


R0015063 Bench Assemble Roller Tables

Instructions to bench assemble roller tables

 Difficulty **Medium**

 Duration **6 hour(s)**

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Comments

Introduction

Tools Required

Standard Hex key set

Standard spanner set

Tape measure/Rule

8.2mm HSS drill

Drill

Parts Required

B0001092 Plastic roller x 48

B0001103 Bush flange x 28

B0001220 Spacer x 28

D0015001 Roller Bed Cylinder Arm x14

D0015002 Shaft 10mm: 58mm Rod End x 14

D0015003 Roller Bed Rail 375mm x 6

D0015004 Roller Bed Rail 550mm x 2
D0015005 Roller Bed Rail 1000mm x 10
D0015006B Roller Bed Arm Bracket x 14
D0015010 Rod End Spacer x 28
D0015283 Saw Infeed Backfence Plate x 5
D0015481 Shaft 8mm: 50mm Cylinder Pivot x 14
D0015547 Sensor Blower Plate x 1
D0015603 Roller Bed Pivot Shaft (silver steel) x 14
D0015608 Saw Infeed Backfence Plate (Full Length) x 5
E0001120 Sensor: Ultrasonic M8 20-150mm x 1
P0000049 Cylinder Spherical Bearing M10 x 1.25 x 14
P0000200 Elbow Adaptor 6mm - M5 x 1
P0001152 Cylinder 25 x 25 x 14
P0001198 Fitting Speed controller 1/8 x 6mm tube x 28
P0000160 flow regulator x1

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 - Assemble Cylinder assembly

⚠ ...Ensure Fixing nut from indicated point is removed from each cylinder and disregarded

14 off

- i** ...All Flow regulator fittings P0001198 should be set at this point to the correct flow rate. To do this follow these steps
- 1 Wind regulation screw clockwise until fully in. Do not overtighten, stop when light resistance is felt.
 - 2 Turn regulation screw exactly 2.5 turns anticlockwise to set flow rate

1 Fit 2 off P0001198 fittings to cylinder P0001110

2 Fit spherical bearing P0000049 to cylinder end, Do not add final tension to the nut



Step 3 - Check for rework 13 off

14 off

Check part D00150001 has been supplied to new specification
Check indicated hole, should measure 8.2mm. If not open up with hand drill

Drawing change requested 06/06/23 to amend from 8mm to 8.2mm



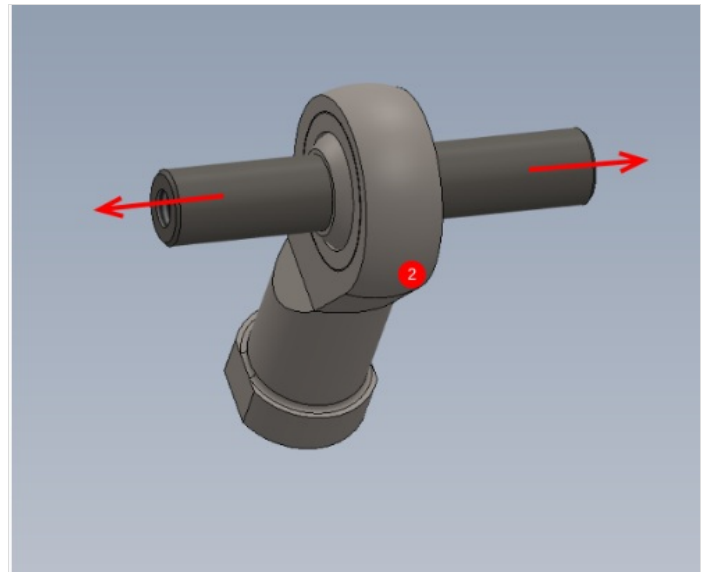
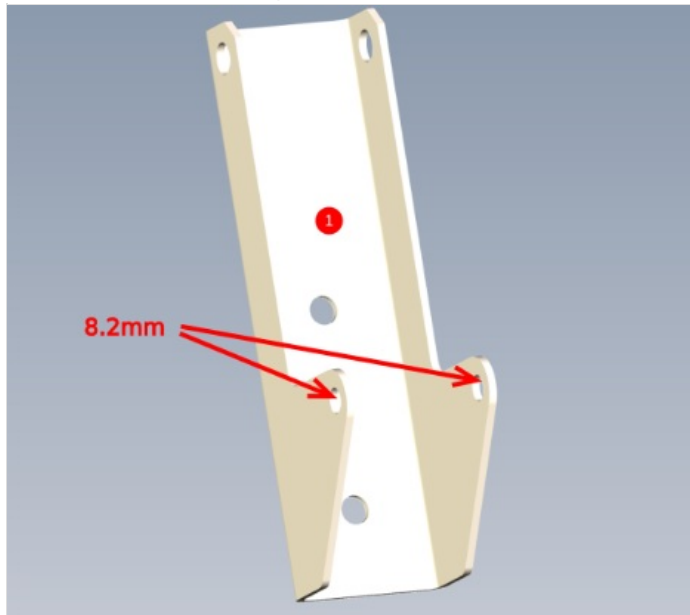
Step 4 - Check for rework of following parts

1 D0015006B indicated holes should measure as shown. Rework by hand if issued old spec

ECR raised 06/06/23

2 D0015002 rod end shaft . Check fit in P0000049 spherical bearing . Polish down diameter to allow shaft to pass through.

ECR raised 06/06.23 to improve tolerance of shaft to allow better fitment



Step 5 - Dokit change

Please be aware following step has been amended to include new assembly details.

It is now required to assemble 3 off of the 14 off cylinder mounts differently

Amendment to fastener type used

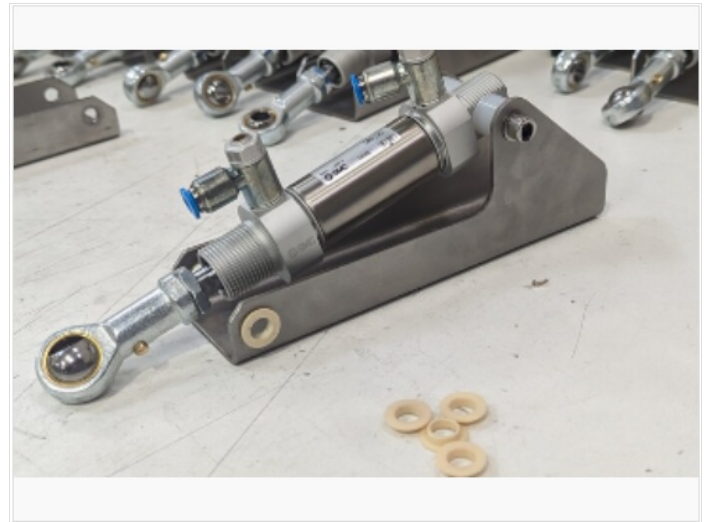
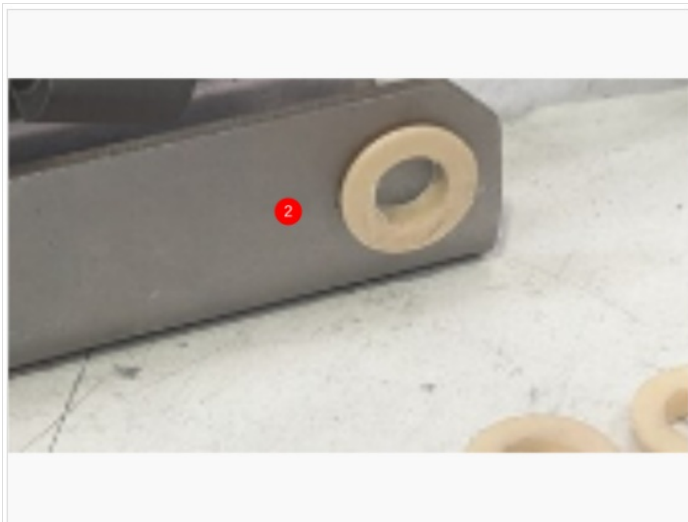
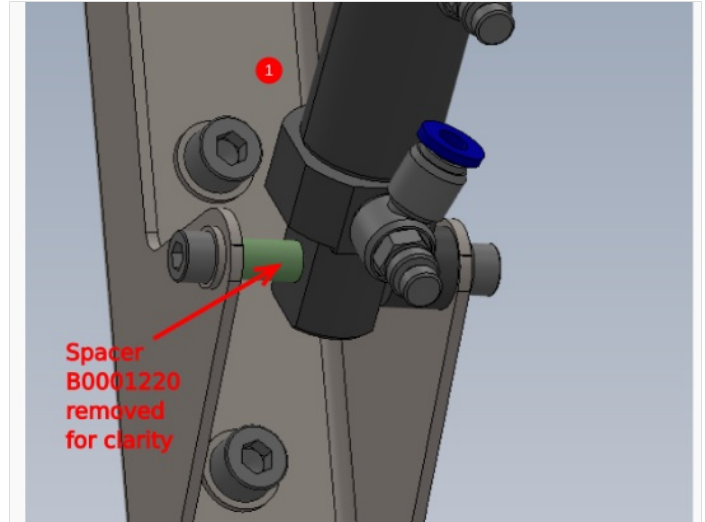
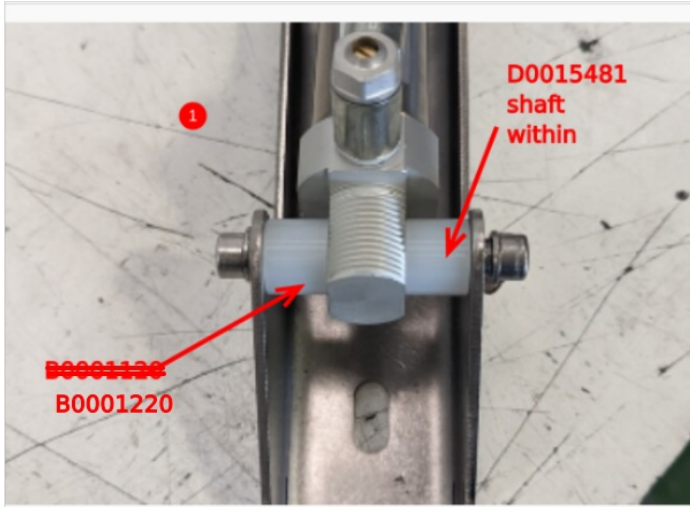


Step 6 - Fit bushes and mount cylinder

14 off

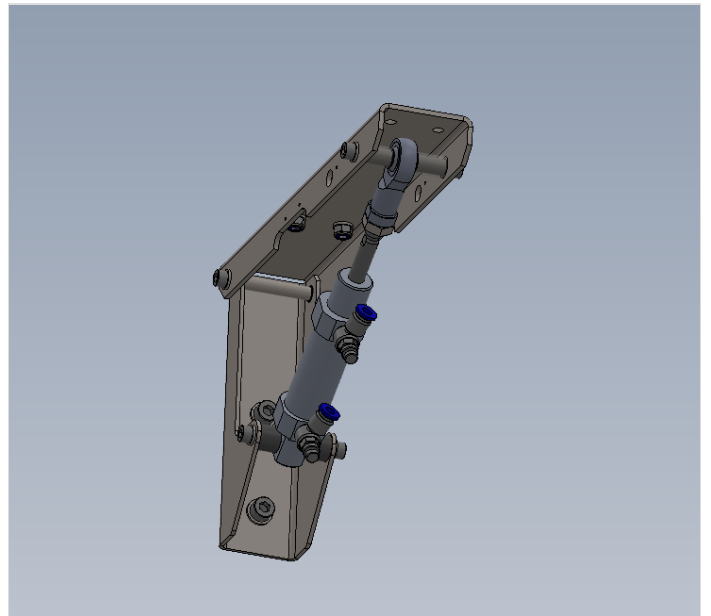
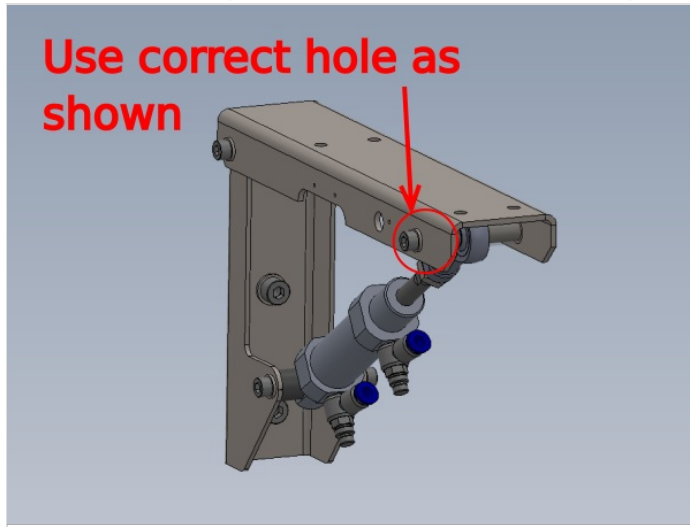
1 Combine D0015481 shaft and B0001220 spacer as shown to mount cylinder to bracket. Use M6 x 12 socket caps and A form washers to fasten on 11 off cylinder mounts. Use M6 x 12 hex set bolts with no washers on 3 off cylinder mounts

2 Fit 2 off B0001103 bushes to D0015006B



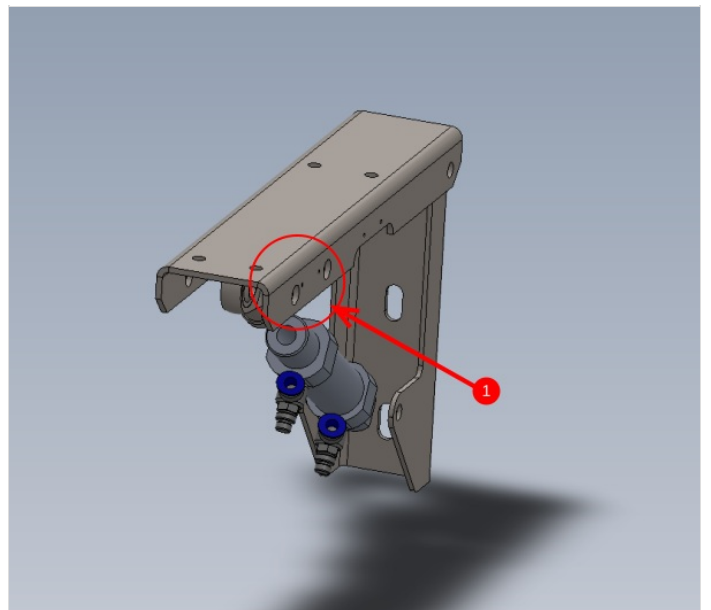
Step 7 - Combine support arm and roller bracket

- 14 off
- 1 Fit 2 off D0015010 spacers, 1 off d0015002 shaft through spherical bearing and fix with 2 off m6 X 12 socket caps and A form washers
- 2 Fit 1 off D0015603 pivot shaft with 2 off M6 x 12 socket caps and A Form washers



Step 8 - Prepare M3 holes

- 1 Tap 2 off indicated holes M3



Step 9 - Caution

Please ensure correct assembled cylinder mounts are fitted to the correct assemblies



Step 10 - Assemble Large roller Table

5 off to be assembled

Use cylinder bracket assemblies with Socket cap heads

1 Mount 2 off D0015005 to prebuild cylinder assemblies as shown
Use M6 x 20 button socket , A form washer and M6 nyloc nuts to fix.
Do not use washer under head of button head screw, on use on on nut side

2 Adjust the 2 off D0015005

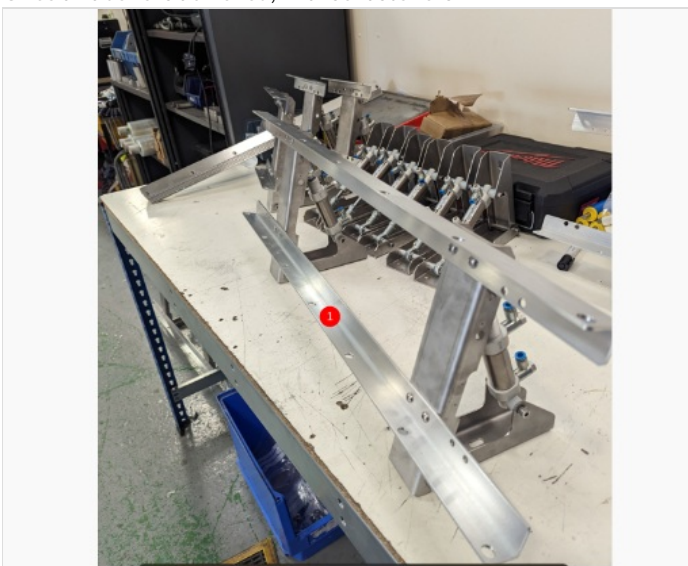
1st section pushed against edge of clearance hole in direction shown

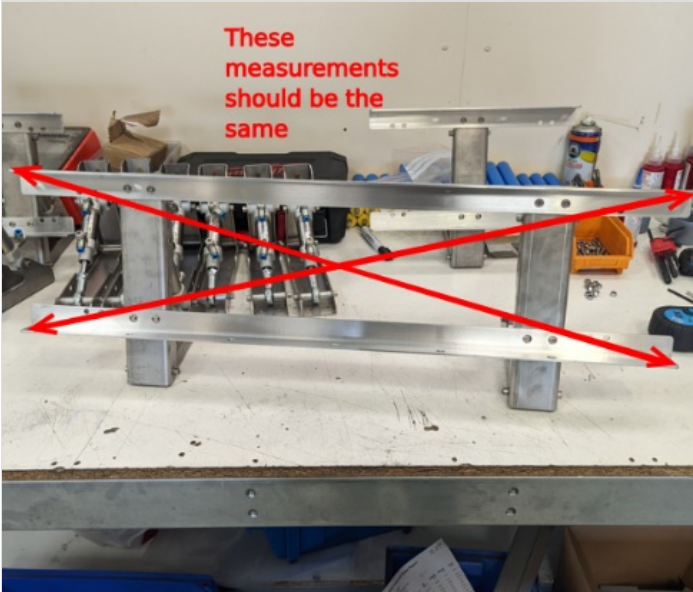
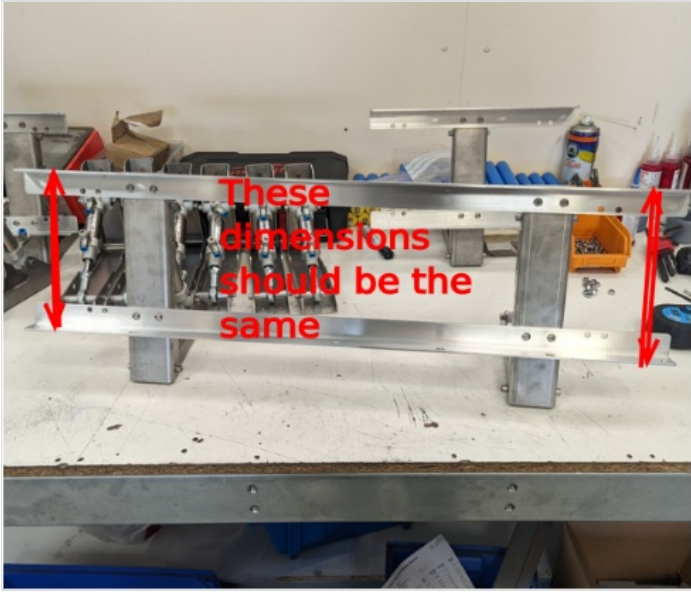
2nd section pushed in same direction

3rd Check parallel and adjust to correct

4th check squareness by taking corner measurements and adjusting if required

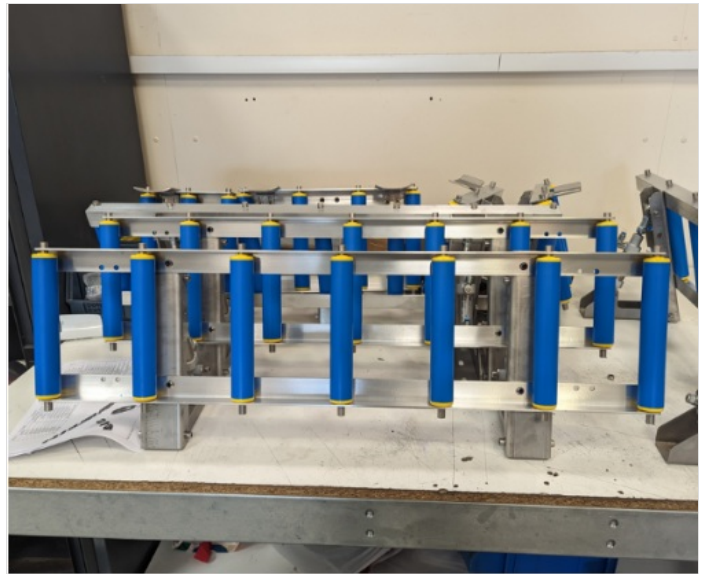
Once all above is achieved, finalise fasteners





Step 11 - Fit rollers

Fit 7 off B0001092 roller to each assembly



Step 12 - Back fence quality

D0015283 Saw Infeed Backfence Plate x 5 and D0015608 Saw Infeed Backfence Plate (Full Length) x 5 should be supplied from manufacturer free from burrs and sharp edges

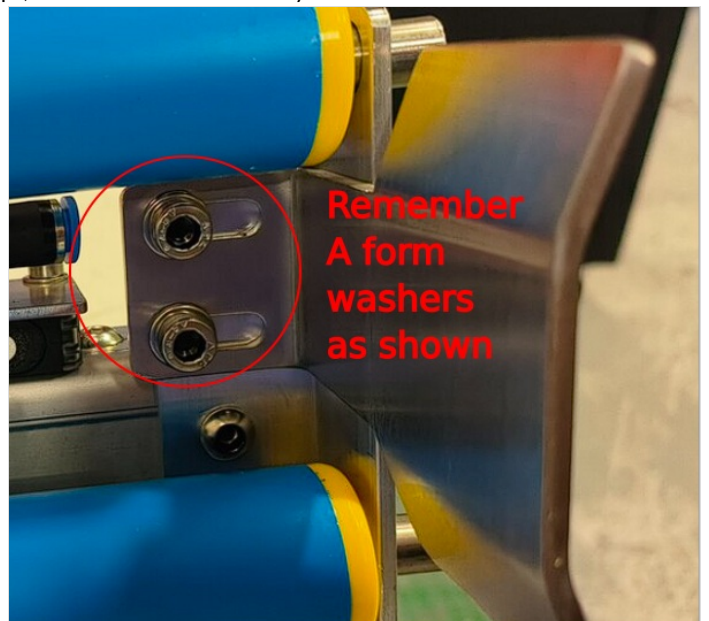
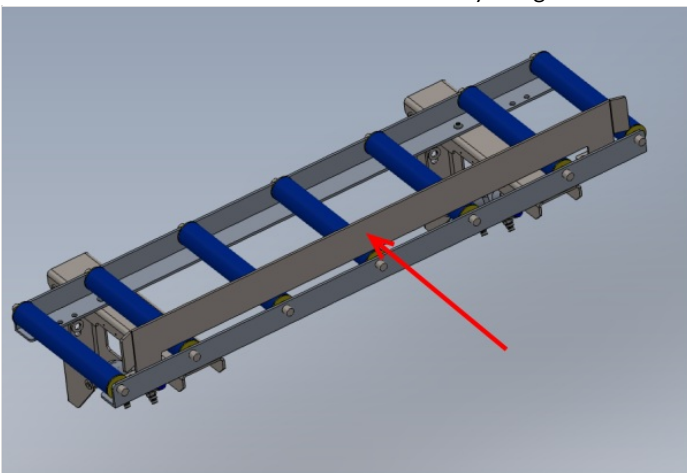
Please check these parts are correct, if sharp edges are present please report



Step 13 - Attach back fence

5 off

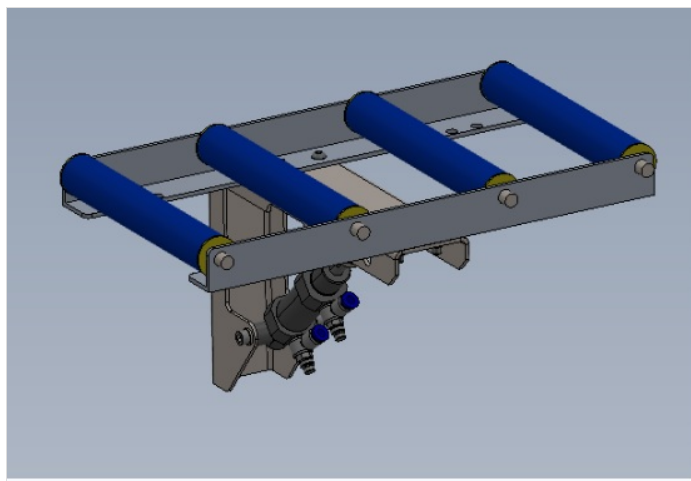
Attach D0015069 backfence to roller assembly using M6 x 16 socket caps, A form washers and M6 nyloc nut



Step 14 - Assemble medium roller table

Ensure cylinder assemblies with socket caps fitted are used on these assemblies

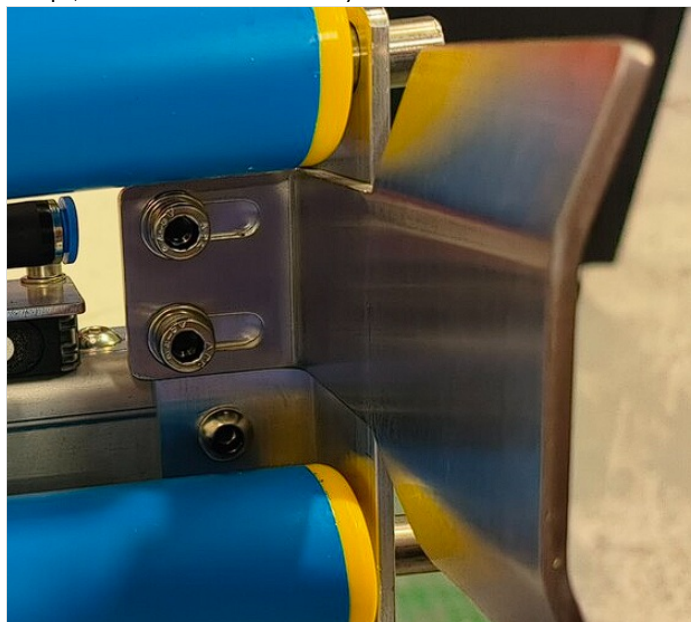
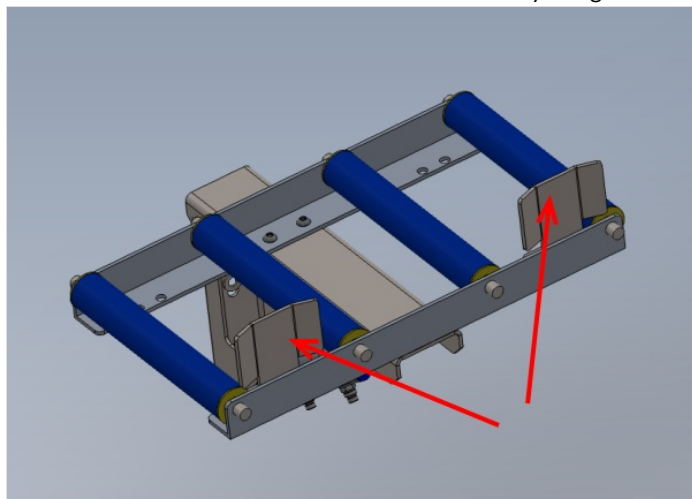
Using same checks and setting as above assemble 1 off roller table with 4 rollers as shown



Step 15 - Attach back fence

1 off

Attach 2 off D0015283 backfence to roller assembly using M6 x 16 socket caps, A form washers and M6 nyloc nut



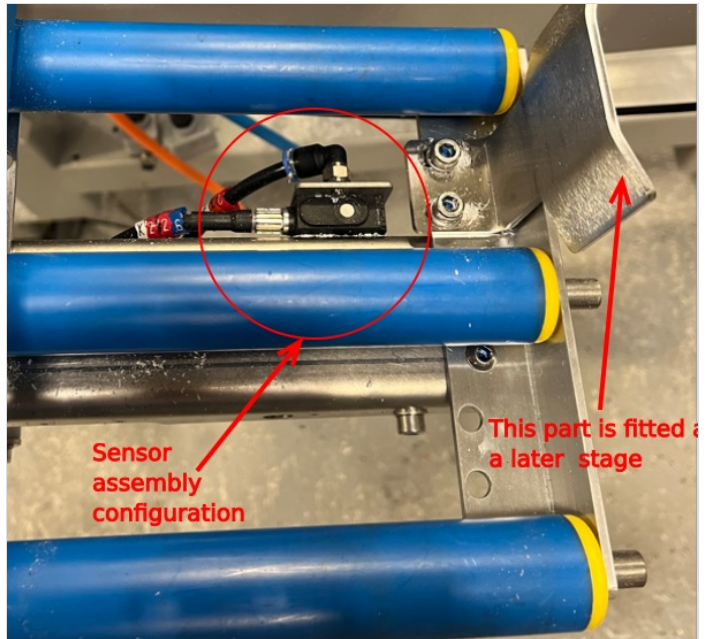
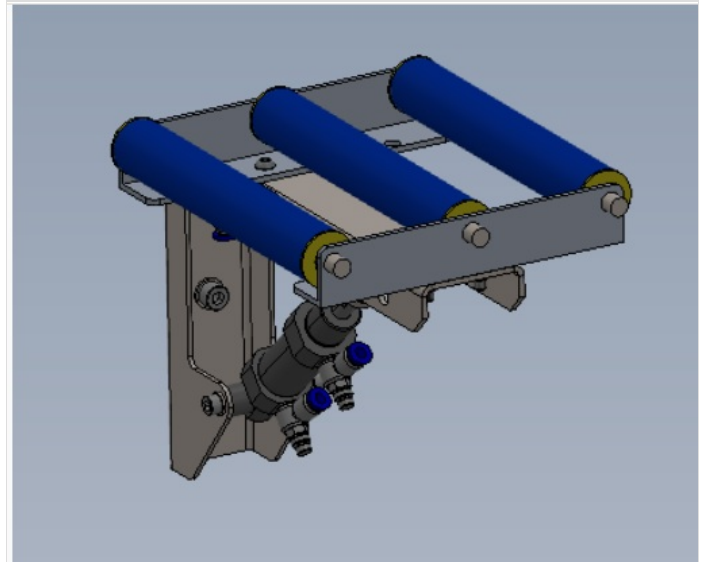
Step 16 - Assemble small roller table

Cylinder assemblies with HEX SET bolts must be used on these 3 off small roller tables

3 off

Using same checks and setting as above assemble 2 off roller tables with 4 rollers as shown,

Use the pre built cylinder bracket with m3 tapped holes for 1 off, and add 1 off Sensor E001120 ,1 off Blower P0000200 and 1 off bracket D0015547 as shown. Identify pipe as 2399 and fit P0000160 flow regulator to pipe

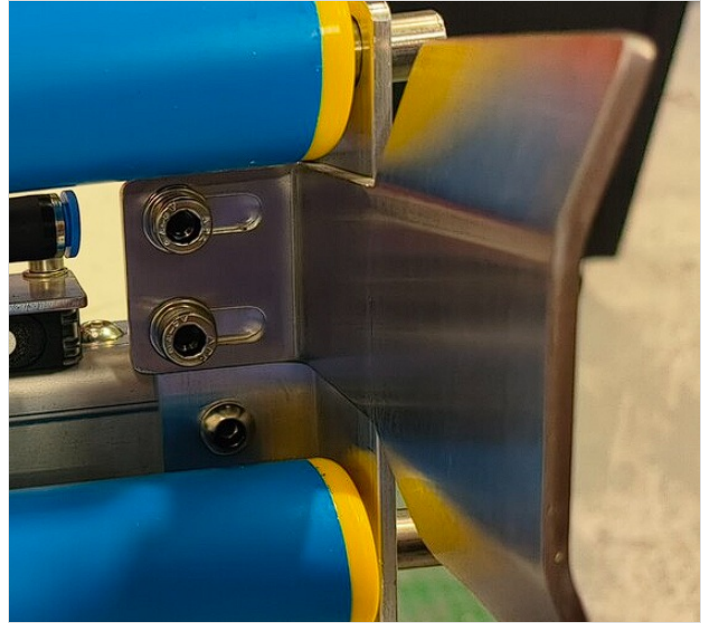
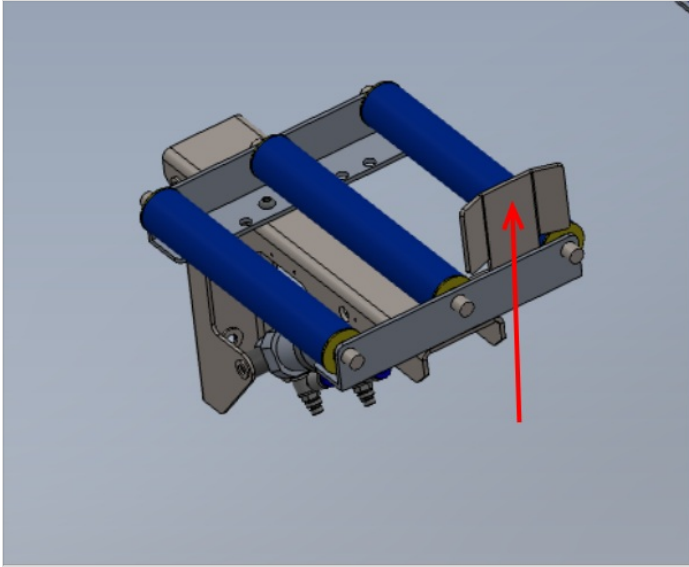




Step 17 - Attach back fence

3 off

Attach 1 off D0015283 backfence to roller assembly using M6 x 16 socket caps, A form washers and M6 nyloc nut



Step 18 - Pneumatic pre assembly

5 off

7 Roller bed assemblies with two cylinders require pneumatic pipe installation.

Use identification numbers as follows

1461 Home position

1469 Active position (down)

