


R0015093 Bench Assemble Transfer Beam

Bench assembly details for correct assembly of transfer rails

 Difficulty **Medium**

 Duration **5 hour(s)**

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Comments

Introduction

Tools Required

Standard Hex key set

Standard hand taps

V rail alignment Jigs

Drill driver and 4mm hex fitting **Parts Required**

B0001155 OpenRail 1000mm Long x 32

B0001170 spacer x 320

D0015571 Transfer Arm (2018) x 9

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 570 on all threaded pneumatic connections

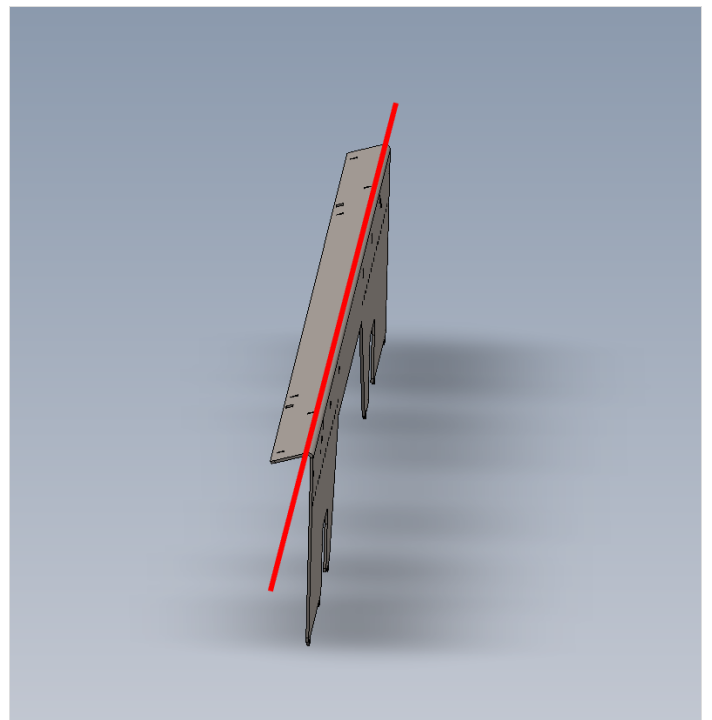
Pen mark all bolts when finalised



Step 2 - Quality Check

All bare transfer beams should be visually checked for straightness on the indicated face .

Any discrepancy should be reported



Step 3 - Transfer beam preparation

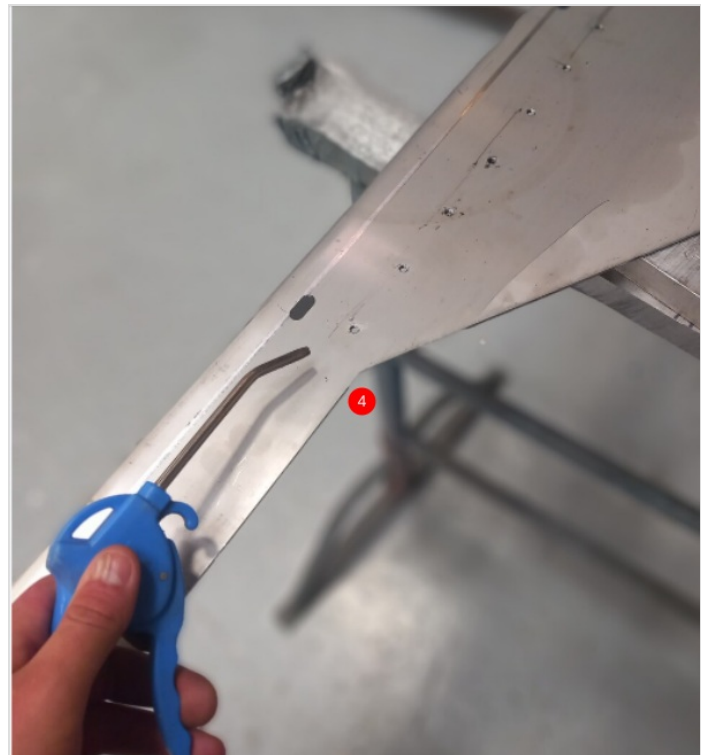
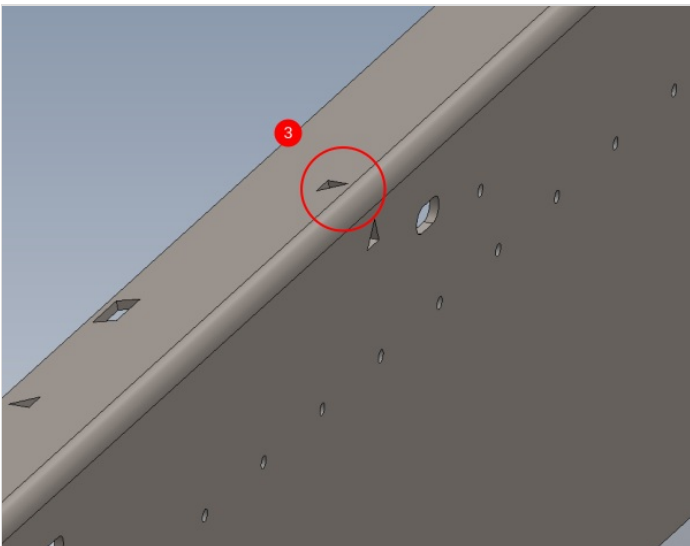
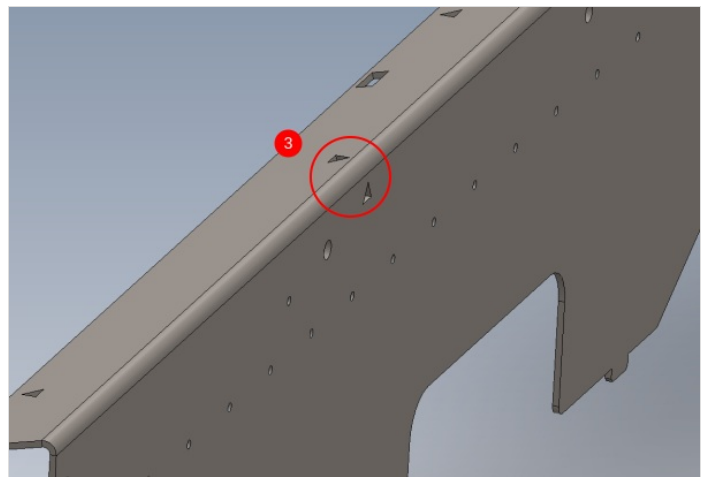
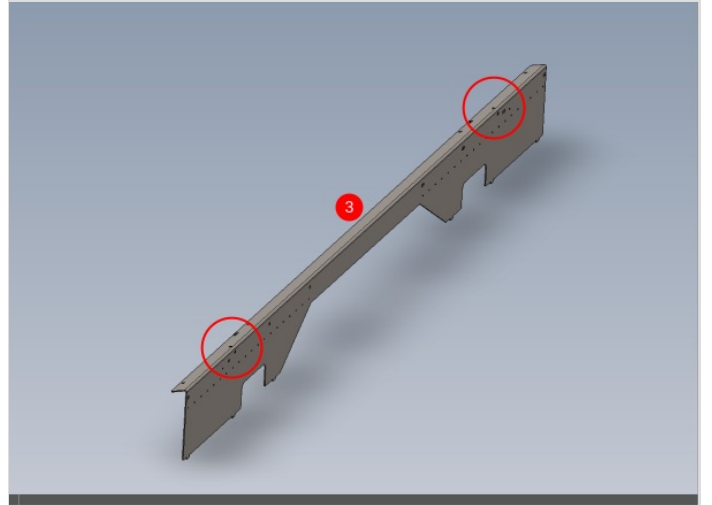
1 Remove all protective plastic wrap from D0015571 Transfer Arm (2018)

2 Tap all holes to clear debris.

3 Check area shown for sharp edges burrs. If present, dress down and report as rework. Use grinder with 'polirico' attachment

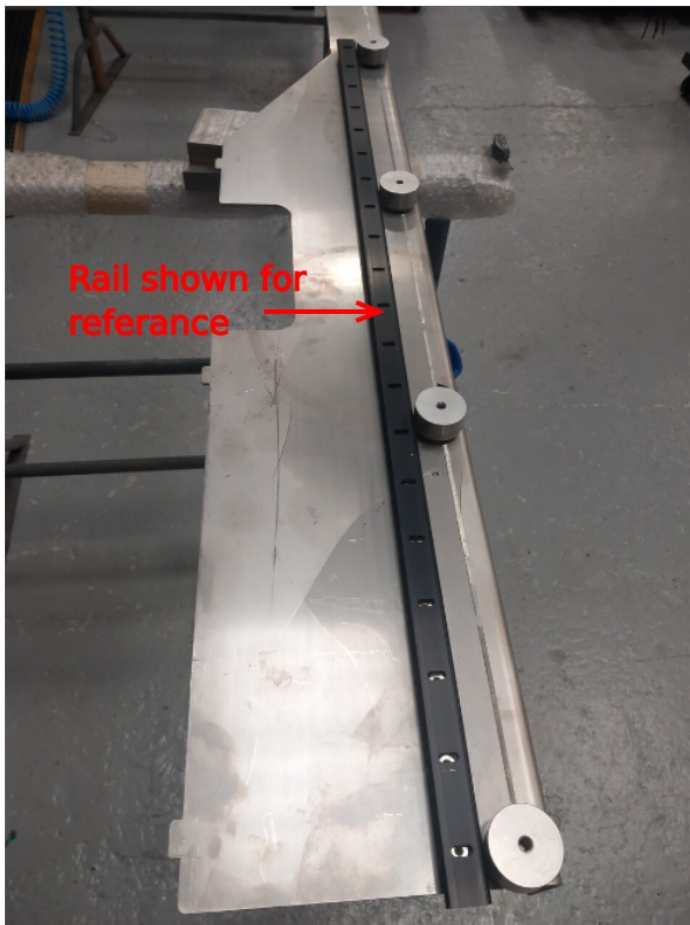
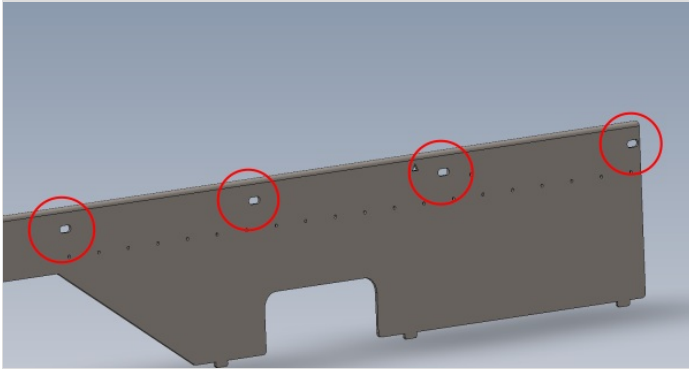
4 Clean with air to remove swarf and debris

5 Wipe transfer beams with duck oil on a clean rag



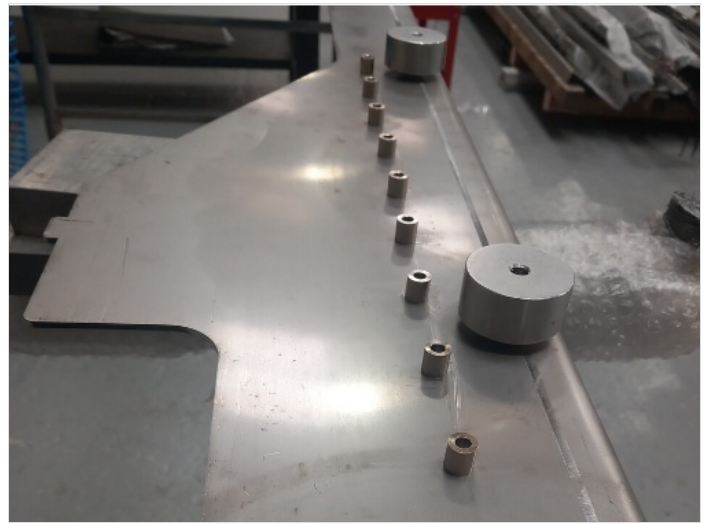
Step 4 - Fit V alignment jigs

Fit 4 off alignment jigs as shown, using jig fasteners



Step 5 - Align spacers

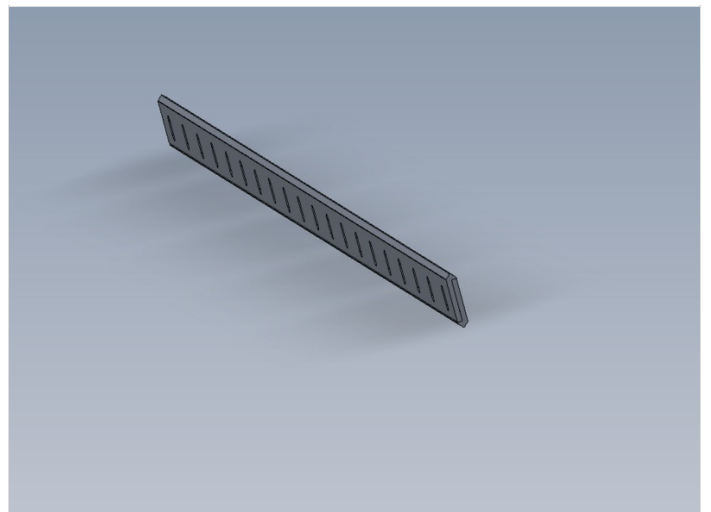
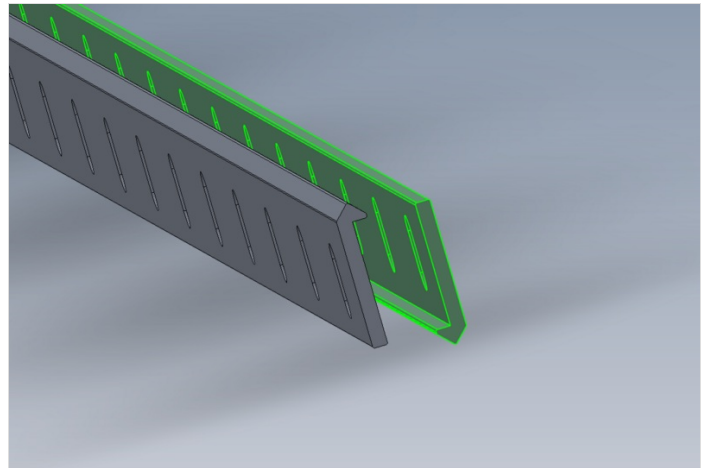
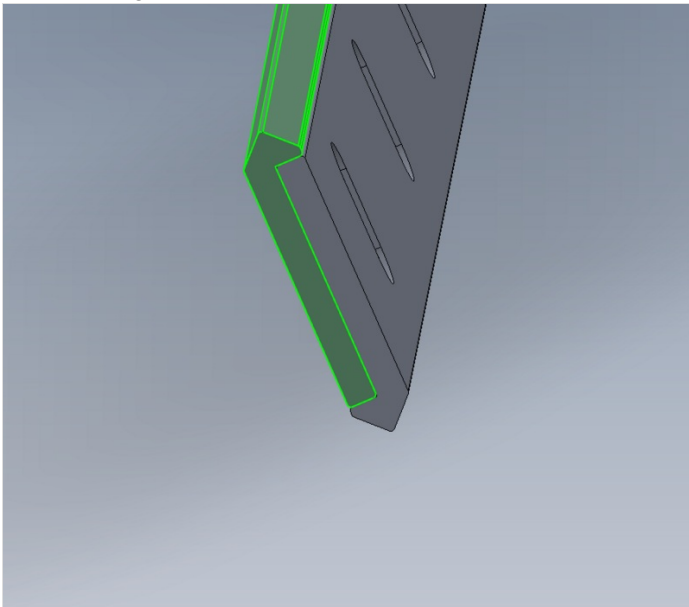
Align 20 off B0001170 spacer over fixing holes as shown



Step 6 - Prepare Rail

Each V rail contains 2 off B0001155 OpenRail 1000mm Long

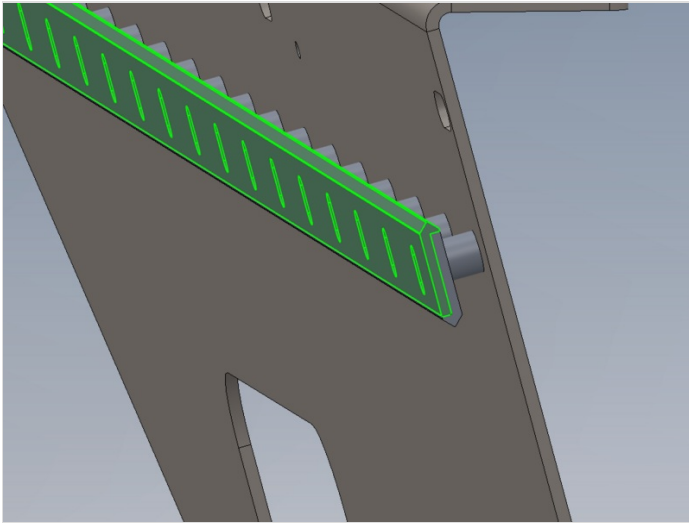
Clean and align 2 off as shown to create One double V rail



Step 7 - Position Rail

Position assembled rail over spacers as shown.

ensure correct orientation of assembled rail as shown



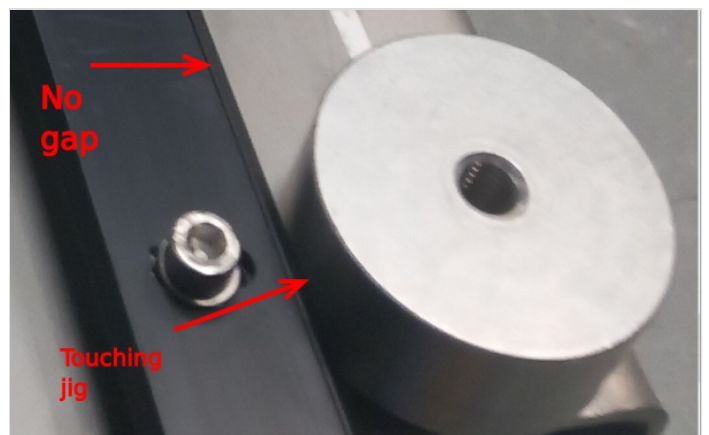
Step 8 - Add Fasteners

1 Use M5 x 25 socket caps and M5 A form washers to fix V rail to beam

2 Ensure V rail is touching jigs and assembled V rails are fully closed

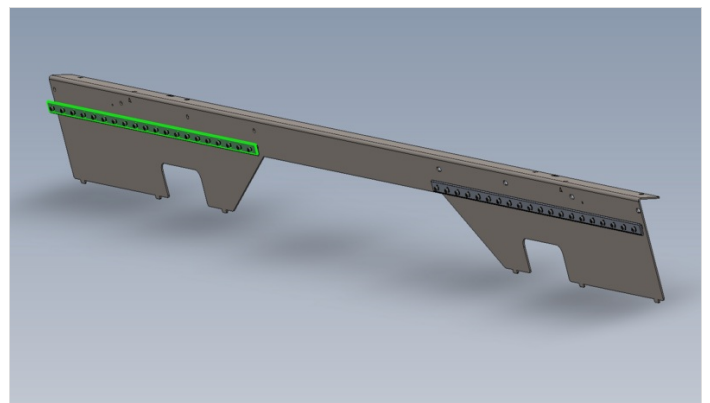
3 Used pistol drill on torque setting 5 with 4mm bit to drive fasteners into place

4 Finalise by hand



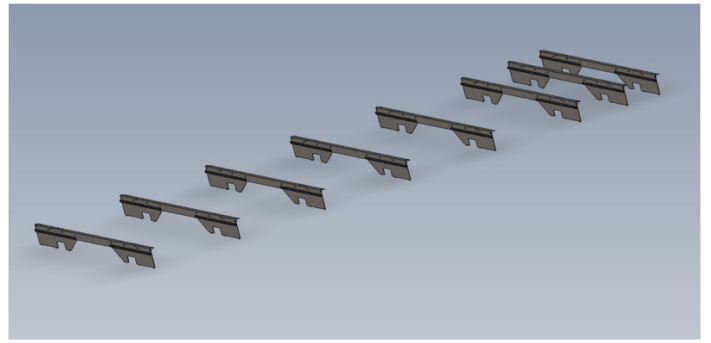
Step 9 - Repeat for 2nd V rail

Repeat process for second rail on transfer beam



Step 10 - Repeat for 7 more transfer beams

Repeat process and assemble 7 more transfer beams following the previous steps



Step 11 - Note

1 transfer beam does not have any V rails attached

In total

8 transfer beams to be fitted with 2 V rails per beam

1 transfer beam to be fitted with no V rails

