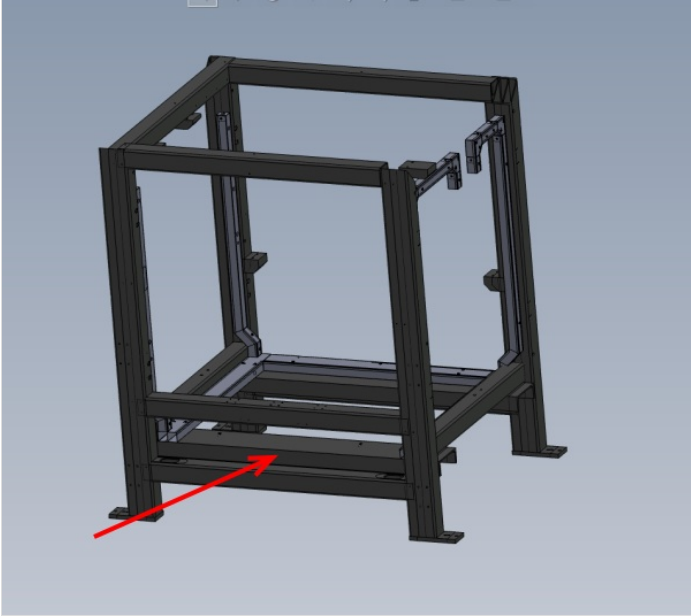


Step 11 - Fit wire basket to rear

Cut A0001065 wire basket to fit between indicated sections shown

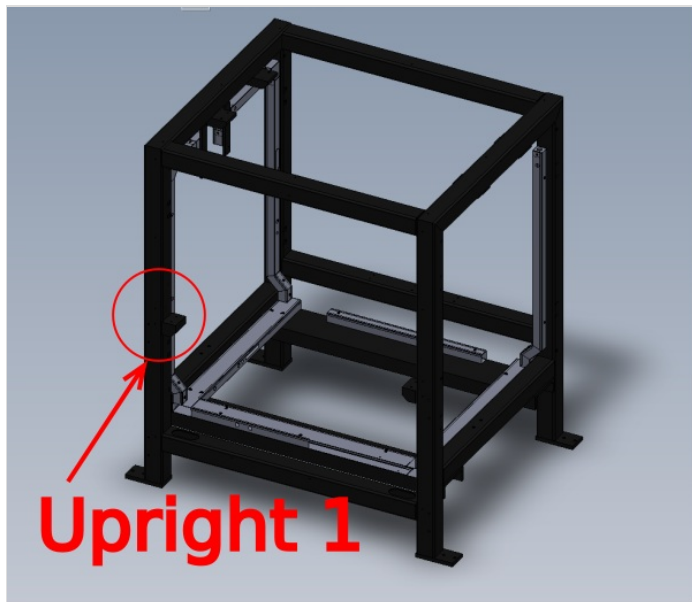
Use 2 off A0001061 Retainer: Wire Basket Cable Tray to fix ,these require drilling and tapping M6

Use M6 x 20 button sockets and M6 penny washers to fix



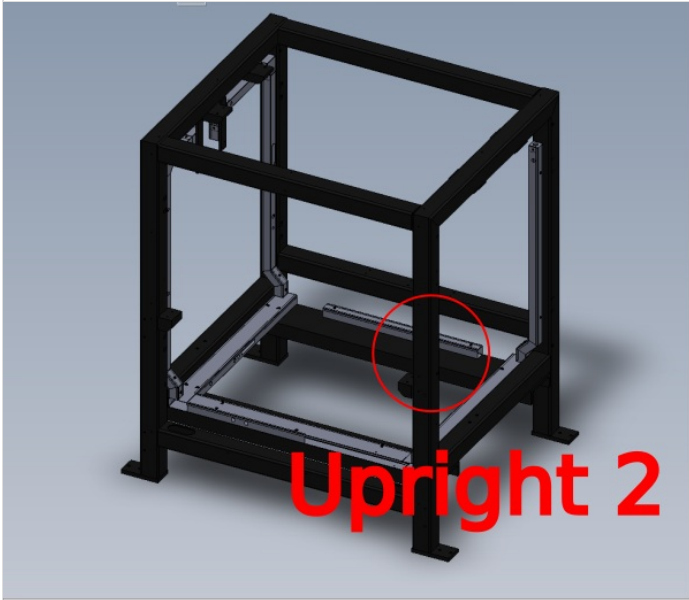
Step 12 - Additional holes Upright 1

Add additional 20.4mm holes as shown



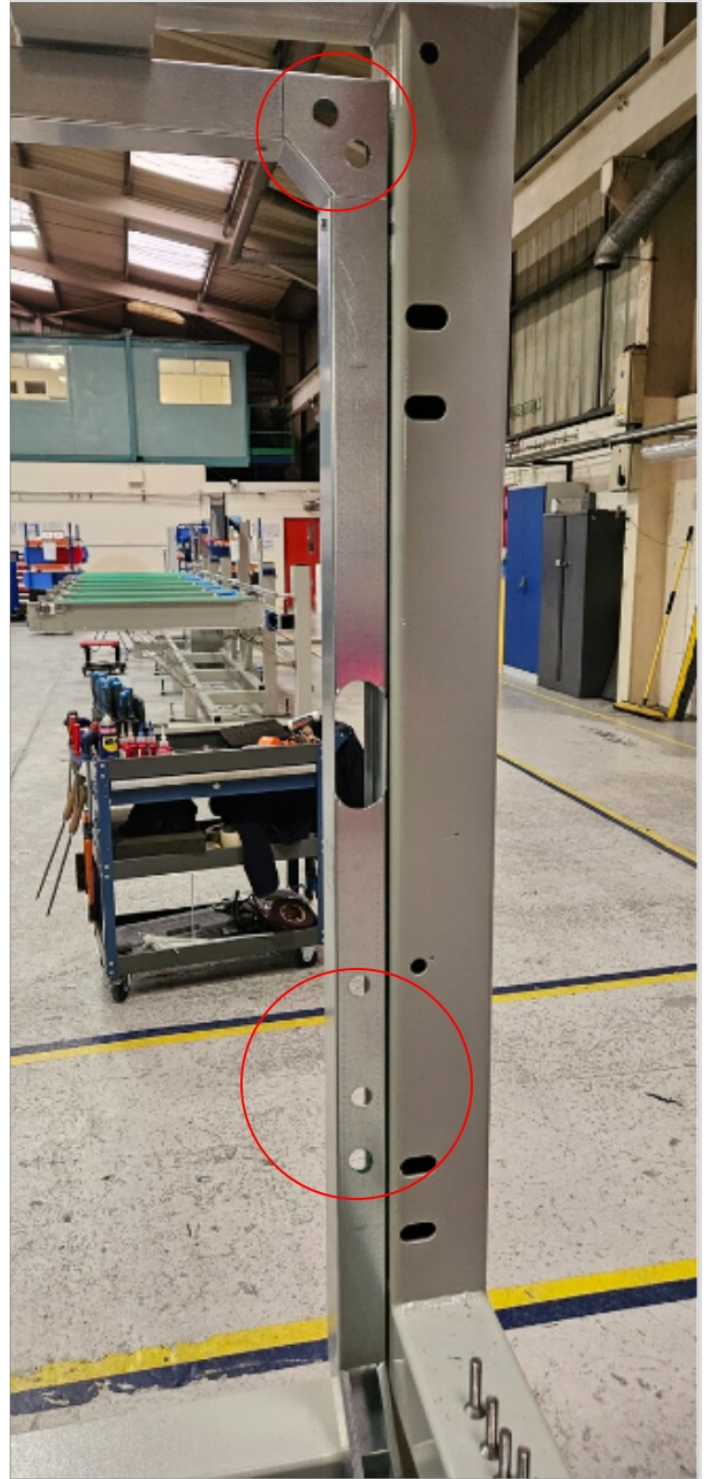
Step 13 - Additional holes Upright 2

Add additional 20.4mm holes as shown



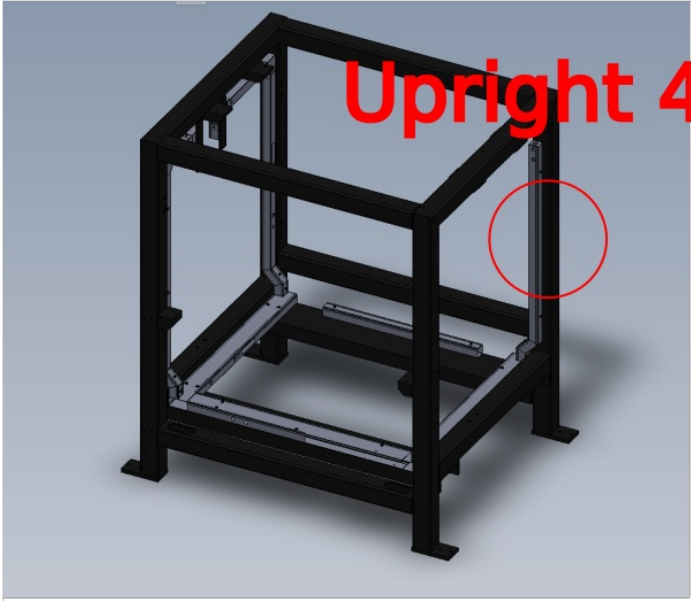
Step 14 - Additional holes Upright 3

Add additional 20.4mm holes as shown



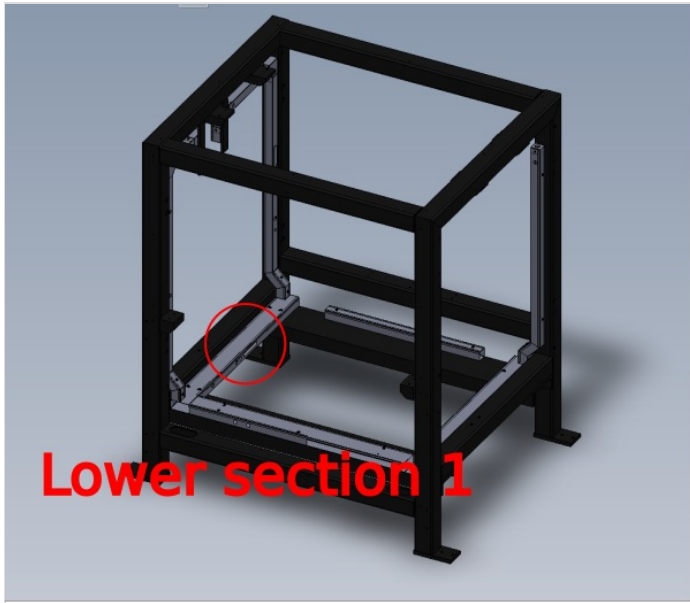
Step 15 - Additional holes Upright 4

Add additional 20.4mm holes as shown



Step 16 - Additional holes Lower section 1

Add additional 20.4mm holes as shown



Step 17 - Fit edging strip M0000031

Fit edging strip to points indicated



Step 18 - Fit A0000234 20mm grommits

Picture of Grommit fitted please

Fit A0000234 20mm grommits to all 20mm holes in trunking

