


R0015028D ZX5 Hepco Beam Alignment Module C part 2

Instructions for mounting and aligning hepco x axis beam

 Difficulty **Very Hard**

 Duration **1 minute(s)**

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Fit linear rails

Step 3 - Level linear rails

Step 4 - Attach mounting brackets

Step 5 - Fit bearings and finalise mounts

Step 6 - Quality check

Step 7 - Dowel in position

Step 8 - Hepco dowels

Step 9 - Remove setting jigs . grease bearings and fit blanking plugs

Comments

Introduction

Tools Required

Engineers level

Hepco flat spanner T0000491

Hepco Box spanner T0000492

Standard hex key set

Incremental shim pack

Parts Required

B0000046 Slide Base Bearing Block (Straight Grease Nipple) x 6

B0000184 Journal Cap Seal 34 x 4

B0000185 Double Row Long Stud Journal Eccentric x 2

B0000186 Double Row Long Stud Journal Concentric x 2

B0000234 Straight Grease Nipple M6 ST/ST x 6

B0001006 Linear rail 25mm x 820mm x 6

B0001102 Double edge spacer slide and beam 7600mm x 1

D0015072 Carriage Plate x 1

D0015492 Vertical Beam Adjustment Plate x 5

D0015493 Lateral Beam Adjustment Plate x 5

P0000200 Elbow Adaptor 6mm - M5 x 2

B0000173 blanking cap x 90

F0000331 M6 threaded plate x 120

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 570 on all threaded pneumatic connections

Pen mark all bolts once finalised



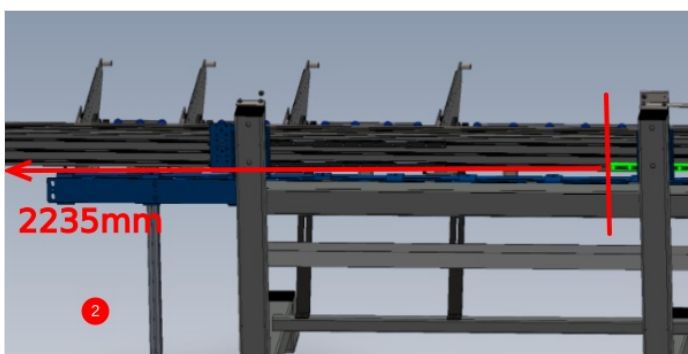
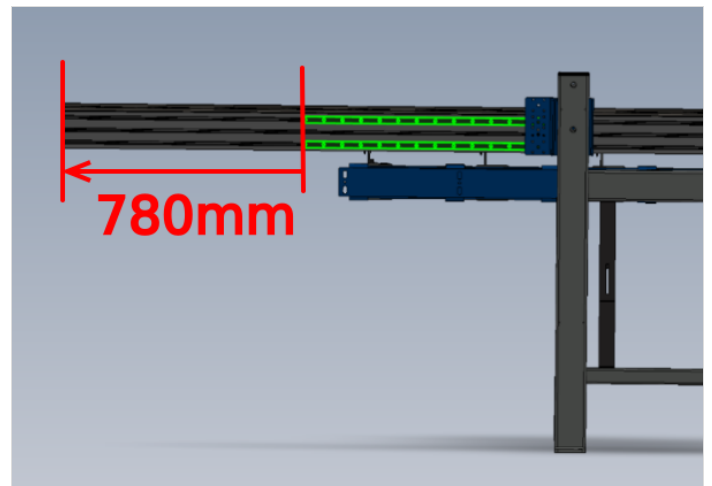
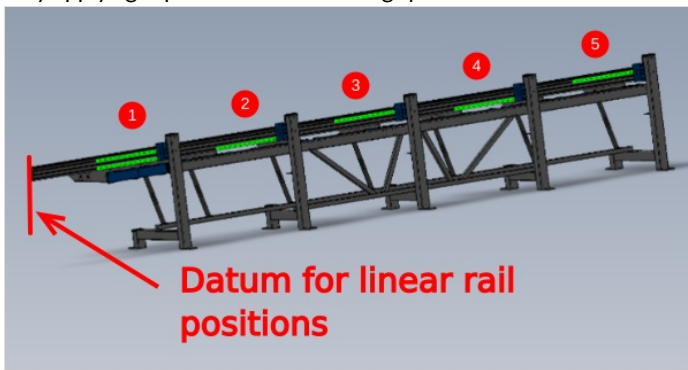
Step 2 - Fit linear rails

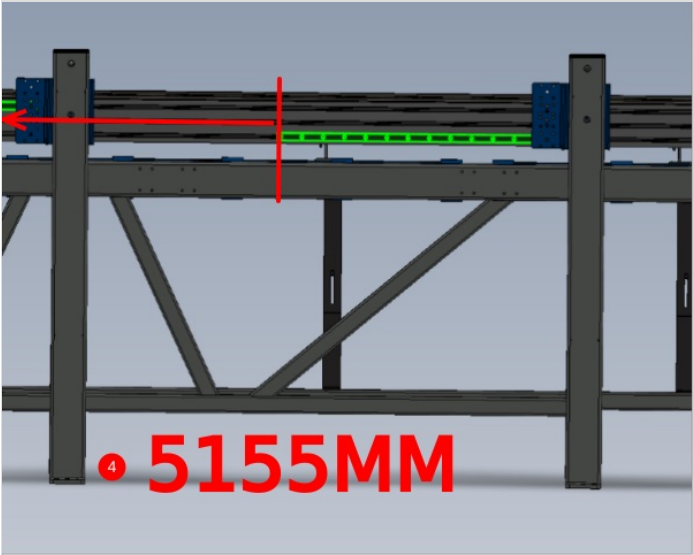
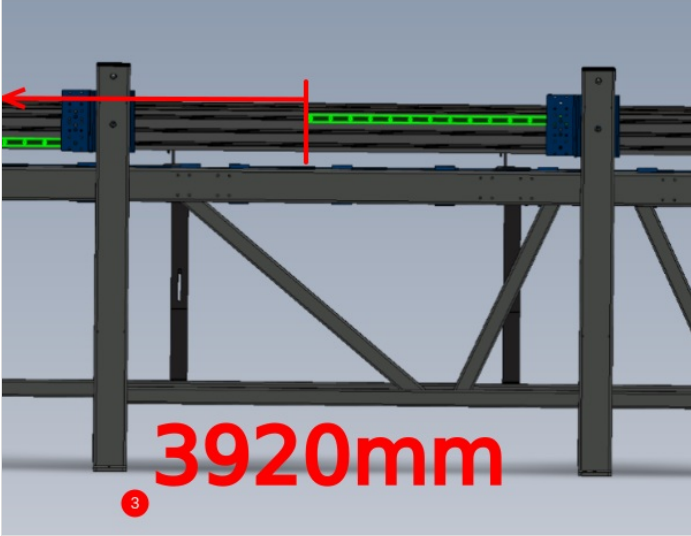
Fit 6 off B0001006 linear rails to hepco beam as shown

Use data for position of each rail

Fix with F0000331 m6 threaded plates and m6 x 20 socket caps with no adhesive (holding stock of F0000331 plates is available from stores via request)

only apply light pressure to 2 off fixings per rail





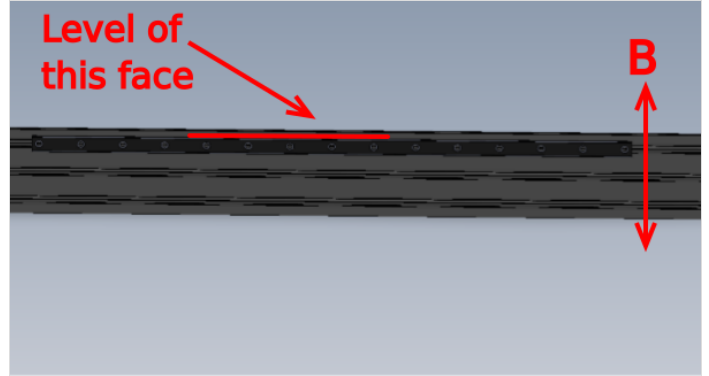
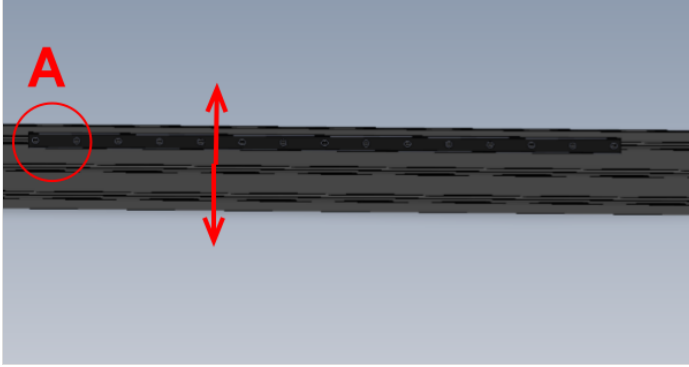
Step 3 - Level linear rails

1 Set hole position A to middle of movement in direction shown

2 Use engineers level on indicated face and adjust position B up or down to set rail level

3 Remove central fasteners one by one, applying adhesive and adding final tension. Then remove both end fasteners ,apply adhesive and apply final tension

Repeat for all remaining 5 linear rails



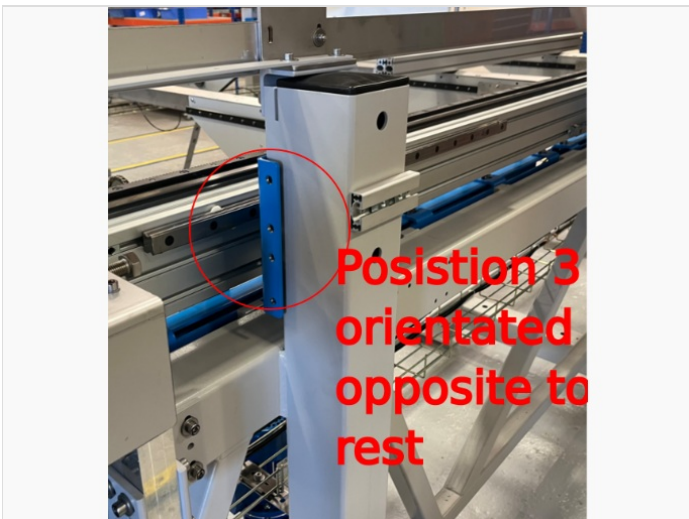
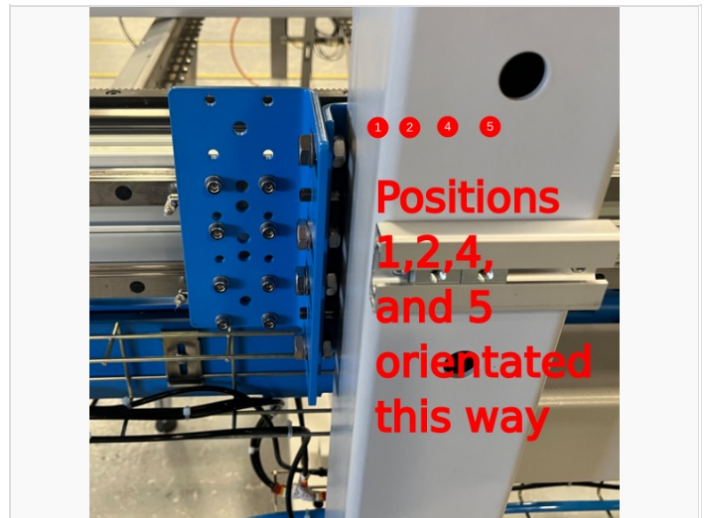
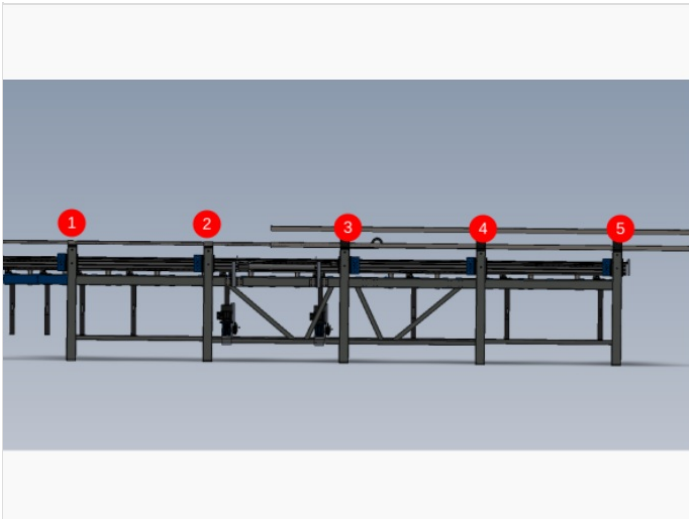
Step 4 - Attach mounting brackets

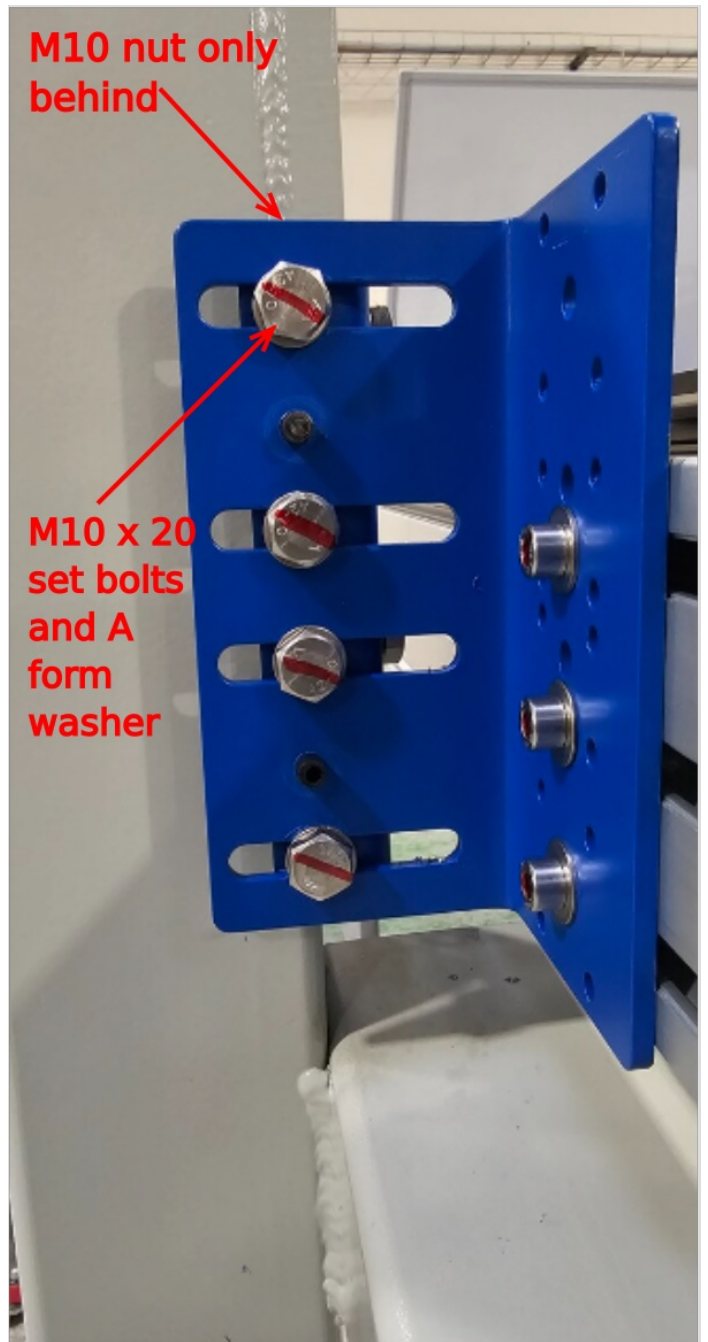
Attach D0015492 Vertical Beam Adjustment Plate x 5 and D0015493 Lateral Beam Adjustment Plate x 5 to positions shown

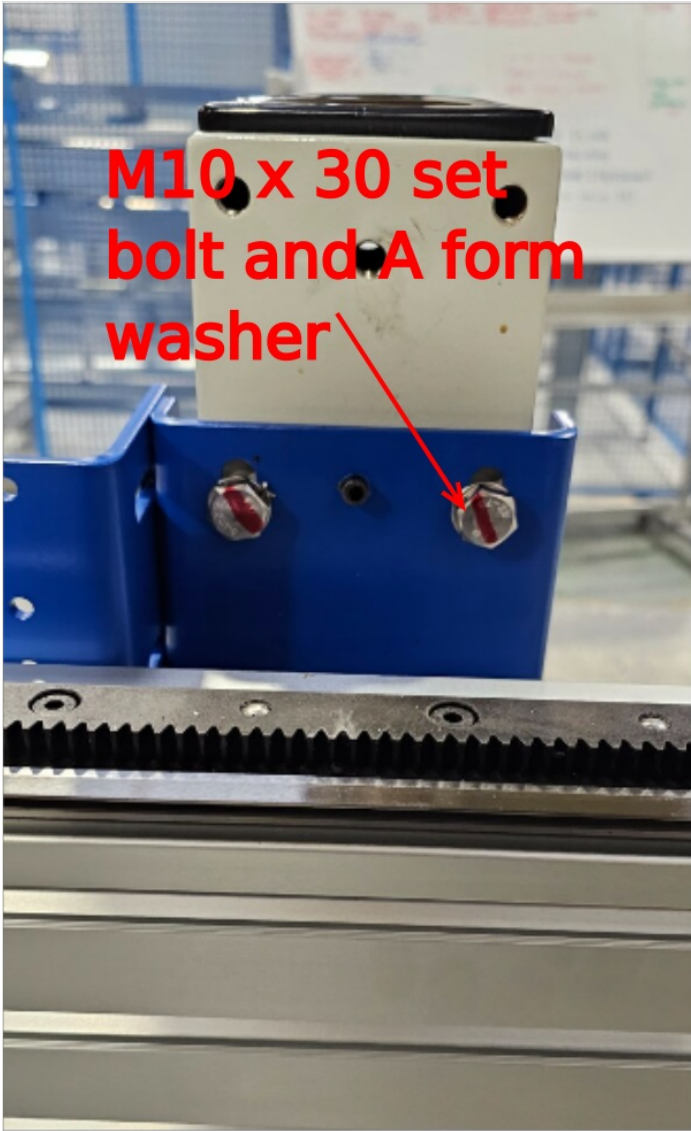
Use M10 x 20 and M10 x 30 set bolts, M10 A form washers And nuts on joining plates

Pay attention to orientation of position 3

only apply light pressure to fasteners to hold in place brackets





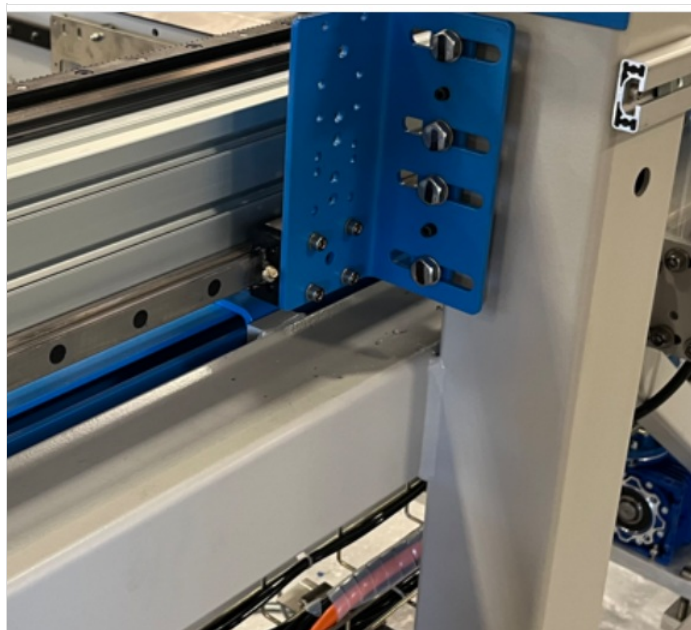
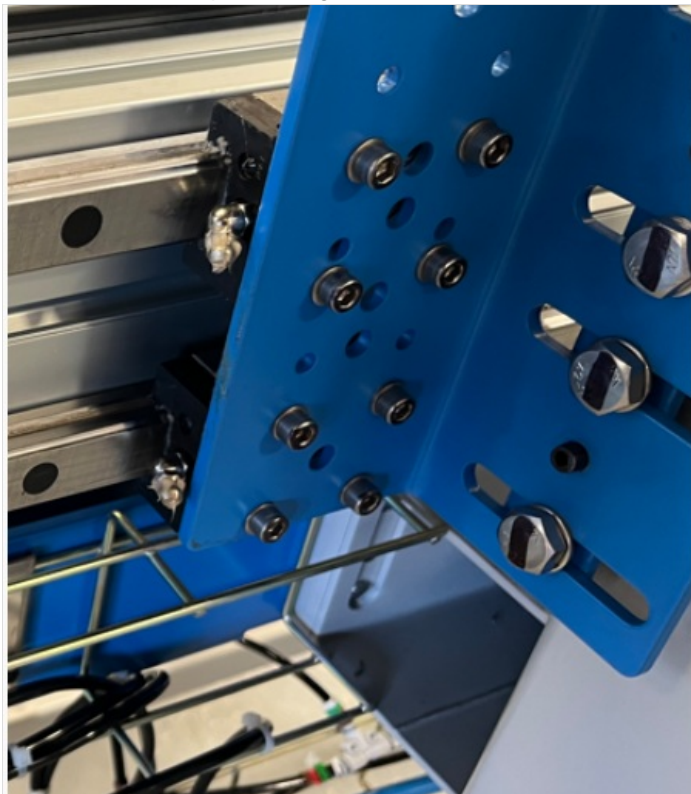


Step 5 - Fit bearings and finalise mounts

Attach B0000046 bearings 6 off to linear rails orientated as shown

Use M6 x 16 socket caps and M6 A form washers with adhesive and lightly fasten as shown , ensure mounting brackets are free to move to align to the bearing face .

Once all faces are in position, tighten all fasteners with adhesive and finalise



Step 6 - Quality check

Quality check required from supervisor before next step commences

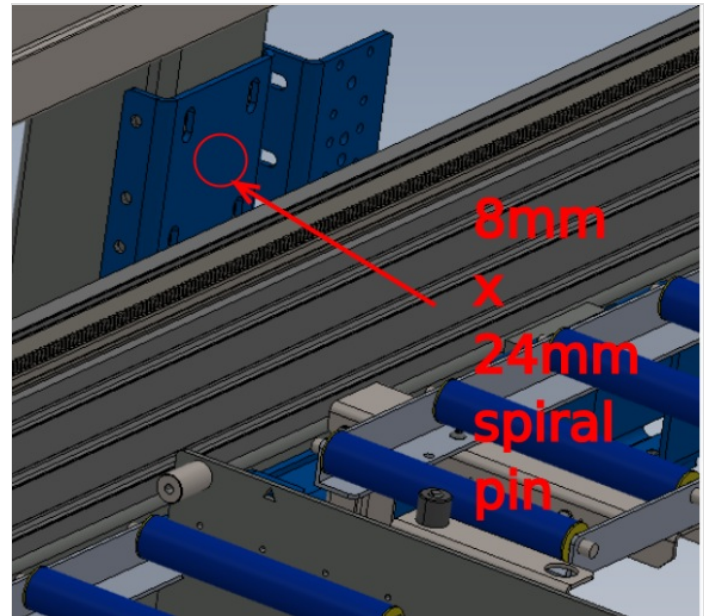
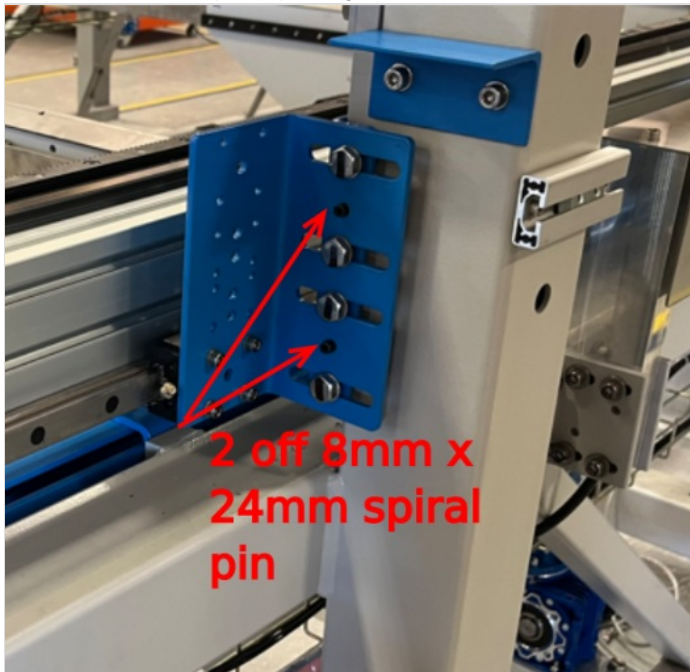


Step 7 - Dowel in position

Brackets require fixing with 8mm x 24mm roll pins

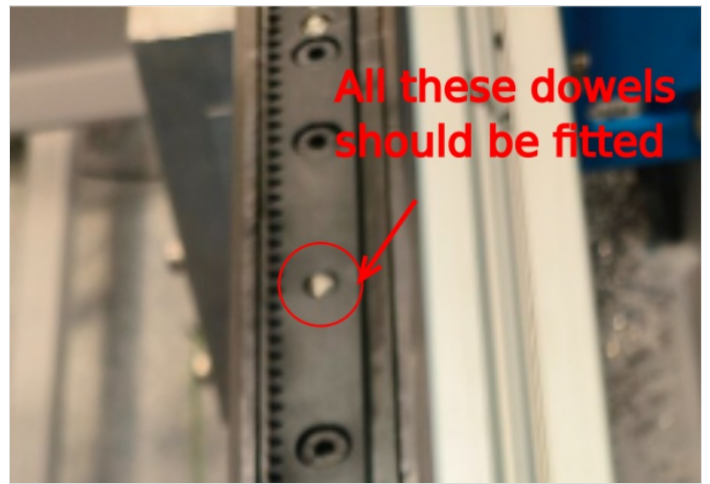
Drill the indicated faces to secure alignment

All 5 bracket sets required pinning



Step 8 - Hepco dowels

Now alignment is complete, the finalising dowels supplied with the hepco rail can be fitted in the areas shown



Step 9 - Remove setting jigs . grease bearings and fit blanking plugs

Setting jigs can now be removed that are supporting hepco rail in 5 positions

Fit B0000173 blanking plugs to linear rails. Ensure plugs are fitted flush to rail face, not below

Grease all linear bearings on hepco rail

