



R0010260 Bench Assemble Tool Break Sensor

Instructions for tool break assembly

 Difficulty **Medium**

 Duration **1.5 hour(s)**

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Comments

Introduction

Tools Required

Standard tap set

Standard drill set

Standard hex key set

Pipe cutters

Flush cutters

M0001053 Stock 6mm copper tube

M0000153 small Stuga sticker

Parts Required

A0001046 P Clip 6mm Steel / Rubber Liner x 6

D0001962 Tool Sensor Mount x 1

D0001963 Tool Sensor Post x 1

D0001964 Tool Sensor Logo Plate x 1

E0001120 Sensor: Ultrasonic M8 20-150mm x 1

E0001082 4 pin m8 sensor single ended x 1

P0000046 Fitting: 'Y' Adaptor 6mm x 1

P0000149 6mm to 4mm reducing stem x 2

P0000160 Fitting: Flow Controller In Line 6mm x 1

P0000456 Compact straight male adapter 4mm- M5 x 2

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

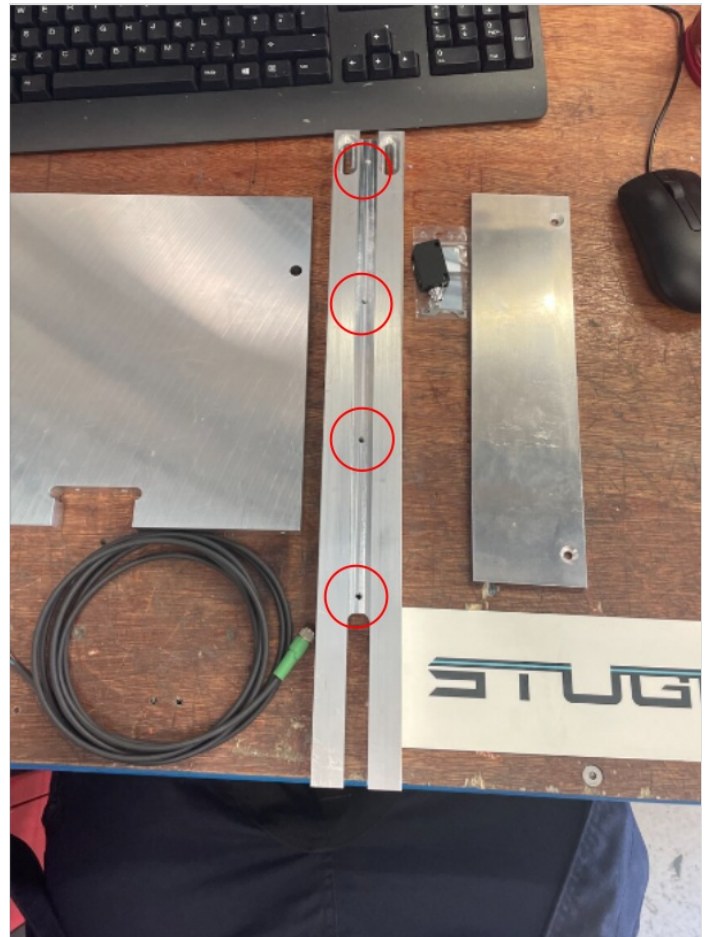
Use Loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



Step 2 - Attach tie bases

Attach 4 off m4 tie bases with m4 x12 button sockets to D0001963 Tool Sensor Post



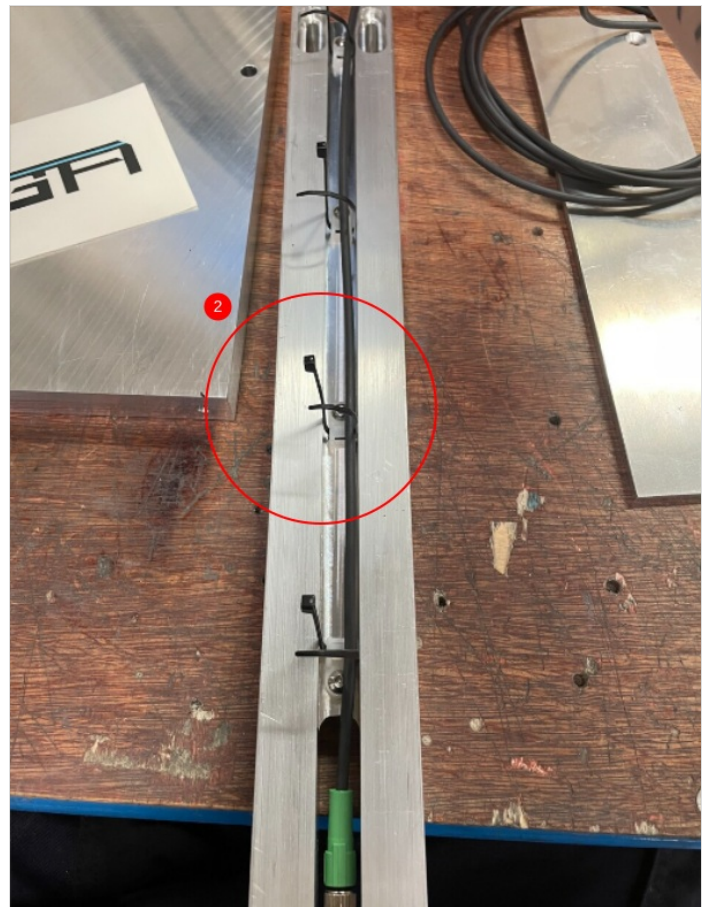
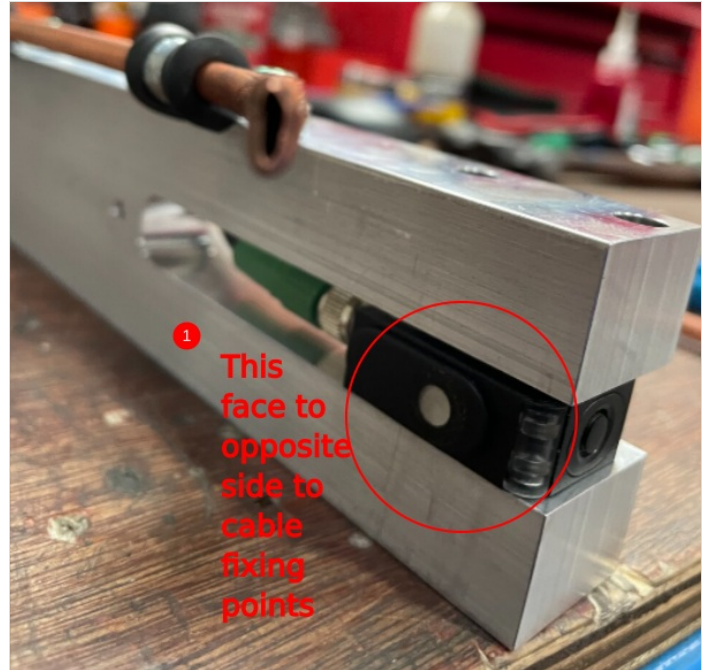
Step 3 - Mount sensor and cable

Attach E0001120 Sensor: Ultrasonic M8 20-150mm to E0001082 4 pin m8 sensor single ended cable

1 Fit sensor to tool mount post using using m3 x 20 pan head fasteners

Note orientation

2 Use small tie wraps to secure cable



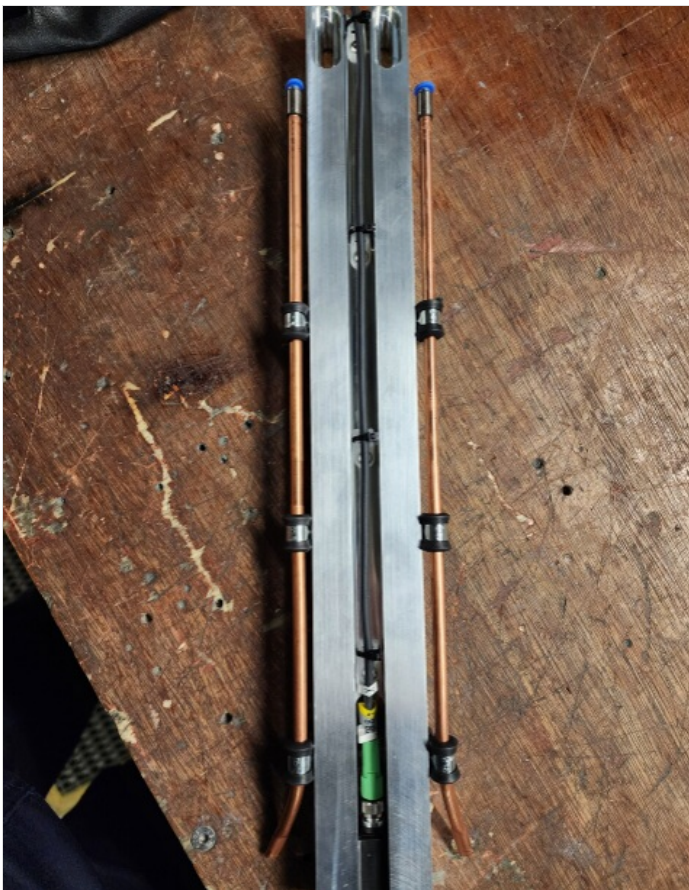
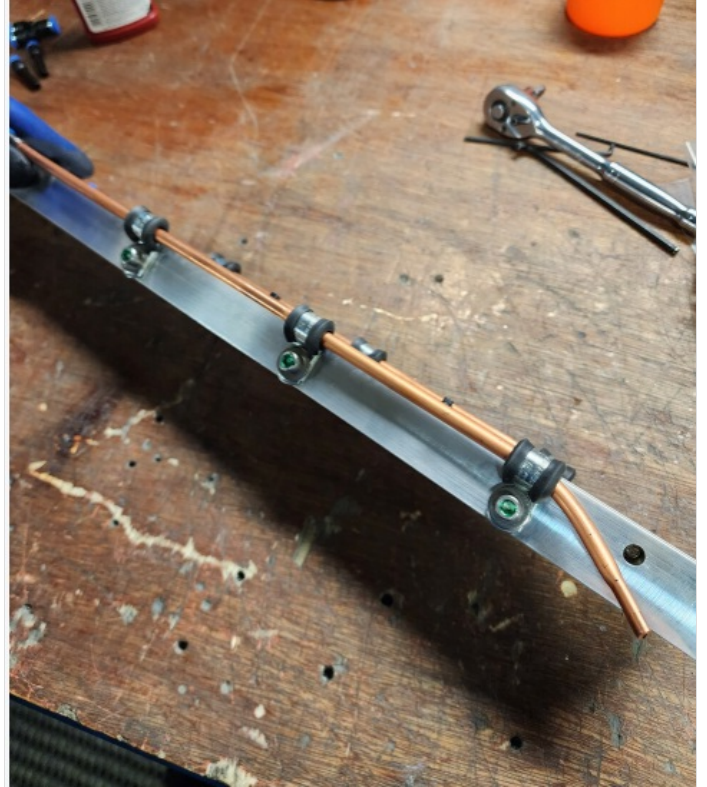
Step 4 - Mount blowers

1 Cut 2 off pieces of M0001053copper tubing at 360mm and straighten in vice

2 Tap one end on each pipe to M5 and add fitting P0000456 to end

3 Pipe opposite end of fitting flatten

4 Mount pipes to tool post as shown using A0001046 P Clip 6mm Steel /Rubber Liner x 6 and M5 x 12 socket caps and heavy M5 washers
Ensure orientation is as shown

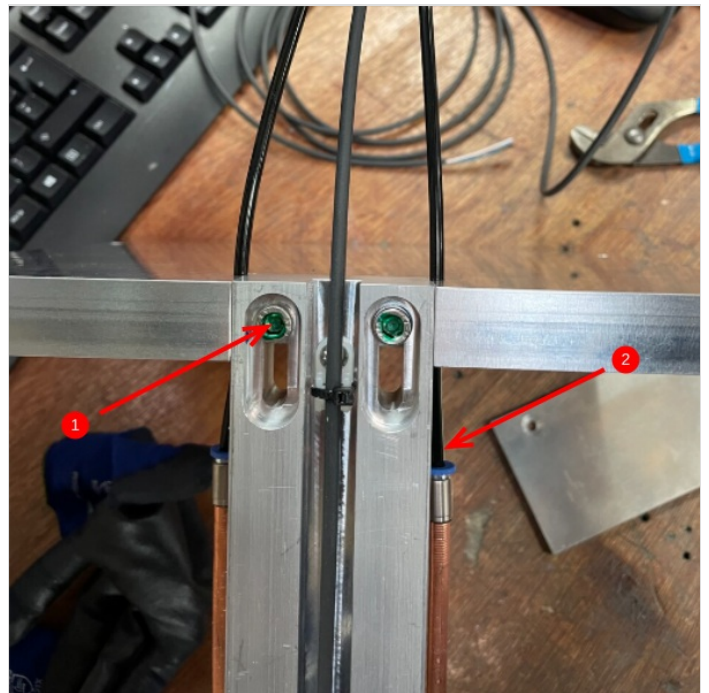




Step 5 - Mount post to plate

1 Use 2 off M6 x 30 socket cap to secure post as shown

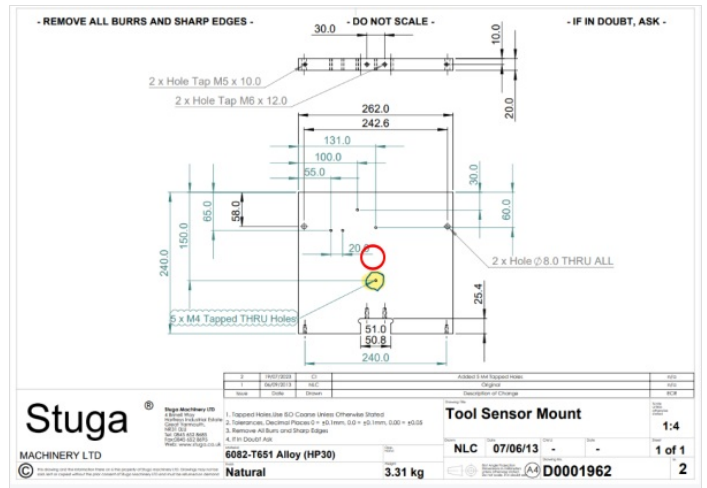
2 Add 2 off pieces of 4mm black air pipe at 300mm



Step 6 - Check and rework if required

Check if indicated hole is M4 or M3.

If M4 rework to M3 by adding new fixing point 10mm from M4 hole



Step 7 - Connect blowers

Drawing for mount plate updated 19/07/23 to include tapped holes for mounting of parts

Pipe as shown using

Use M3 x 25mm caphead to secure Y adapter

P0000046 Fitting: 'Y' Adaptor 6mm x 1

P0000149 6mm to 4mm reducing stem x 2



Step 8 - Add tie bases and flow regulation

Pipe identification 2699

Pay attention to P0000160 flow regulation direction when mounting. Use M4 x 5 button heads to mount tie bases, and M4 x 20mm to mount flow regulator



Step 9 - Add logo plate

1 Mount D0001964 Tool Sensor Logo Plate as shown using M5 x 10 socket counter sunk

2 Add M0000153 small sticker to face

