

# R0015094 Fit shafts and Pinions

Instructions for installing main drive shafts to support arm assembly

 Difficulty **Medium**

 Duration **3 hour(s)**

## Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Bearing position Clarification

Step 3 - Attach Bearings

Step 4 - Location of shafts

Step 5 - Fit shafts and pinions

Step 6 - Couple shafts

Step 7 - Fit keys

Step 8 - Lubrication

Comments

## Introduction

### Tools Required

Standard Hex key set  
Grease gun and grease

### Parts Required

Previously assembled parts from R0015094 Bench Assemble shafts, Bearings and Pinions

B0001100 x 24

B0001153 x 2

B0001165 x 2

## 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

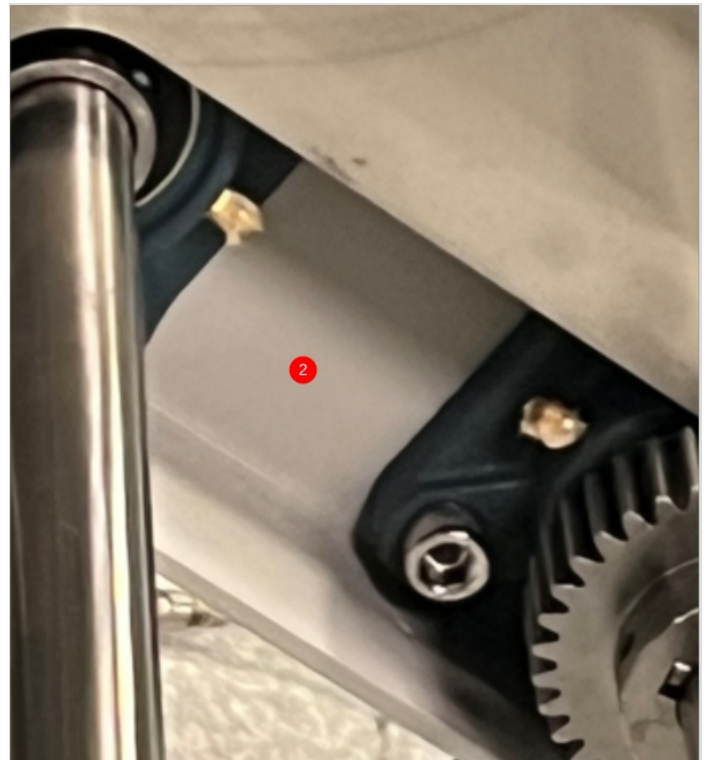
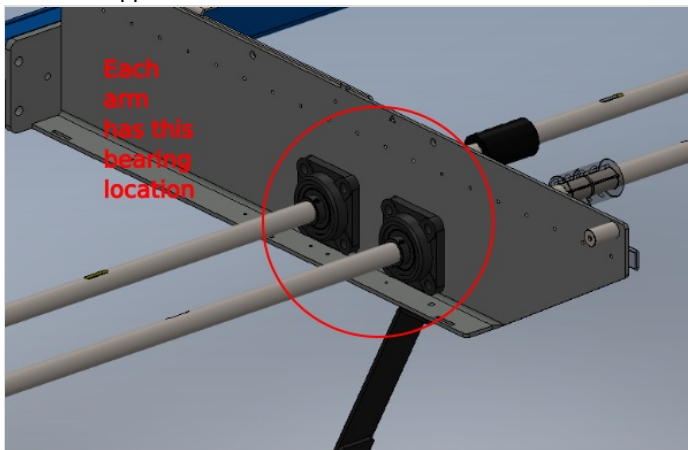


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## Step 2 - Bearing position Clarification

1 Bearings should be located as shown on each arm

2 Grease nipples to face each other as shown



## Step 3 - Attach Bearings

1 Use 2 off M10 x 40 Countersunk bolts to centralise position of bearing block

2 Add 2 off M10 x 20 socket cap and fix in two holes indicated and tighten.

3 Replace M10 counter sunk bolts with another 2 off M10 x 20 socket caps

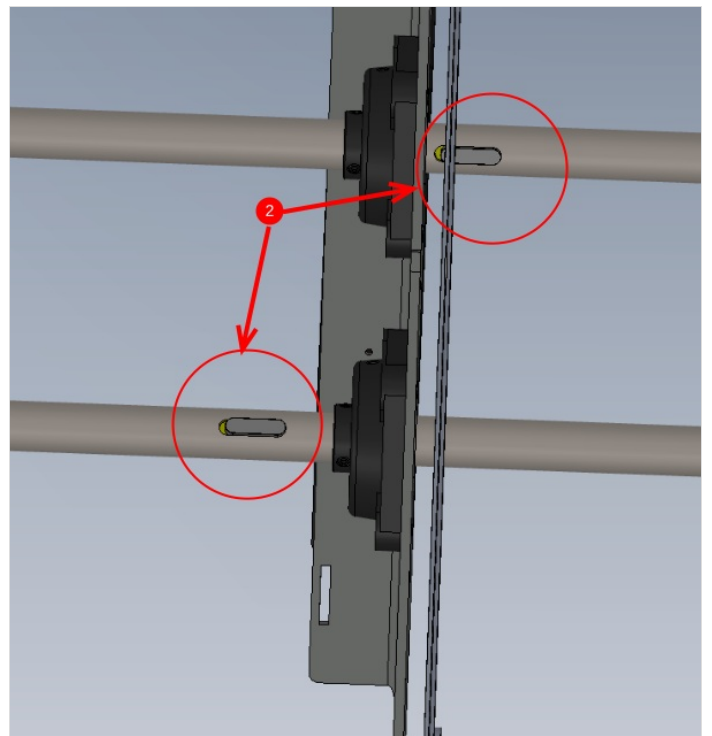
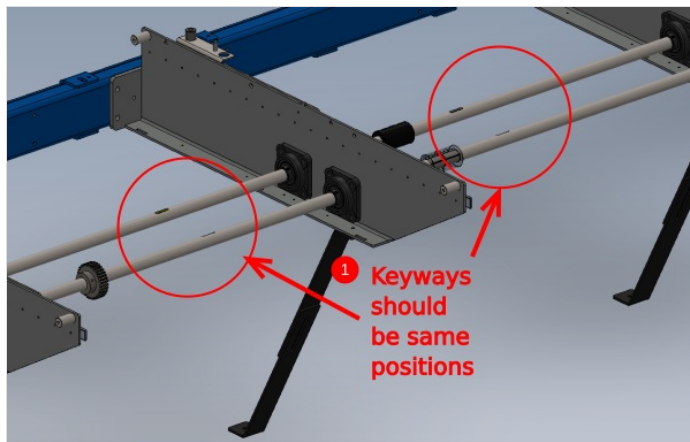
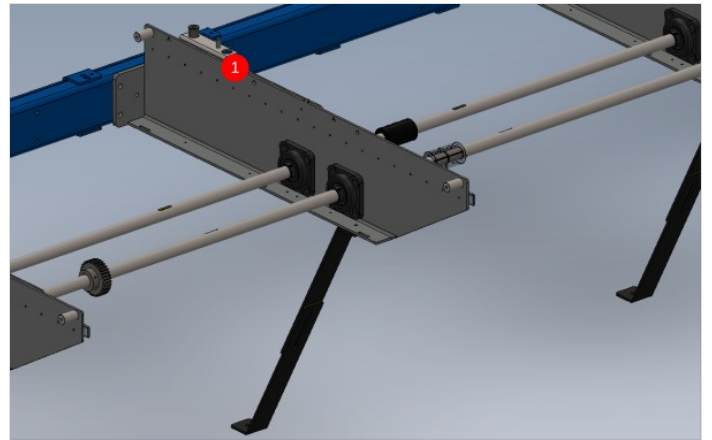
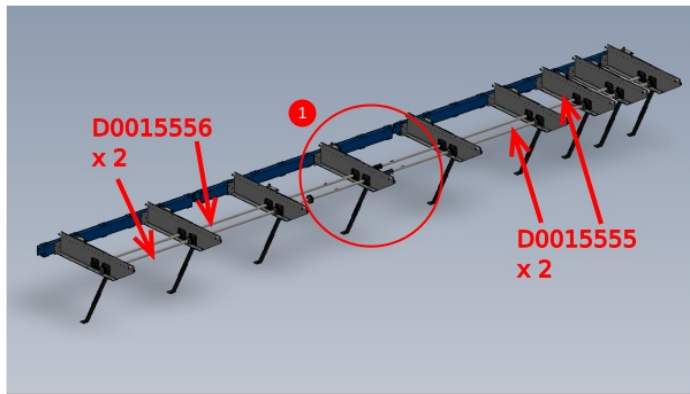
repeat for all bearing mounting positions



## Step 4 - Location of shafts

1 Shafts need to be correctly orientated

2 Each arm should have a key positioned as shown for drive pinions



## Step 5 - Fit shafts and pinions

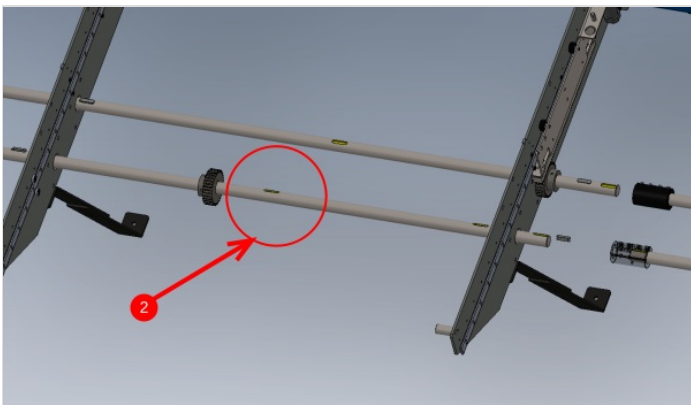
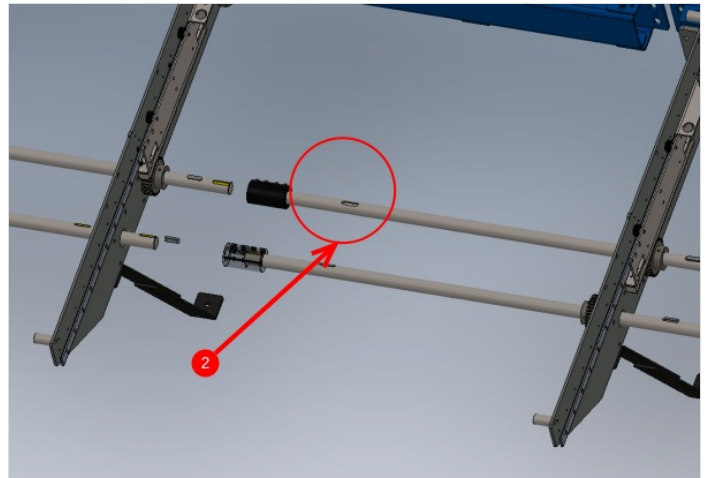
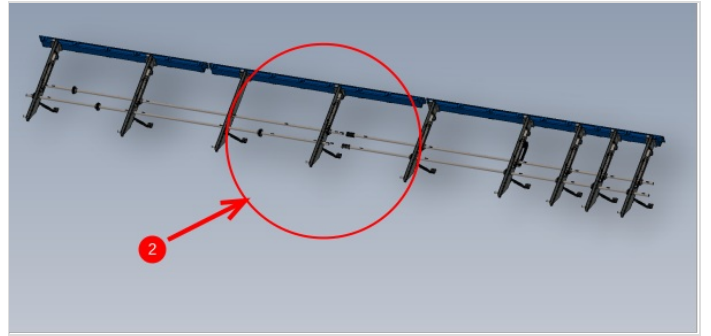
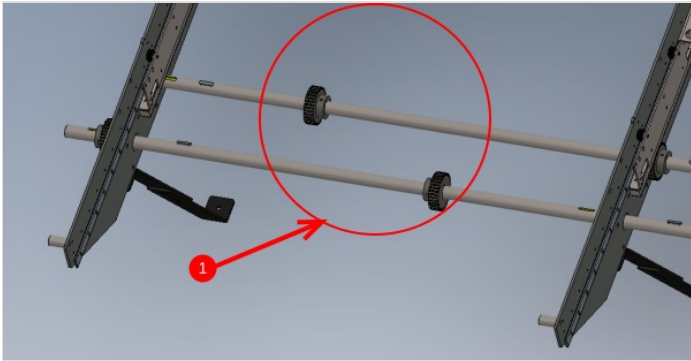
1 Shafts should be slid through bearing blocks to install. Drive pinions should be added to shaft between each arm as the shaft is fitted.

2 B0001165 2 off drive sprockets will also require adding to shafts as they are fitted . See images for location

3 B0001165 should be orientated as shown



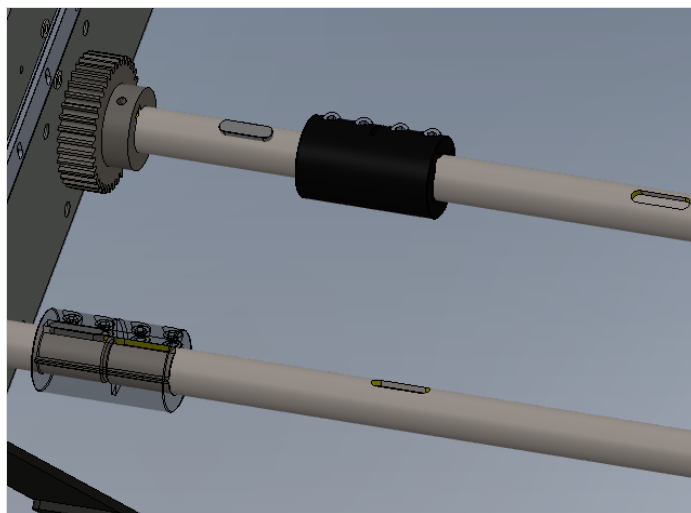
...Do not fix any pinions into position, leave floating on shafts Do not fix any bearing grubscrow lock points





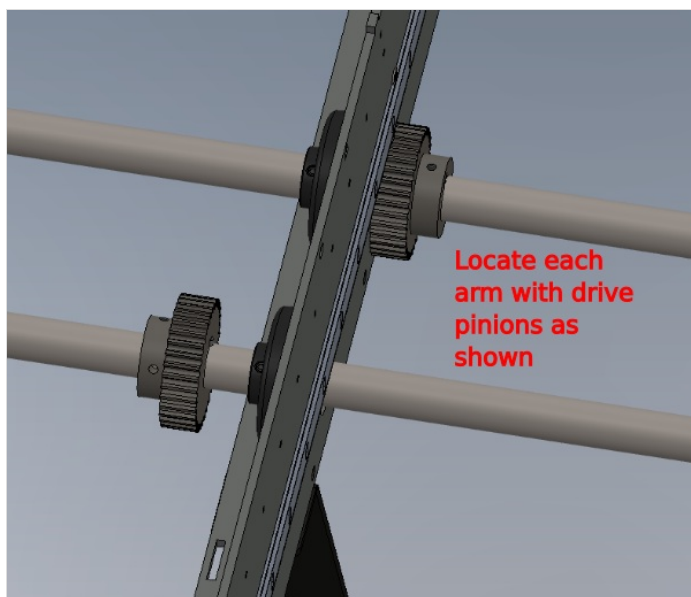
## Step 6 - Couple shafts

Couple shafts together with 1 off B0001153 shaft couplers and 2 off B0001100 key per shaft



## Step 7 - Fit keys

fit 20 off keys to relevant keyways and slide 18 drive pinions and 2 off drive sprockets into approximate positions



## Step 8 - Lubrication

all bearings should be lubricated with grease gun and trojan grease

