

R0015081 Bench Assemble Single Roller Table

Assembly details for individual roller assembly

 Difficulty **Medium**

 Duration **1 hour(s)**

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Assemble Cylinder assembly

Step 3 - Check for rework

Step 4 - Check for rework of following parts

Step 5 - Insert Bush

Step 6 - Insert bushes into cylinder arm

Step 7 - Attach cylinders to brackets

Step 8 - Attach D0015006B

Step 9 - Attach D0015594

Step 10 - Fit rollers

Step 11 - Attach Roller bed mount

Comments

Introduction

Tools Required

Standard Hex key set

Standard spanner set

Parts Required

B0001103 Bush Flange 8 I/D 10 O/D 3.8 Long iglidur J type x 2

B0001154 Plastic Roller Blue Ø30 x 160 Long. Spring Loaded Shafts x 4

B0001168 Bush Sleeve 8 I/D 10 O/D 8L iglidur J type x 2

D0015001 Roller Bed Cylinder Arm x 1

D0015002 Shaft 10mm: 58mm Rod End x 1

D0015006B Roller Bed Arm Bracket x 1

D0015481 Shaft 8mm: 50mm Cylinder Pivot x 1

D0015483 Infeed Loader Roller Bed Mount x 1

D0015594 Roller Bed Rail (Loader Wheel) x 2

D0015603 Roller Bed Pivot Shaft (silver steel) x 1

P0000049 Cylinder Spherical Bearing M10 x 1.25 x 2

P0001110 Cylinder 25 x 10 x 2

P0001198 Air Fitting x 4

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 Cylinder assembly

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

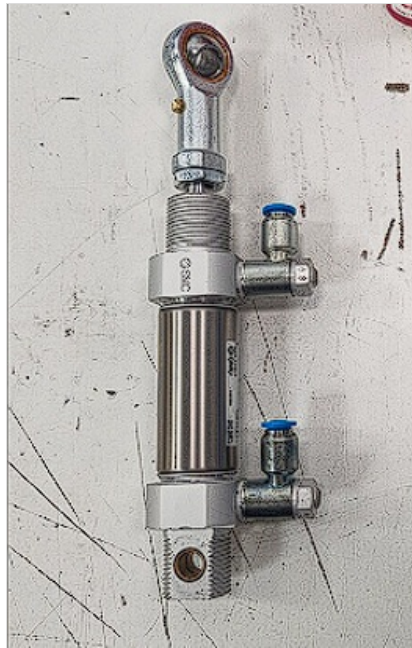
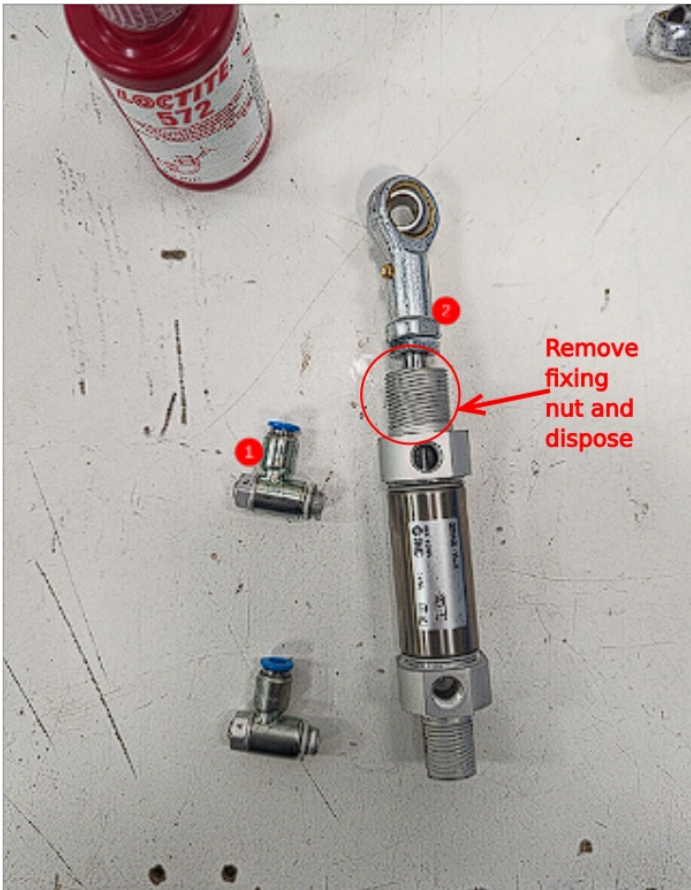
2 off

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 or adhesive to the nut



Step 3 - Check for rework

1 off

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

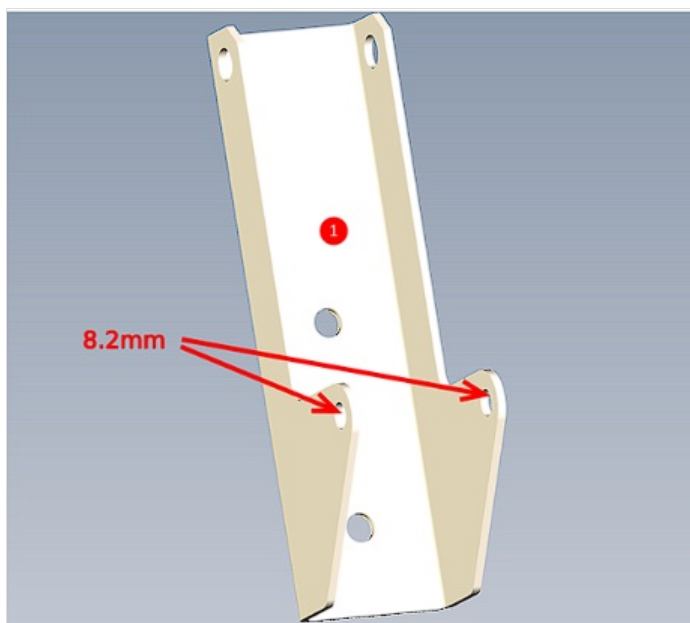
Drawing change requested 06/06/23 to amend from 8mm to
8.2mm



Step 4 - Check for rework of following parts

1 off

1 D0015006B indicated holes should measure as shown. Rework by
hand if issued old spec
ECR raised 06/06/23



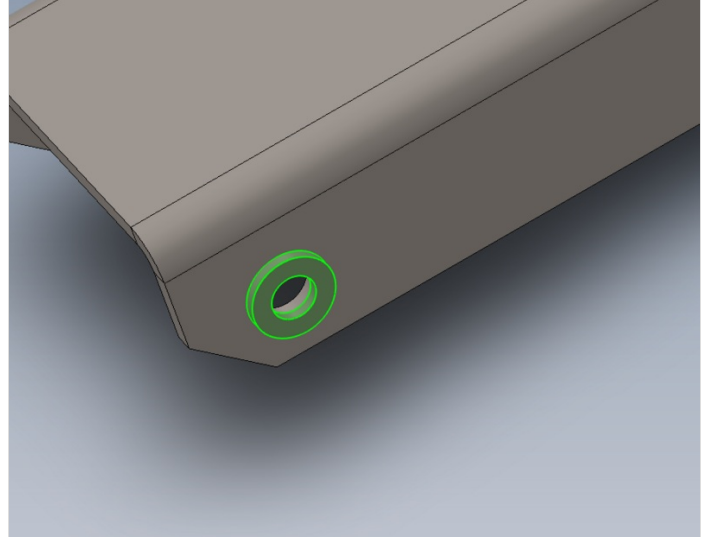
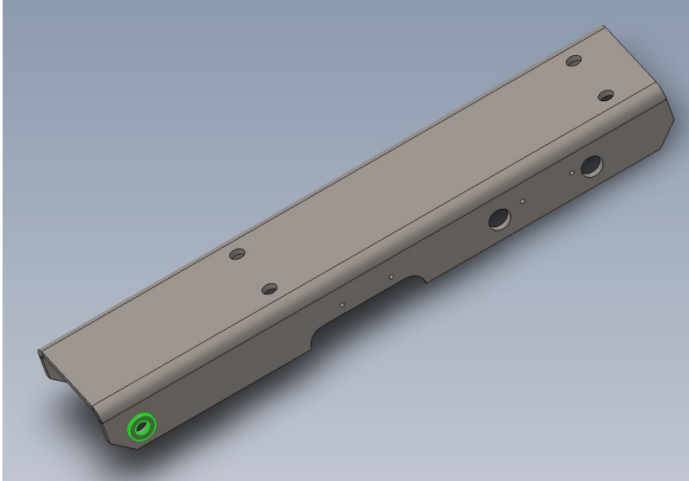
Step 5 - Insert Bush

Insert bush B0001168 2 off into P0000049 spherical bearing 2 off



Step 6 - Insert bushes into cylinder arm

Insert 2 off B0001103 bush flange into Roller cylinder bed arm as shown S

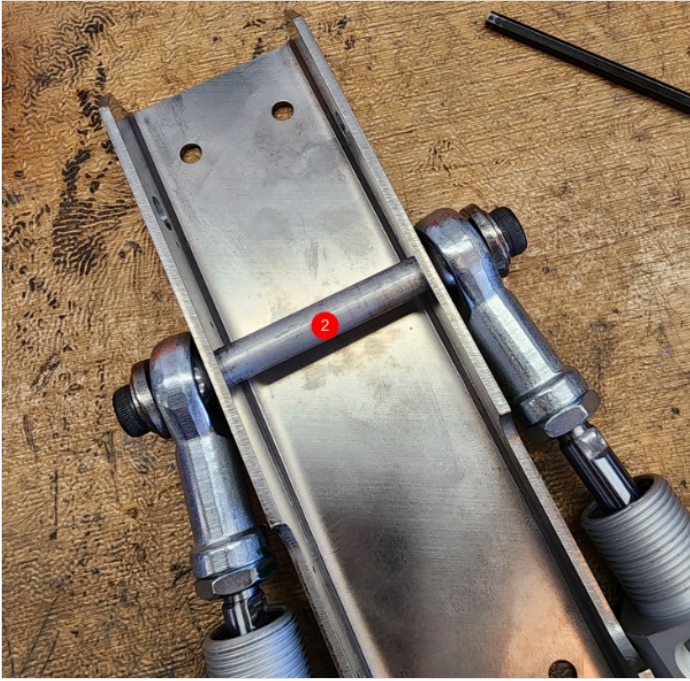


Step 7 - Attach cylinders to brackets

1 Attach 2 off cylinders to D0015001 using M6 x 8 x20 shoulder bolts with M8 A form washer and Heavy M8 washer to space as shown

2 Attach to D0015002 as shown

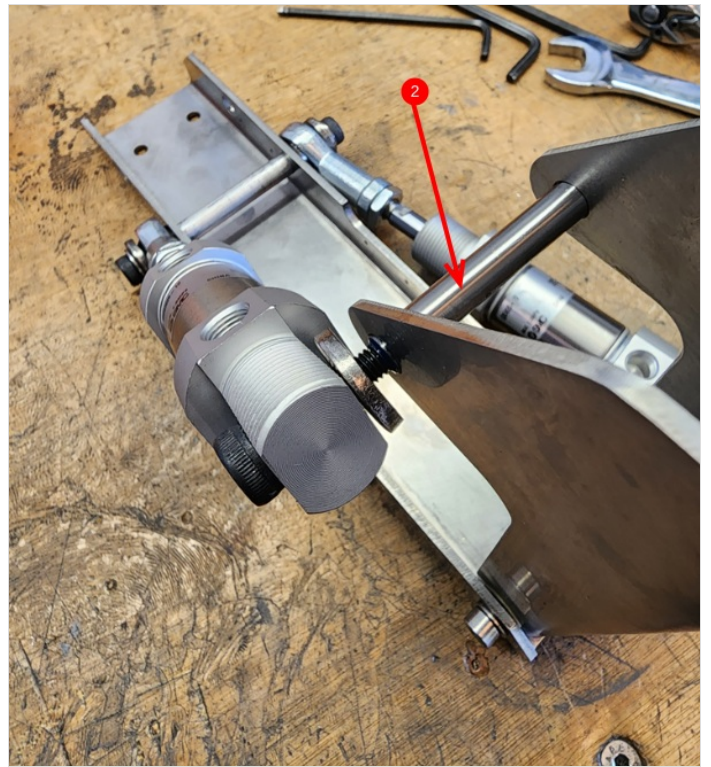
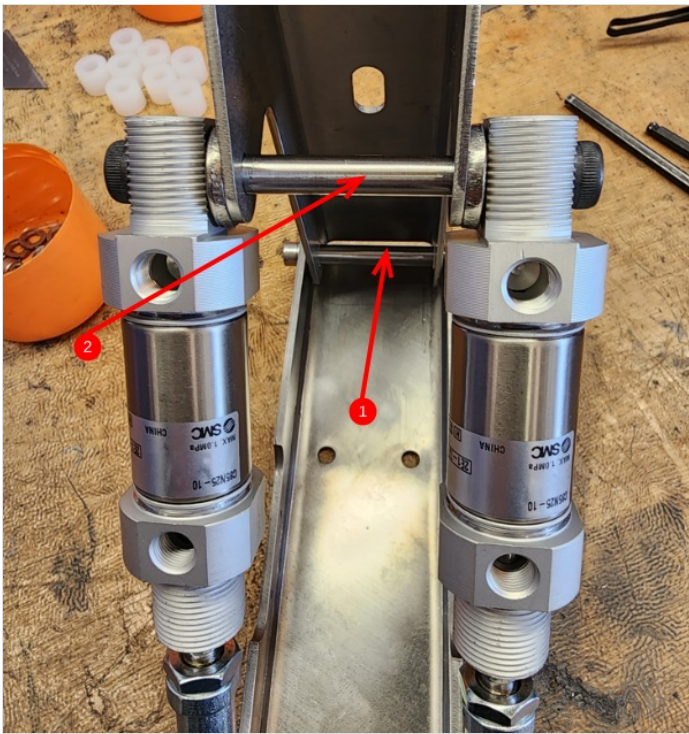




Step 8 - Attach D0015006B

1 Fit 1 off D0015603 pivot shaft with 2 off M6 x 12 socket caps and A Form washers

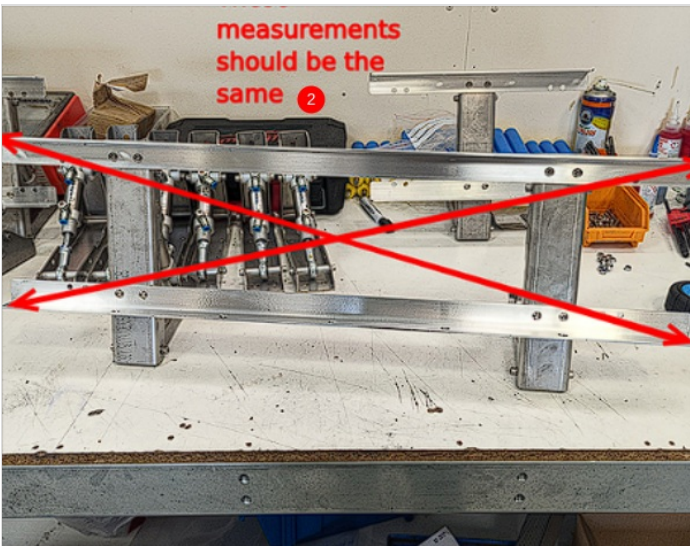
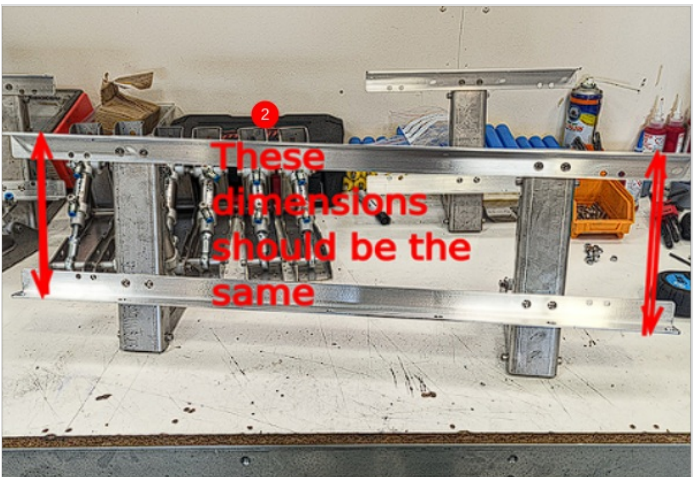
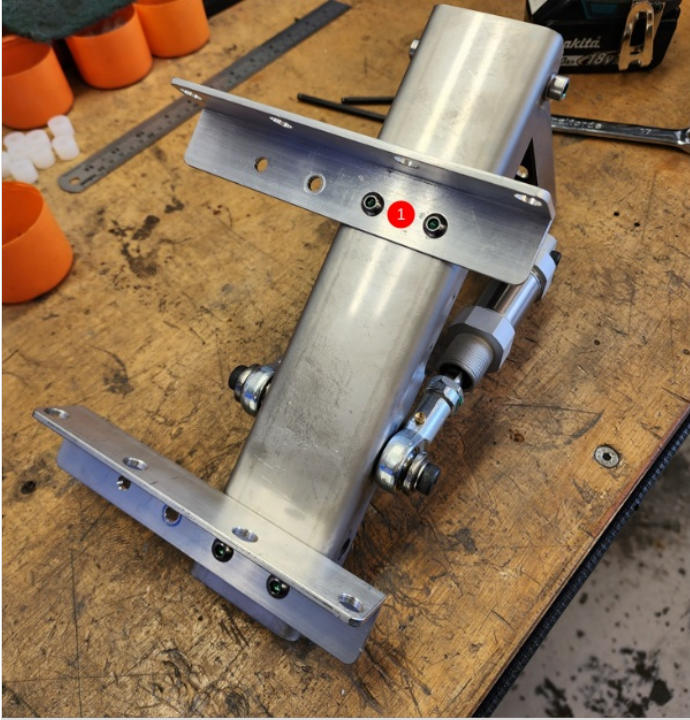
2 Use D0015481 shaft to fix base of cylinders as shown with M6 x 8 x 20 shoulder bolt and spaced with M8 heavy washer as shown



Step 9 - Attach D0015594

1 Attach 2 off d0015594 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 nut side

2 Align 2 off parts using checks shown (different assembly shown but checks remain the same)



Step 10 - Fit rollers

Fit B0001154 Plastic Roller Blue Ø30 x 160 Long. Spring Loaded Shafts x 4



Step 11 - Attach Roller bed mount

Attach D0015483 as shown using M8 x 25 socket caps, Heavy M8 washers and M8 nyloc nuts



