


R0015084 Bench assemble and Drill Off Swarf chutes

Drilling and assembly details for swarf chutes

 Difficulty **Medium**

 Duration **2.5 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set

Standard HSS drill set

Standard tap set

Standard spanner set

Parts Required

D7908 Swarf chute front section (OH-D0002973)

D7905 Swarf Chute Front Section Small (OH D0008702)

H0007907 Swarf dispersal lip x 1

H0007909 Swarf corner left x 1

H0007910 Swarf corner right x 1

H0007946 Front swarf chute infill x 1

P0000047 Bulkhead Elbow 6mm x 2

P0000152 Bulkhead Elbow 8mm x 2

P0000161 Plug-in Reducer 6mm Tube 8mm Fitting x 2

P0000489 Air Nozzle Flat(Air Knife) x 2

P0000540 Straight Adaptor Ø8mm x 1/4" BSP Female x 2

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 572 on all threaded pneumatic connection

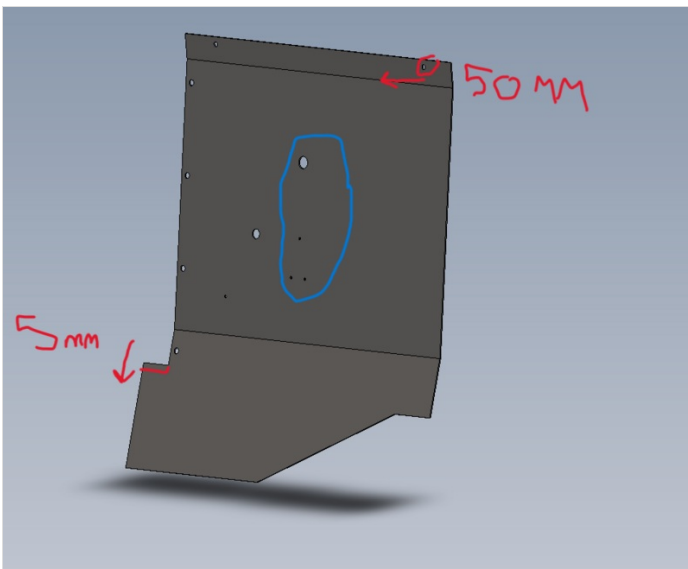
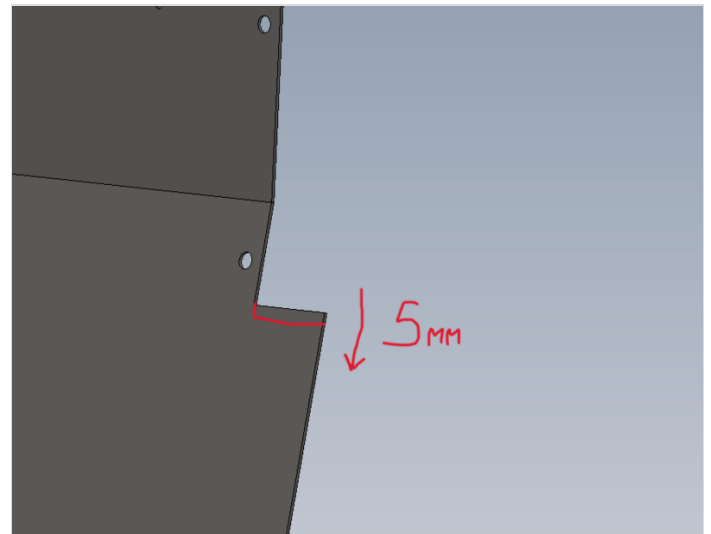
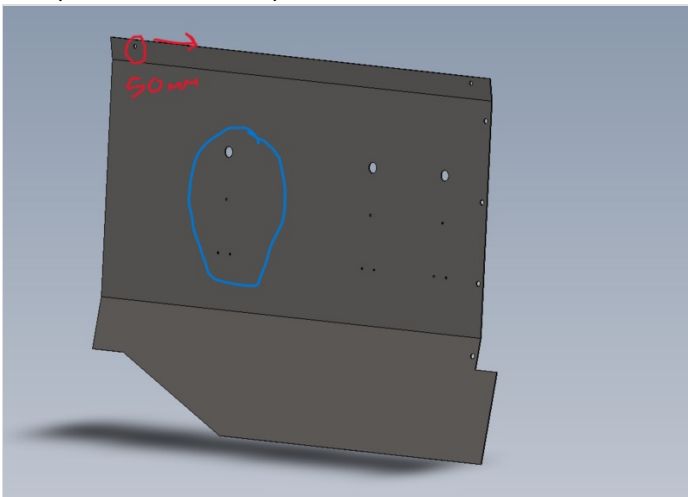
Pen mark all fasteners to show finalised



Step 2 - ECR raised

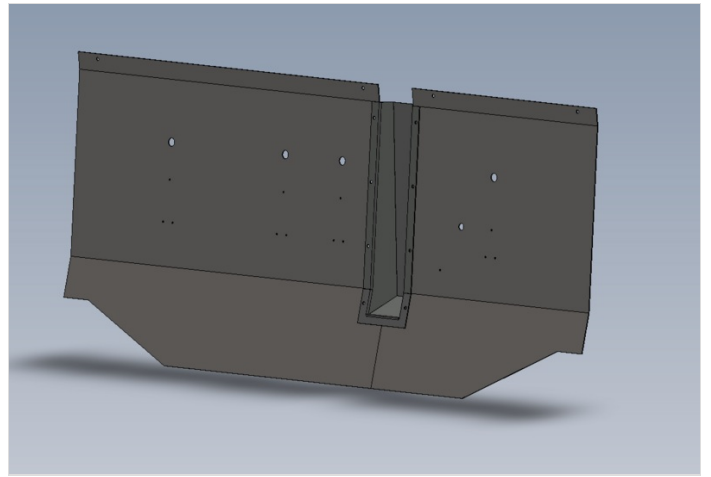
Ecr raised to cover current reworks to panel

Until processed rework at production



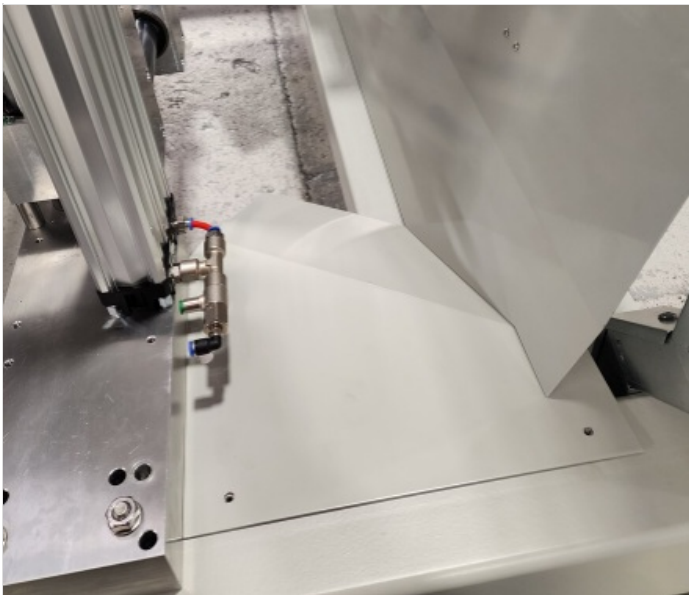
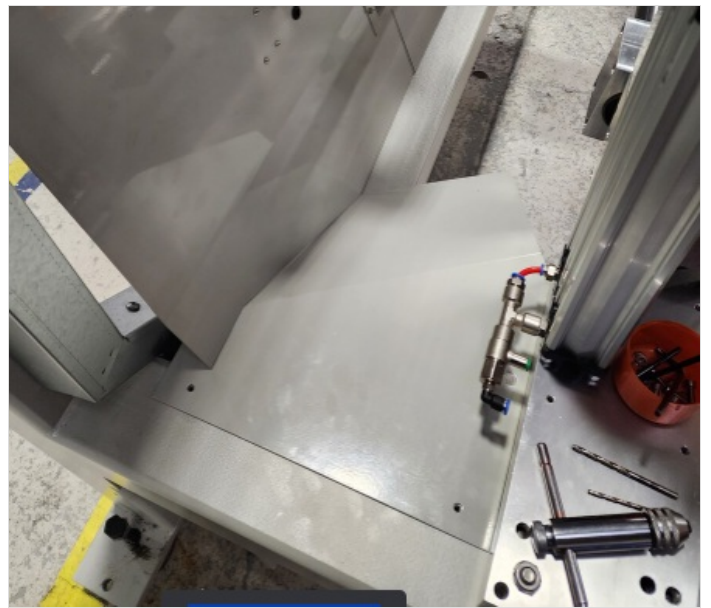
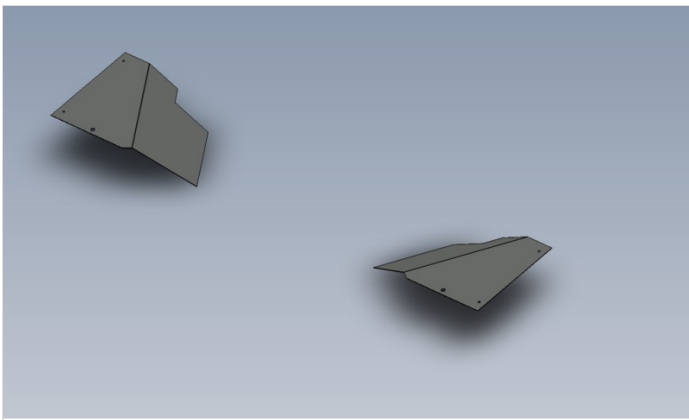
Step 3 - Assemble chutes

Assemble chute panels as shown



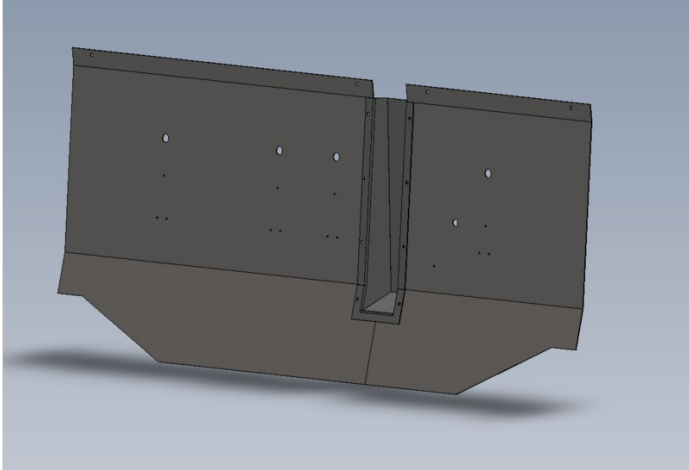
Step 4 - Position swarf corners

Position swarf corners onto main frame



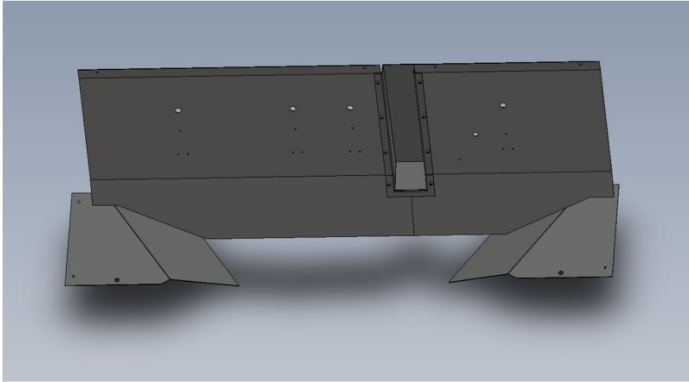
Step 5 - Position assembled chute

Position assembled chute into frame



Step 6 - Adjust chutes and corners

Adjust panels to best fit

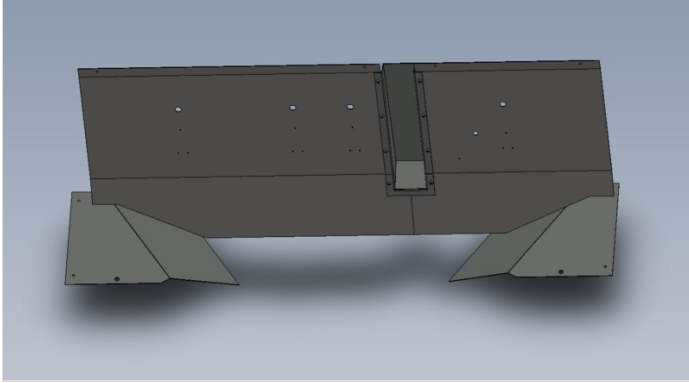


Step 7 - Drill off to suit

Drill to suit all fixing holes @ M5

8 off in total

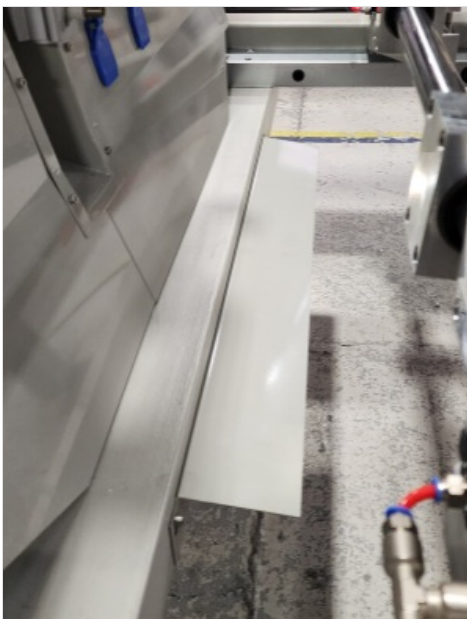
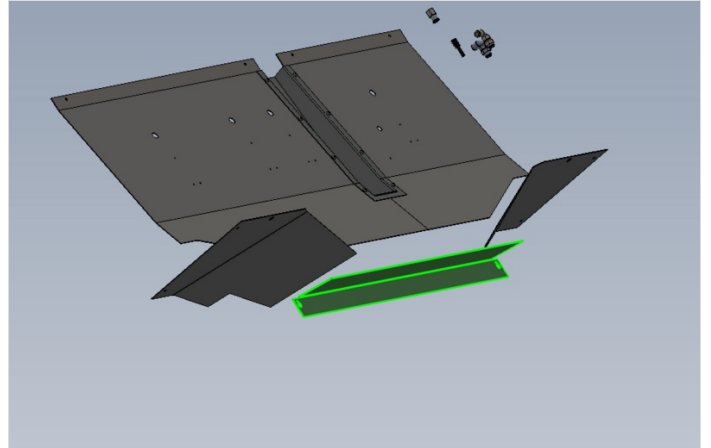
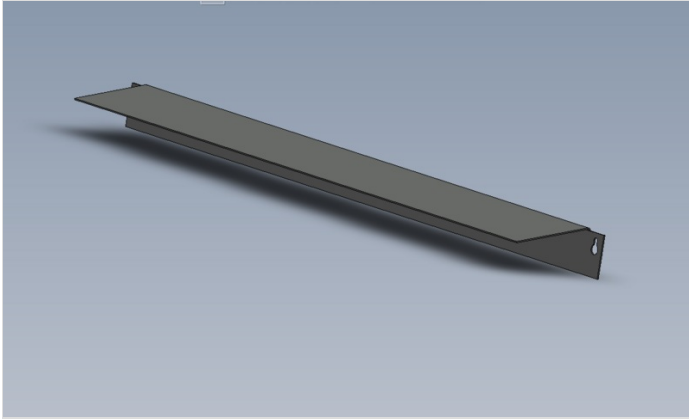
If upper holes are not able to be used due to position, an additional fixing hole may be required to fix



Step 8 - Mark lower chute position

With chutes still fitted, align and mark lower lip chute

Align with bottom of lifting channel and central between fitted chutes

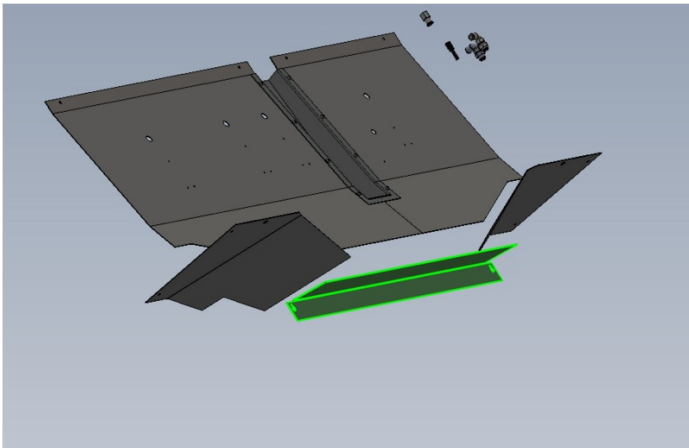


Step 9 - Remove all chutes

Remove all chutes and drill marked fixing points for lower lip chute

Drill 2 off M5

Final fit lower lip using 2 off M5 x 12 socket caps and





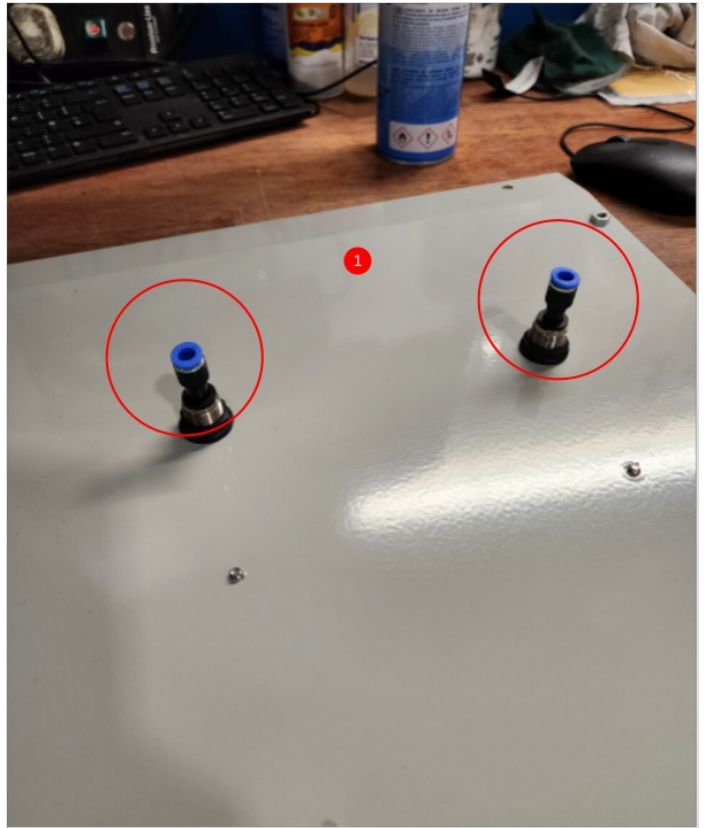
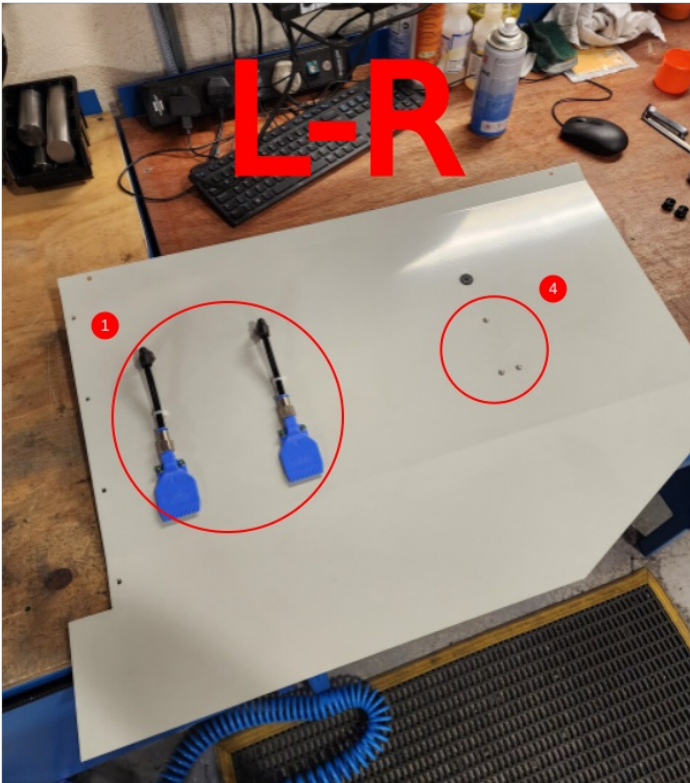
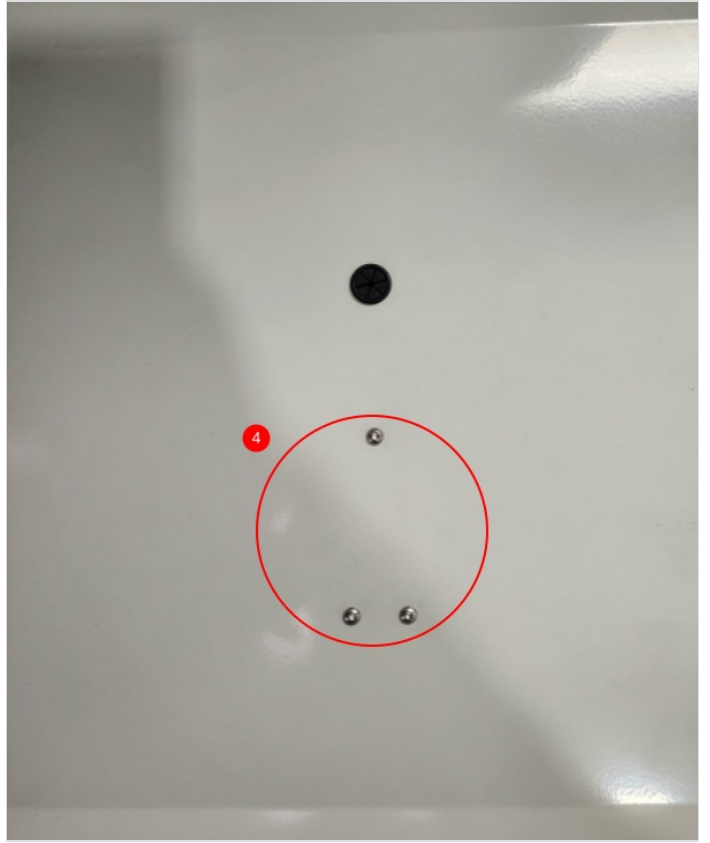
Step 10 - Assemble chutes

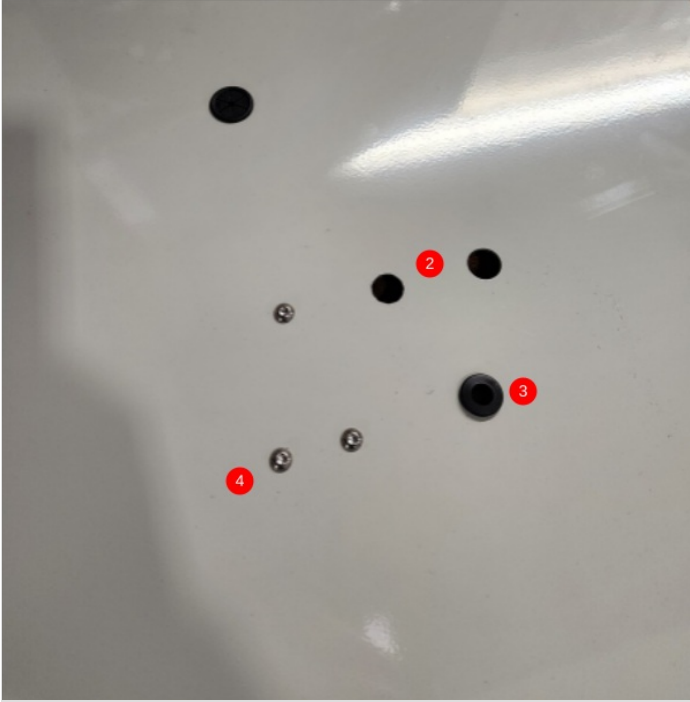
1 Fit blowers to chutes and add connecting 8mm black pipe. Fix with M4 tie base and tiewrap. Fit P0000161 Plug-in Reducer 6mm Tube 8mm Fitting x 2 to rear

2 Add 2 off 6mm bulkheads and tie base for clamp feeds

3 Add grommit for clamp reed switch

4 If present blank redundant M4 holes with M4 x 6 button heads





Step 11 - Label bulkheads both sides of panel

Label 6mm bulkheads both sides of panel as

3501 and 3502

