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R0015095 Bench Assemble Infeed Support Arms

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Instructions to bench assemble infeed support arms

Author [Gareth Green](#) | [Last edit](#) 5/09/2024 by [Gareth Green](#) being drafted

□
 Difficulty
 Medium
 Duration
 5 hour(s)

Instructions to bench assemble infeed support arms

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Introduction

Tools Required

Standard hex key set

Standard tap sete

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

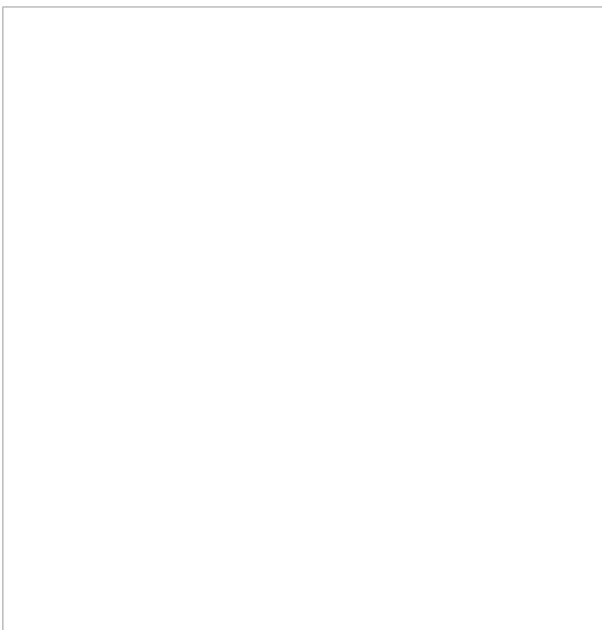
M5 A form washer x 180

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

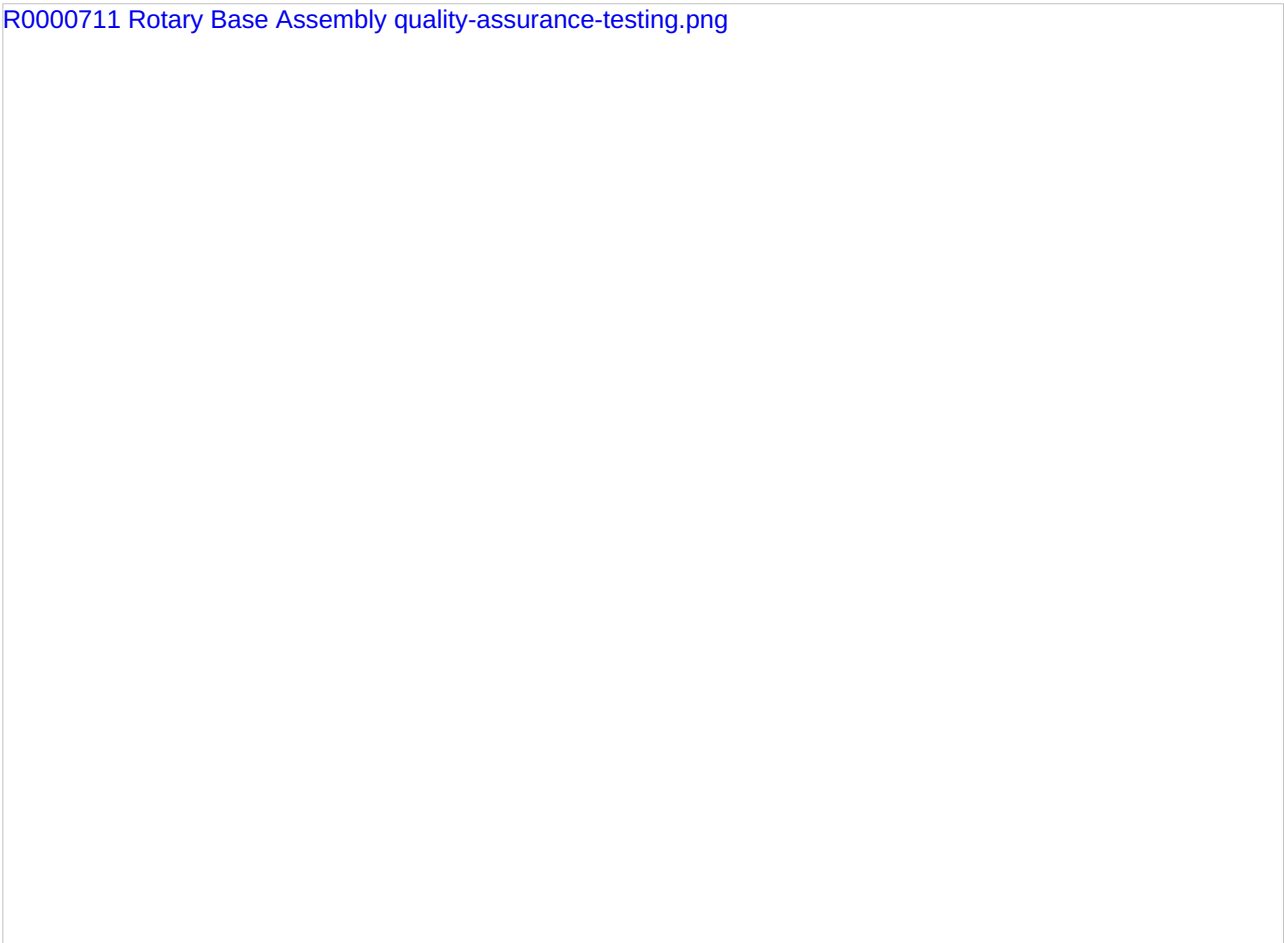




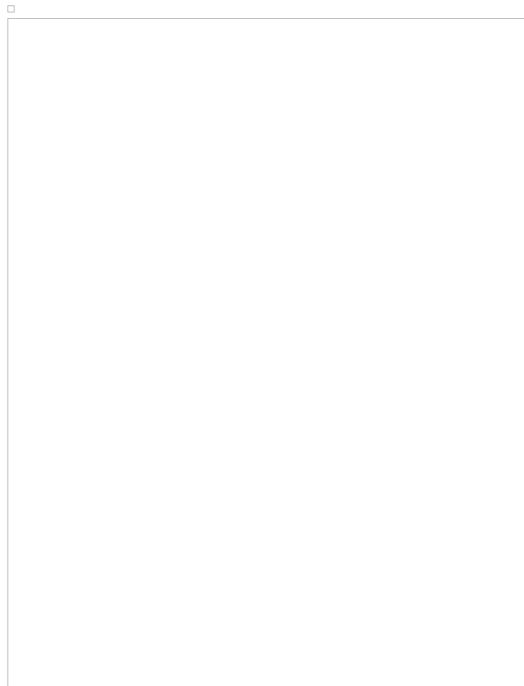
Step 2 - Hand of parts issued determines handing.

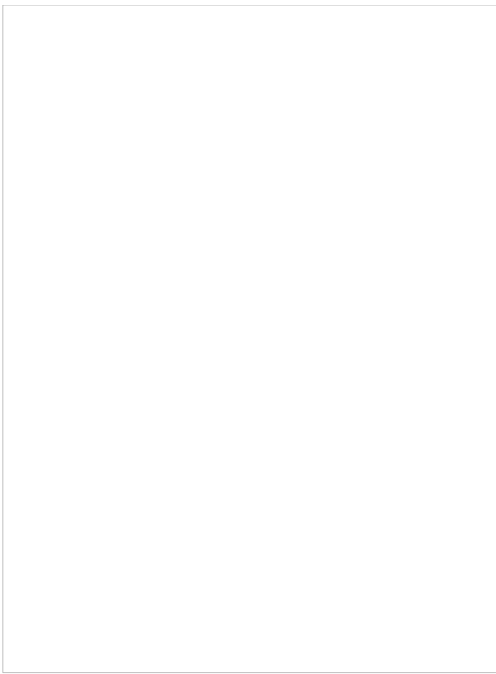
Steps shown below will show location and position of parts and procedure for fitting , not orientation

[R0000711 Rotary Base Assembly quality-assurance-testing.png](#)

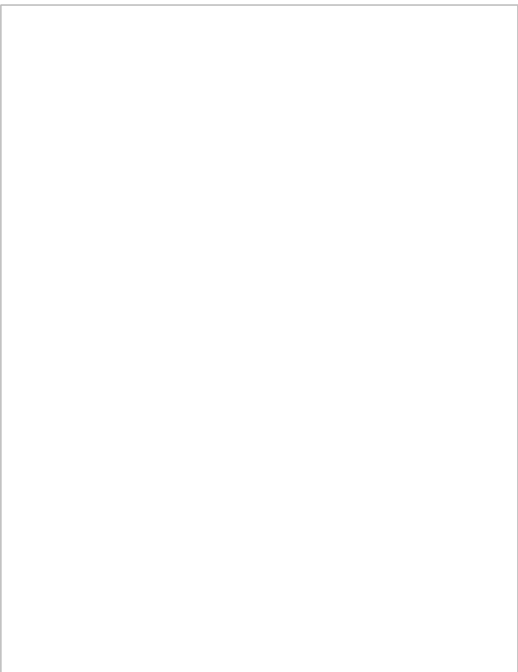


Step 3 - Clean all threads

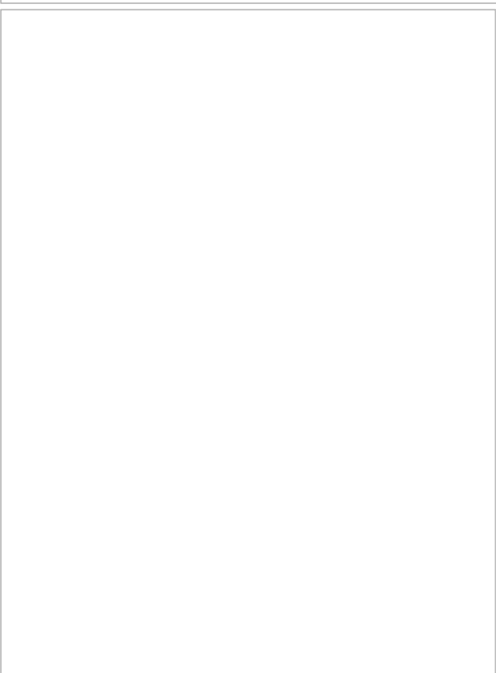




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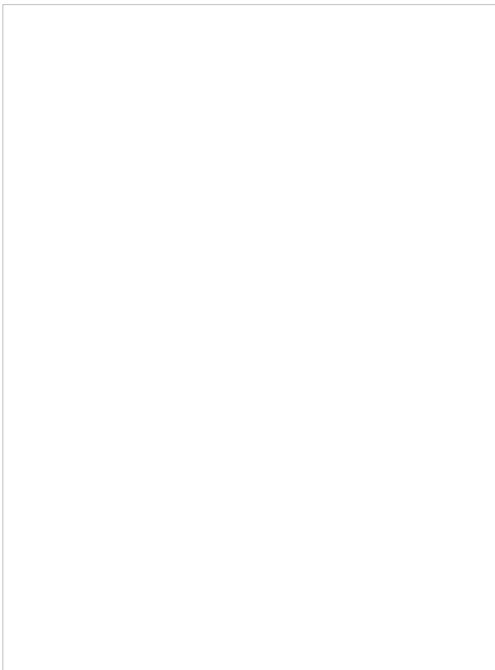
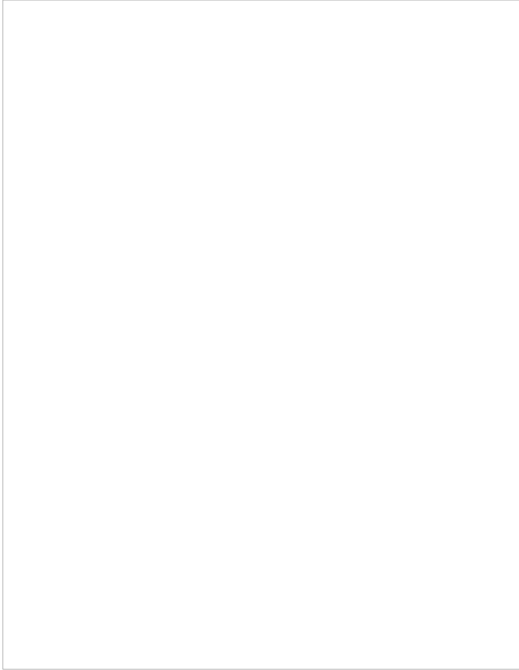


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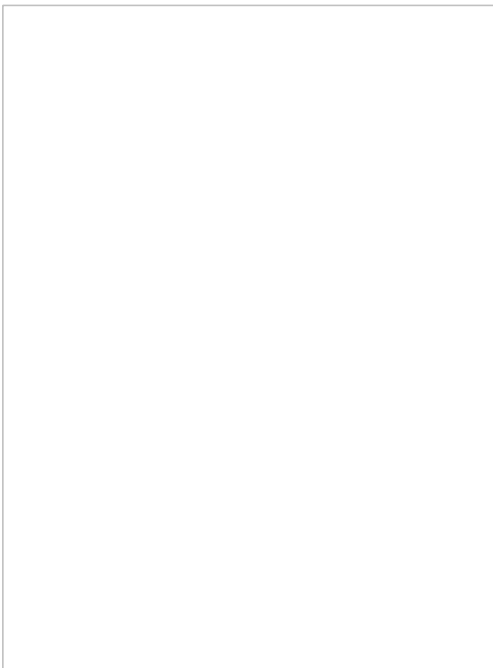
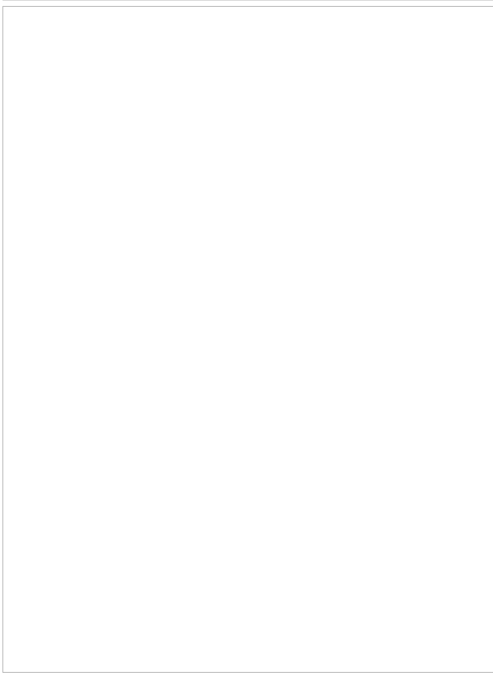
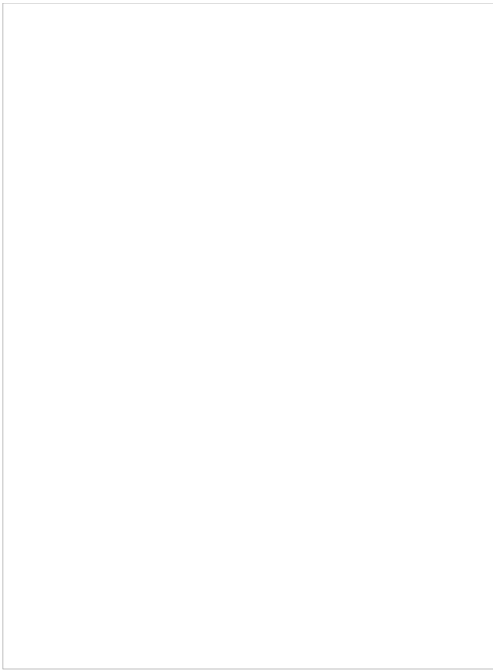
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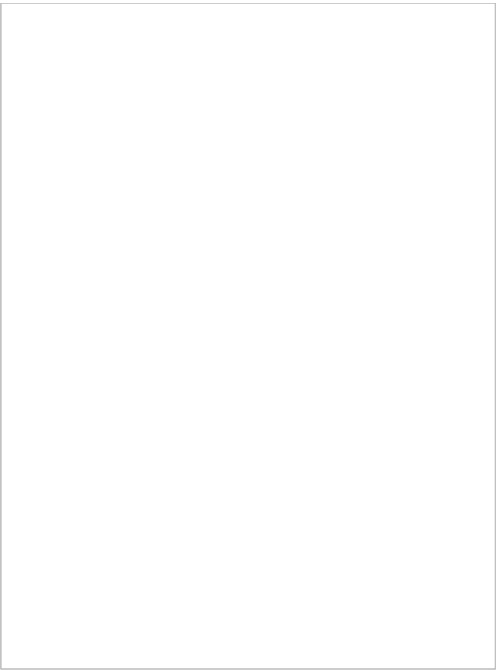
Step 4 - Align spacers and fit setting jigs

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

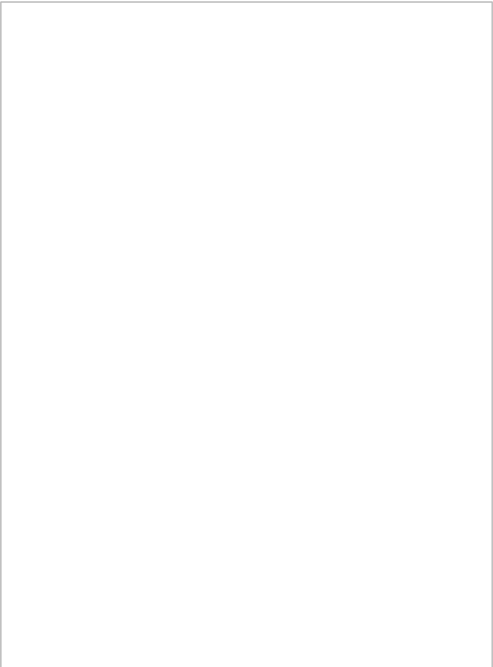
2 align 20 off spacers over all m5 holes



1.



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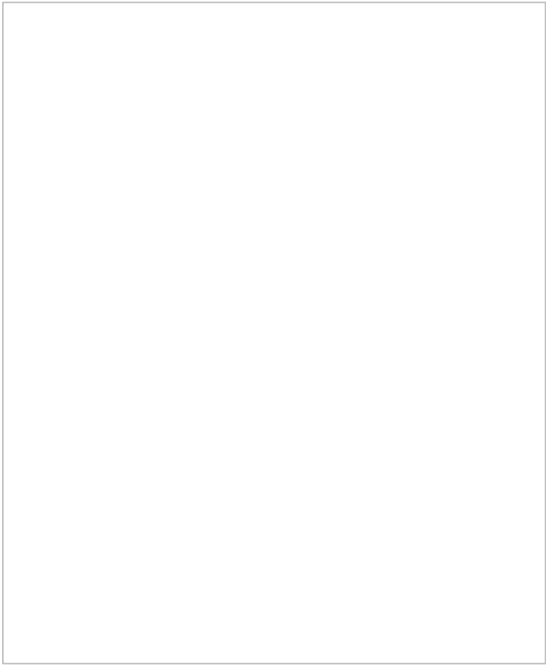
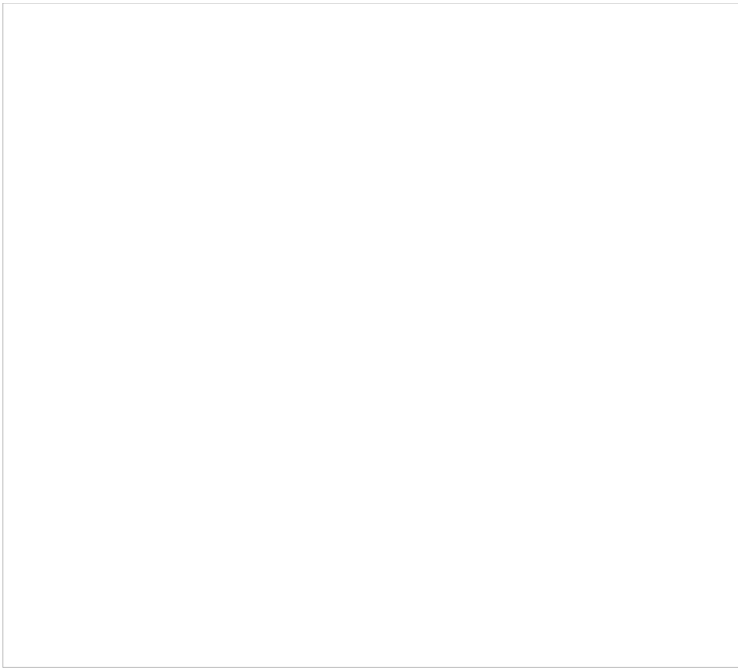


Step 5 - Fix Rail to arm

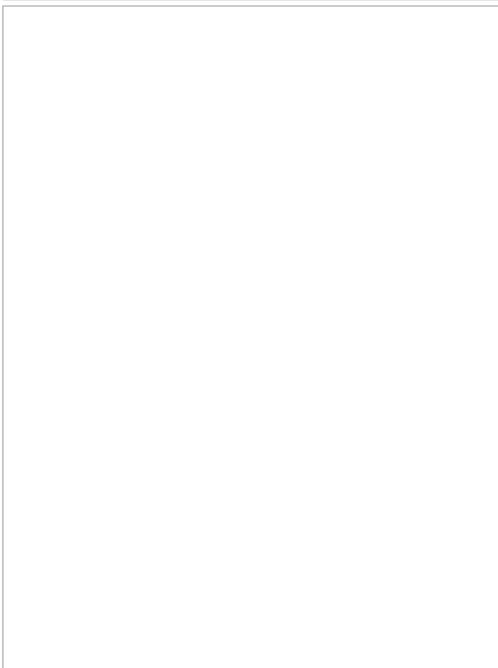
1 Use M5 x 25 socket cap and A form washer with loctite 243 to fix rail to arm

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

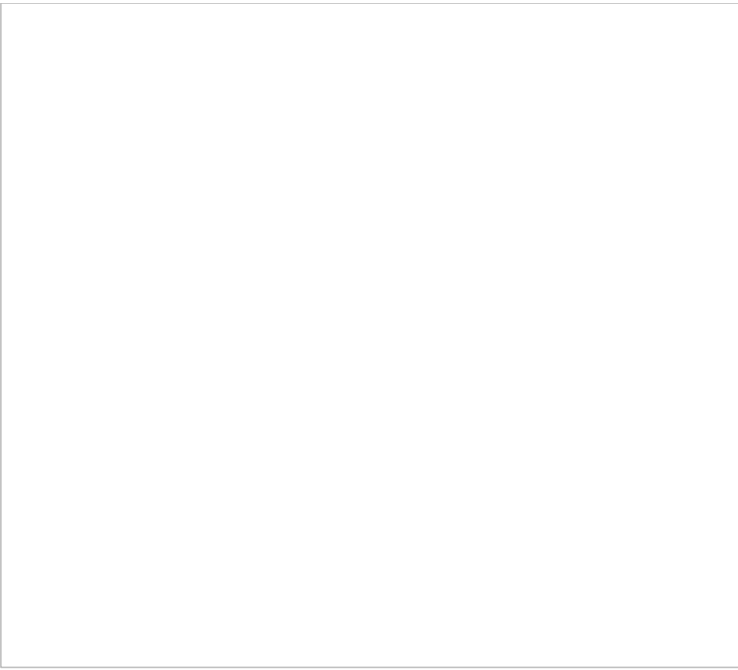




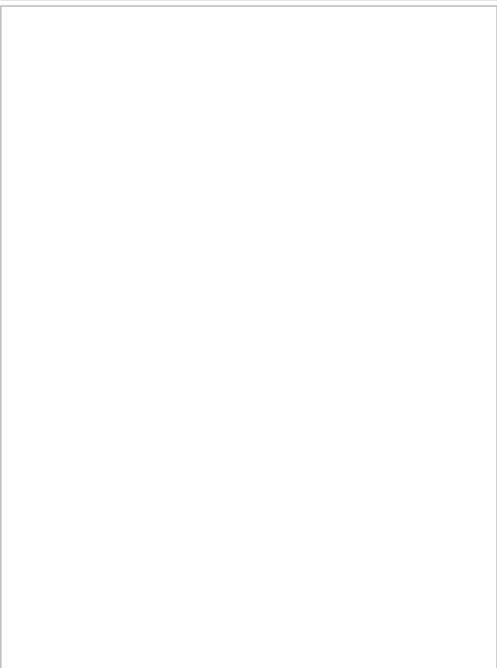
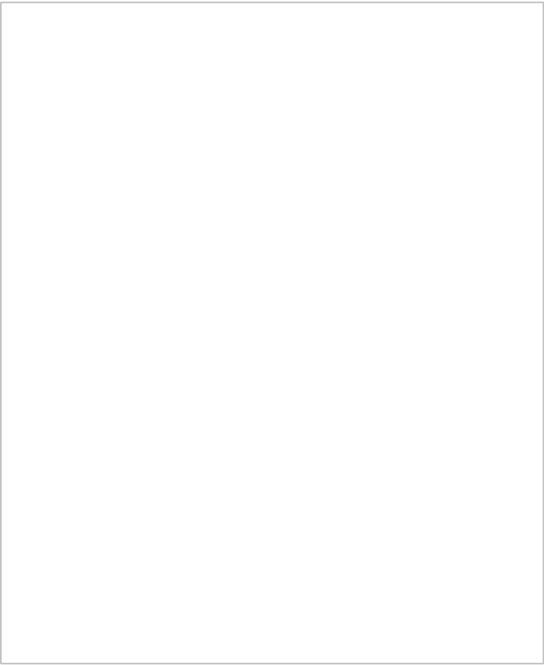
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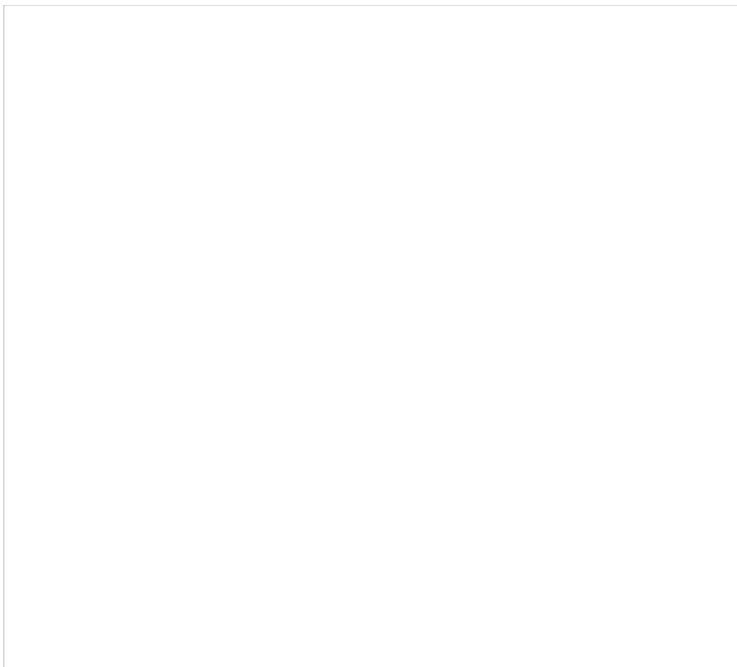


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