



R000559 Bench assemble machined parts

Preparation for machining

 Difficulty **Medium**

 Duration **0.25 hour(s)**

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Assemble

Step 3 - Check

Step 4 - Pass to machine shop

Comments

Introduction

Tools Required

standard hex key set

Parts Required

D0004142 Backfence Support Bar x 2

D0004598 Backfence Bar Support x 1

Step 1 - Unless otherwise stated

All bolts to have Loctite 243 adhesive applied unless otherwise stated

All Threaded Pneumatic connections to have Loctite 570 applied

All bolts to be pen marked once adhesive applied and correct tension added



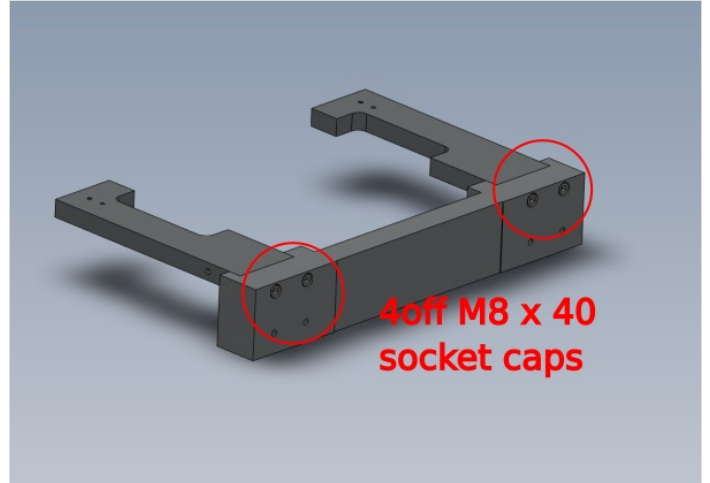
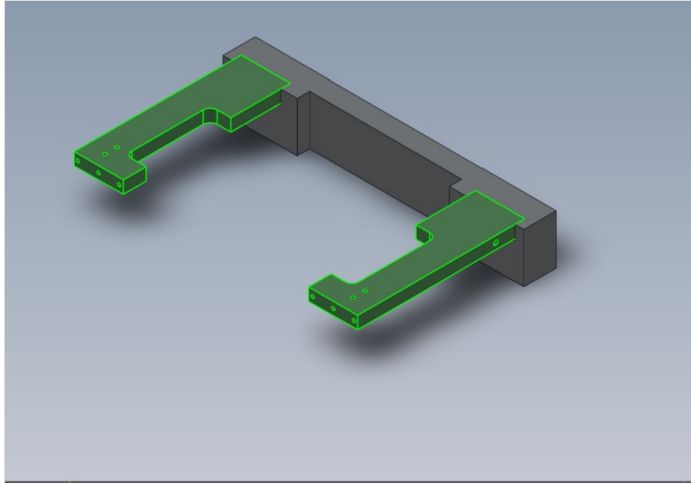
Step 2 - Assemble

Quality check bars for size, flatness and burrs.

Check fit of arms into mounting bar. Arms must be a good fit into mounting bar, but not tight. Inspect parts if loose or tight fit is observed

Assemble D0004142 Backfence Support Bar x 2
and D0004598 Backfence Bar Support x 1 as shown

Use 4 off M8 x 40 socket caps to fix



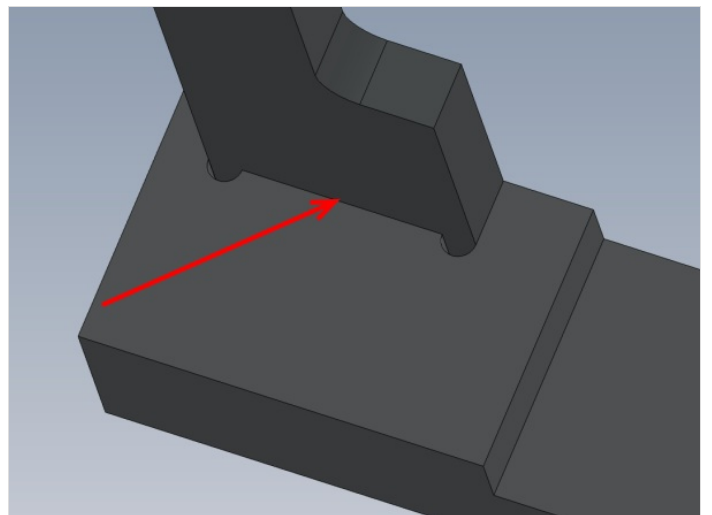
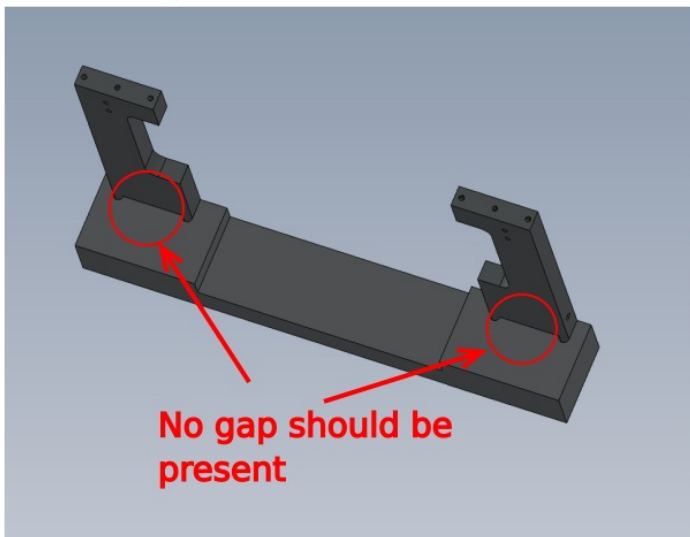


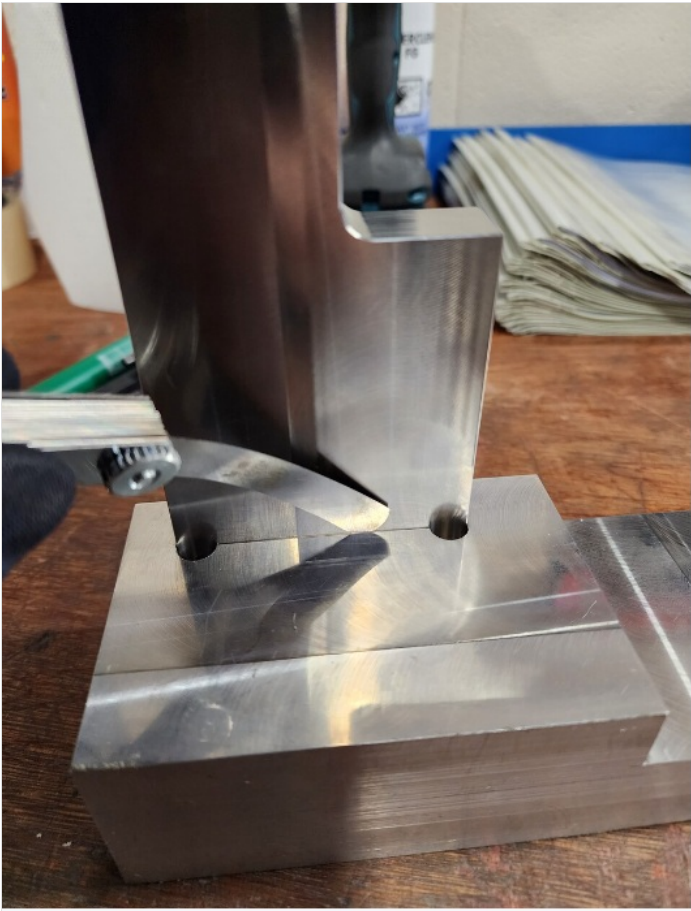
Step 3 - Check

Check the indicated area for correct fitment

There should be no gap present , check with feeler gauges

Tolerance 0.002"/0.05mm





Step 4 - Pass to machine shop

Pass to machine shop for alignment machining

Indicated faces required skimming to be true to each other

