



R0015250 Bench Assemble Support Arms

Instructions for bench assembly of support arms

 Difficulty Easy

 Duration 5 hour(s)

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Clean all threads

Step 3 - Align spacers and fit setting jigs

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Step 5 - Fit support arm spacers to arms

Comments

Introduction

Tools Required

Standard hex key set

Standard tap set

Setting jigs

Parts required

B0001170 Spacer 180 off

B0001155 open rail 18 off

D0015552 Transfer Support arm R/H (right to left machine) OR D0015553 Transfer Support Arm L/H (Left to Right machine)

D0015554 x 18

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

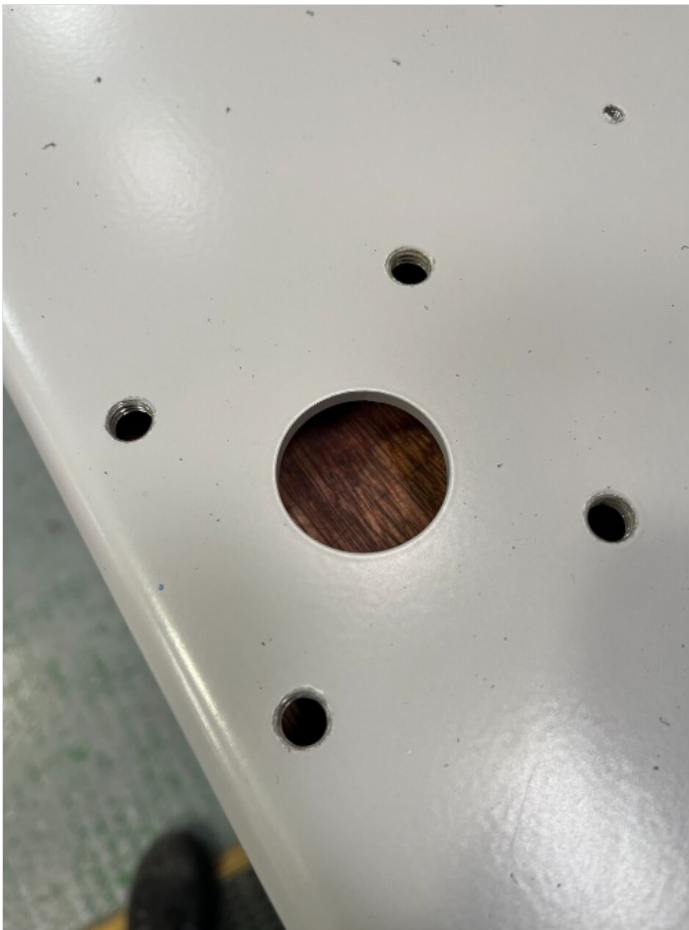
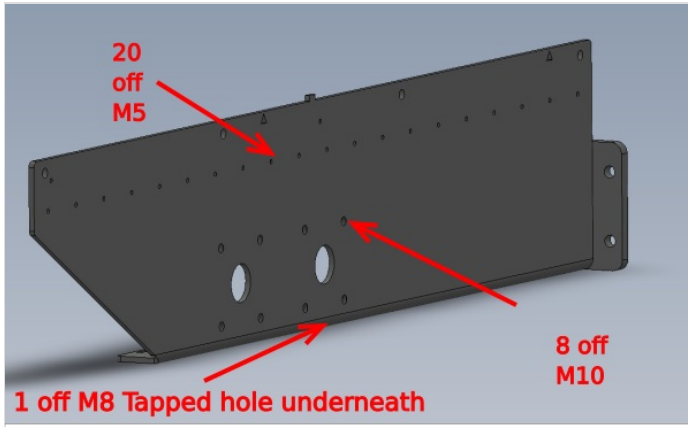
Use Loctite 572 on all threaded pneumatic connections

Pen mark all bolts to show finalised



Step 2 - Clean all threads

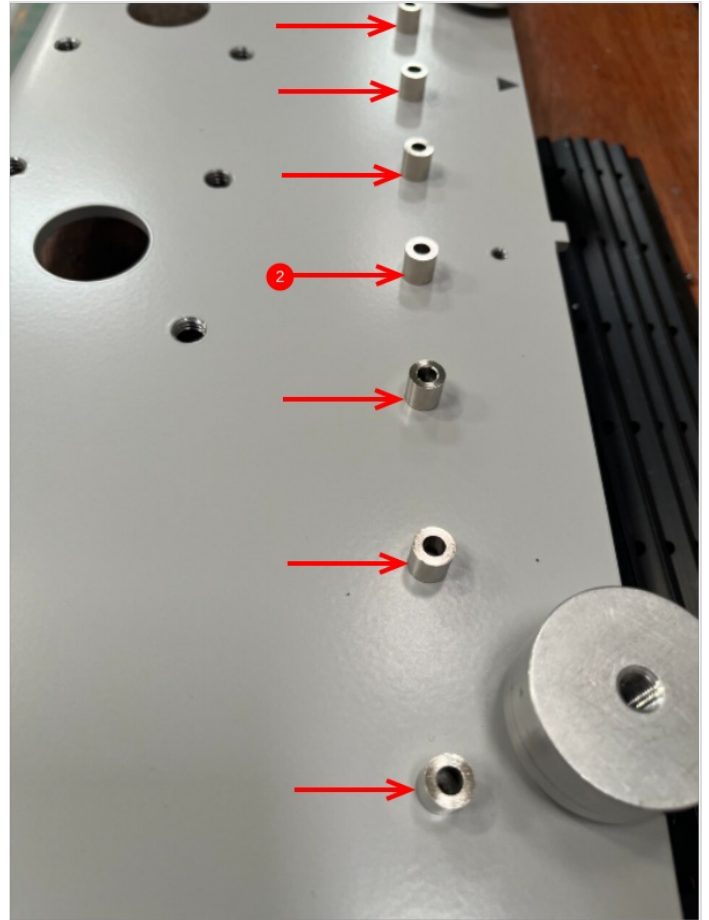
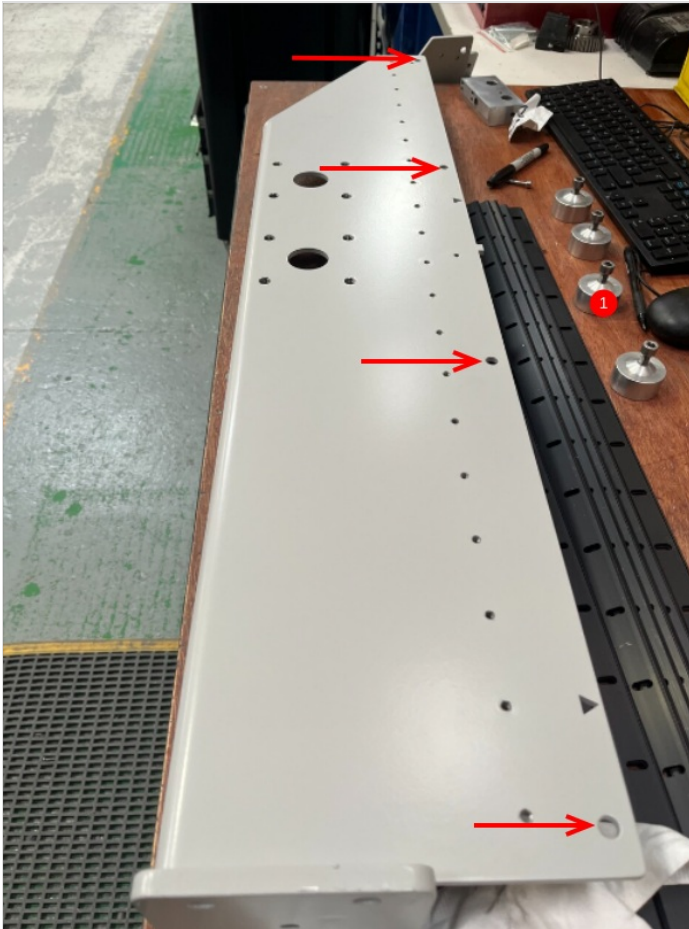
Use Drill on speed one torque 15 and tap to remove debris build up from coating process in all tapped holes in each support arm



Step 3 - Align spacers and fit setting jigs

1 Mount 4 off setting jigs to arm on the indicated points

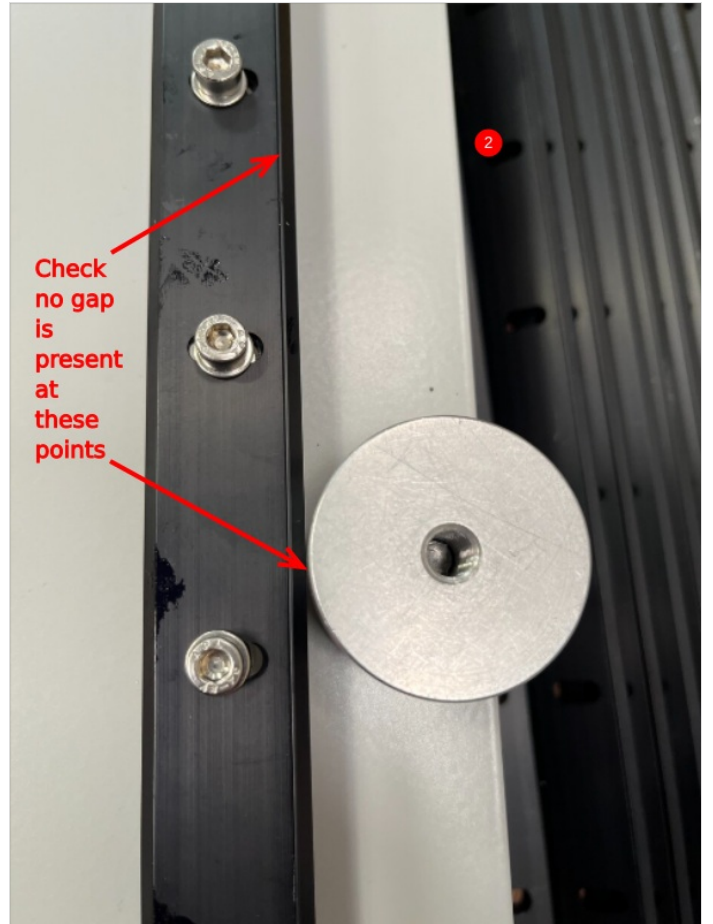
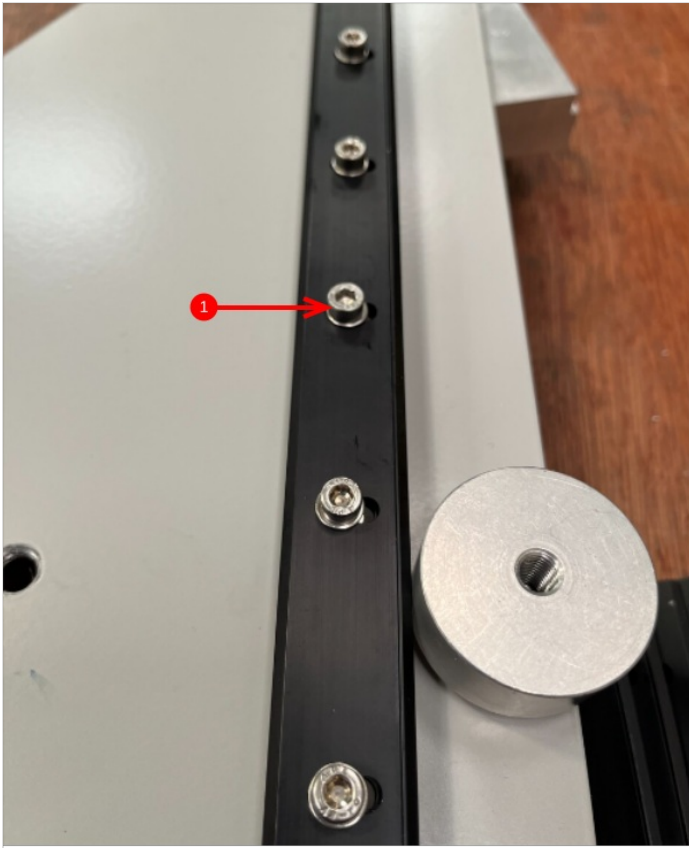
2 Align 20 off B0001170 spacers over all m5 holes

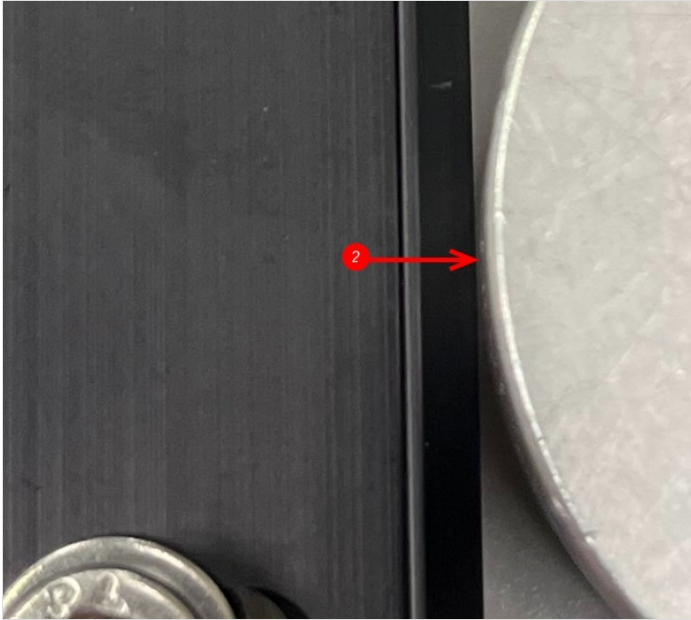


Step 4 - Fix Rail to arm

1 Use 20 off M5 x 25 socket caps and A form washer with loctite 243 to fix rail to arm

2 Ensure rail touching setting jig as indicated and two rails are pushed completely together





Step 5 - Fit support arm spacers to arms

2 off per arm

Secure with M8 x 20Hex head Set bolt and finalise with Loctite 243 adhesive

Please provide photo

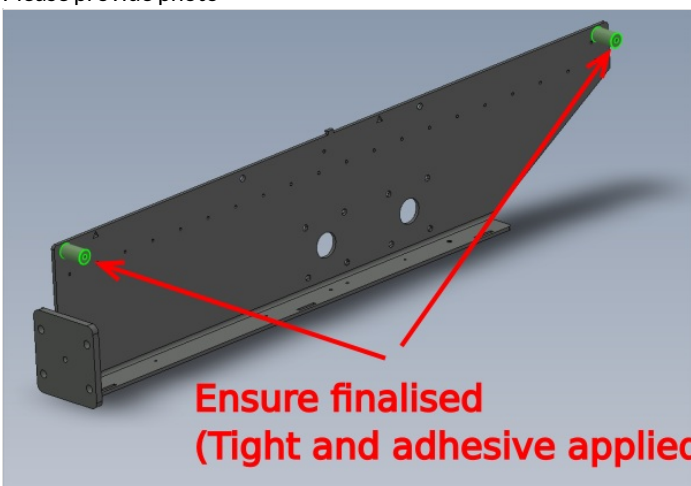


Photo
Required