


R0015042 Install Infeed Datum Rollers

Details for mounting of datum rollers

 Difficulty Easy

 Duration 0.5 hour(s)

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Correct orientation

Step 3 - Mount Infeed clamp support Bar

Step 4 - Fit Datum Rollers

Comments

Introduction

Tools Required

Standard hex key set

Parts Required

D0007678 Infeed Clamp Support

R0000706 Bench assemble Infeed Datum rollers

Step 1 - Unless otherwise stated

Use loctite 243 on all fasteners

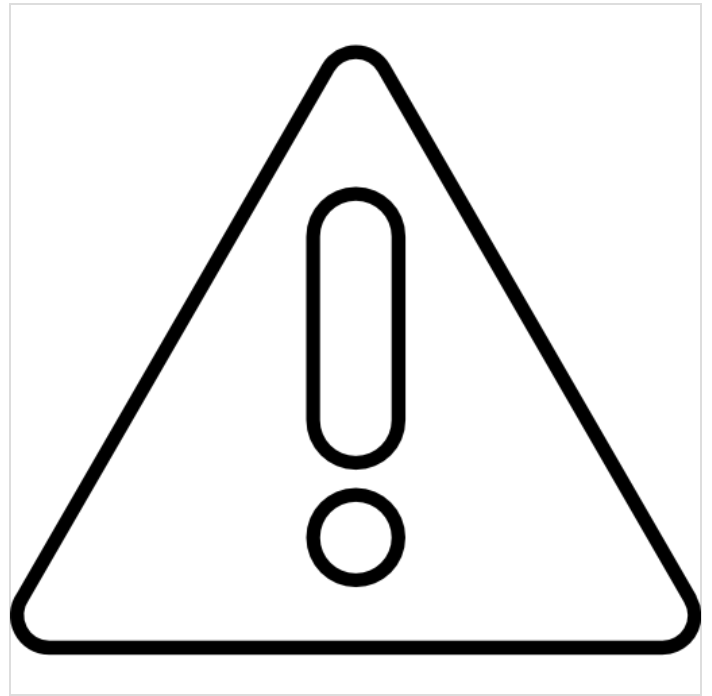
Use loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



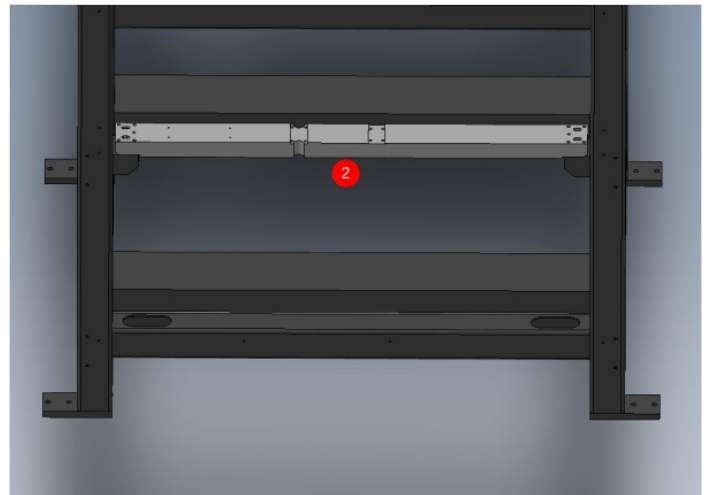
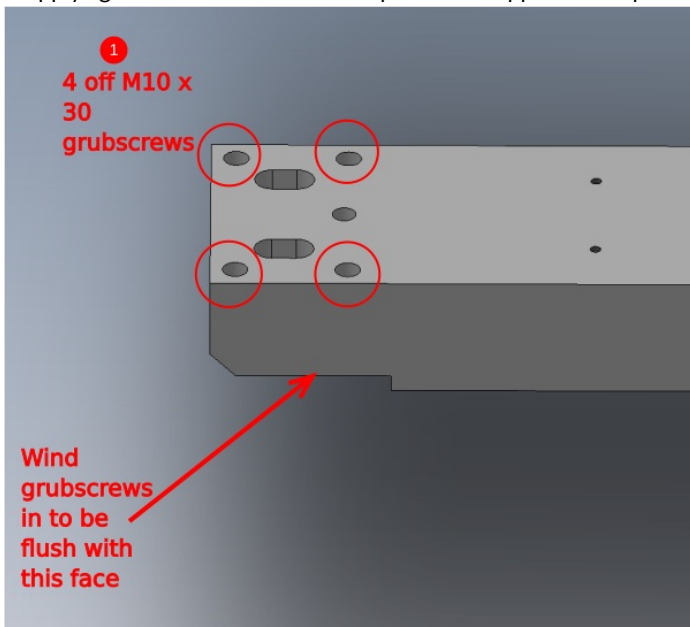
Step 2 - Correct orientation

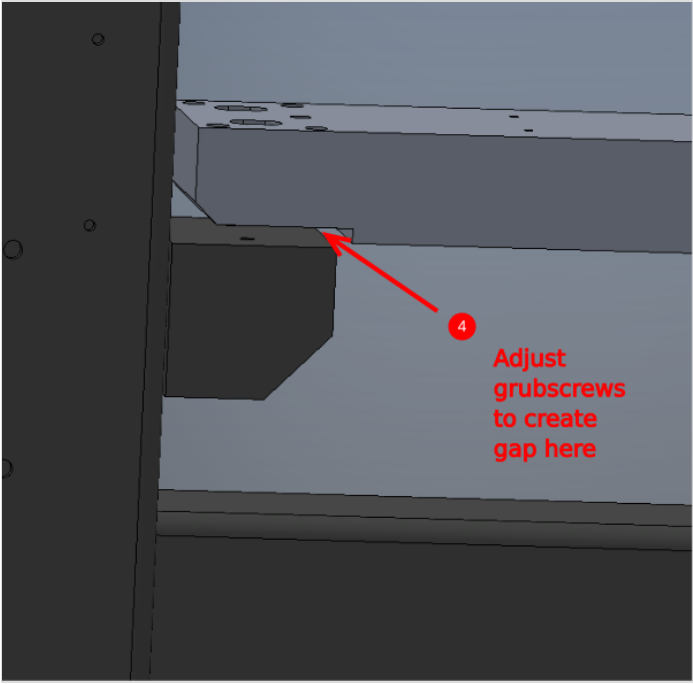
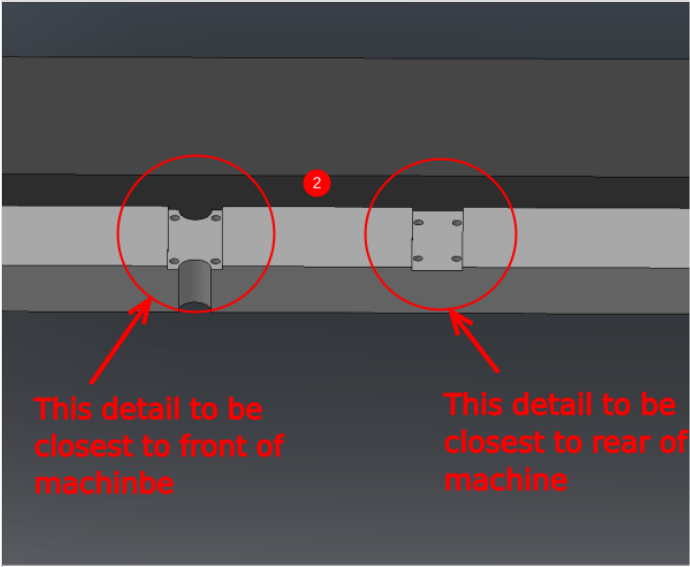
- !** ...Datum roller assembly can be fitted in 2 positions.
Ensure the correct position is used for ZX5



Step 3 - Mount Infeed clamp support Bar

- 1 Insert 8 of M10 x 30 flatbottom grub screws into holes indicated. Wind in until flush with bottom face
- 2 Mount D0007678 Infeed Clamp Support as shown.
- 3 Use 4 off M8 x 80 socket cap, each with a heavy M8 washer and a Heavy M8 penny washer
- 4 Wind each M10 grub screw (8 off in total) 6 exact full turns to lift the beam evenly away from the indicated face
- 5 Apply light tension to M8 socket caps to hold support bar in position





Step 4 - Fit Datum Rollers

1 Mount R0000706 Bench assemble Infeed Datum rollers using 4 off M8 x 70 socket caps and M8 heavy washers . Orientate as shown

