

R0015095 Bench Assemble Infeed Support Arms

Instructions to bench assemble infeed support arms

 Difficulty **Medium**

 Duration **5 hour(s)**

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Step 1 - Unless otherwise stated

Step 2 - Hand of parts issued determines handing.

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Comments

Introduction

Tools Required

Standard hex key set

Standard tap set

Setting jigs

Parts required

B0001170 Spacer 180 off

B0001155 open rail 18 off

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

D0015554 x 18

M8 x 20 button hex fastener x 18

M5 x 25 socket cap x 180

M5 A form washer x 180

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

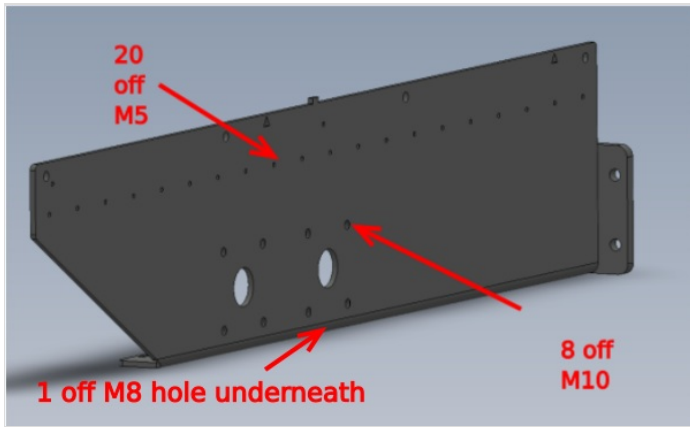


Step 2 - Hand of parts issued determines handing.

Steps shown below will show location and position of parts and procedure for fitting , not orientation



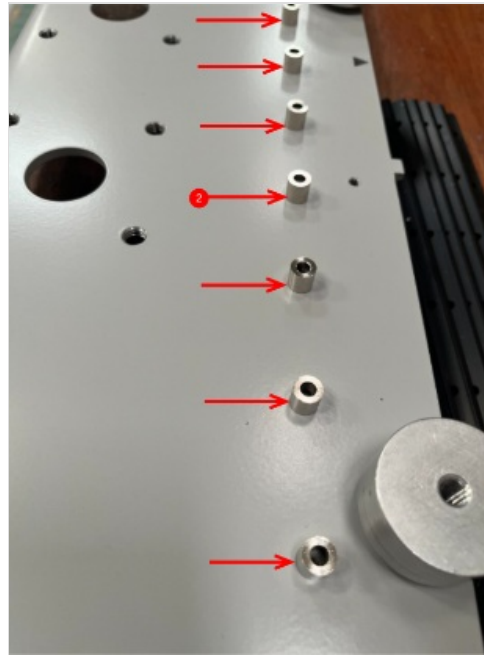
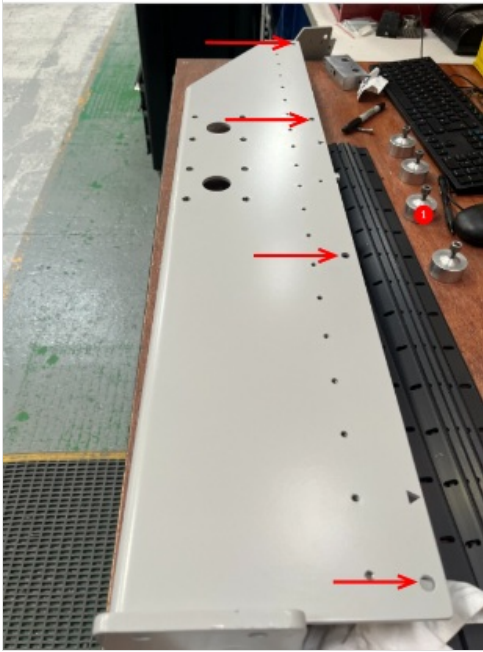
Step 3 - Clean all threads



Step 4 - Align spacers and fit setting jigs

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

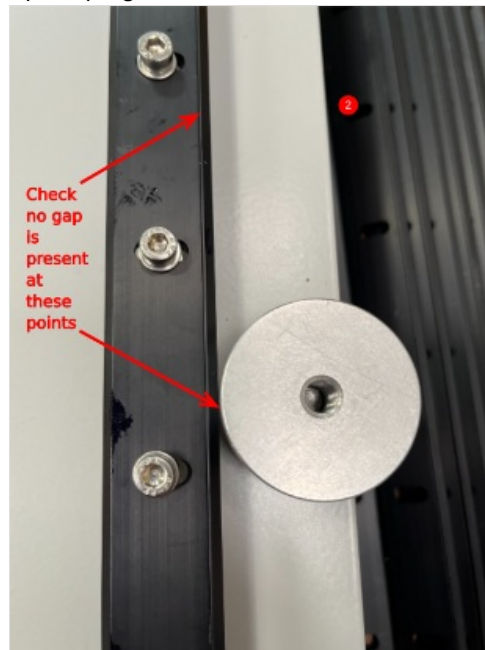
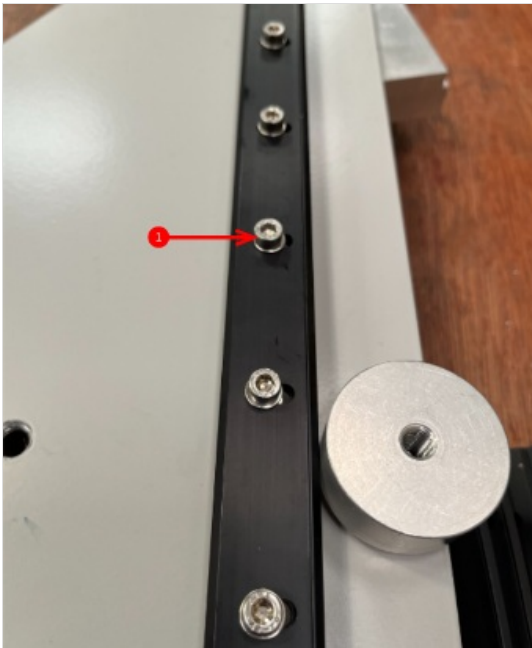
2 align 20 off spacers over all m5 holes

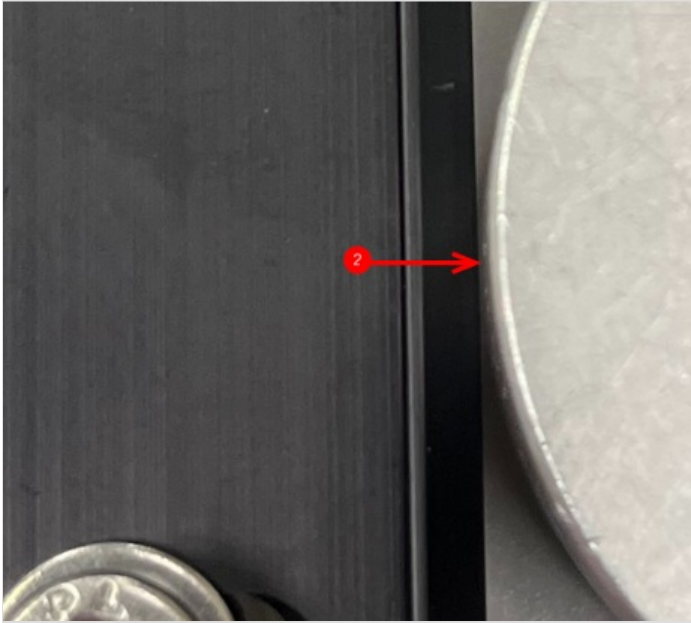


Step 5 - Fix Rail to arm

1 Use M5 x 25 socket cap 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 6 - Fit support arm spacers to arms

2 off per arm

Fix using M8 x 20 hex head Set bolt and finalise with loctite 243

Please provide pictures

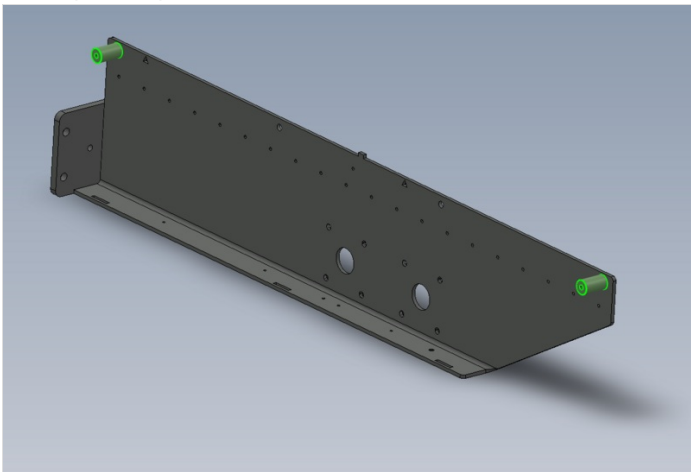


Photo
Required