R0015099 Guard panel drilling

Details to drill to suit guard panels

Difficulty **Medium** Duration **6 hour(s)**

Contents

Introduction

Tools Required

Standard hex key set
Standard Hss drill set
Standard Tap set
Material clamps
Clamping blocks
Drill
Cutting fluid
Marker pen
Hide hammer

Parts Required

D0000330 Rear Chute Panel (500mm) x 1
D0004391E LF Side Sheet Mk5 (5395E) x 1
D0004576E Saw Centre Frame Mk5 (5343E) Standard Hand x 1
D0010967 Saw Mk5 Undertray x 2
D0015238 Saw Top Hood ZX5 x 1
H0004649 Chute Insert Outfeed (5321) x 1
H0004697 Chute Insert Infeed (5322) x 1
H0004751 Ejector Tray Front (5323) x 1

H0004752 Ejector Tray Rear (5324) x 1
H0004846 Right Side Hinged Panel x 1
D0001878 Rear saw door x 1

Step 1 - Drill hinge panel

Drill hinge panel as detailed

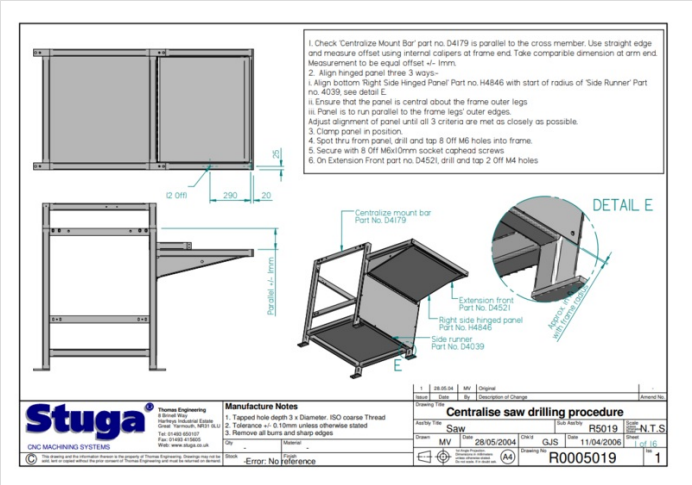
1 Clamp panel in position equalising edges to frame

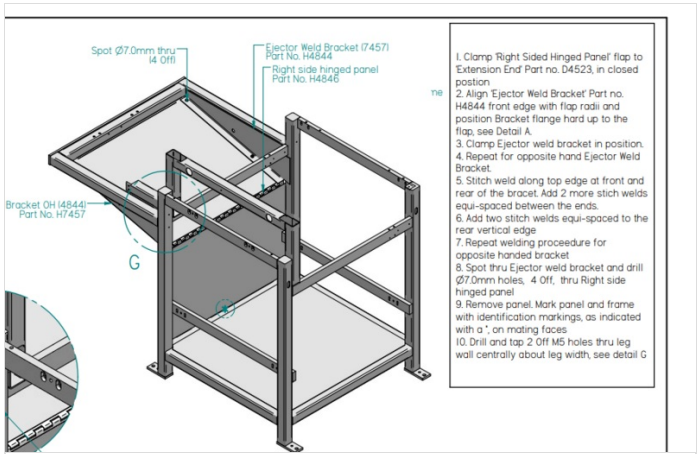
2 Drill vertical face holes onto frame M6 tapped

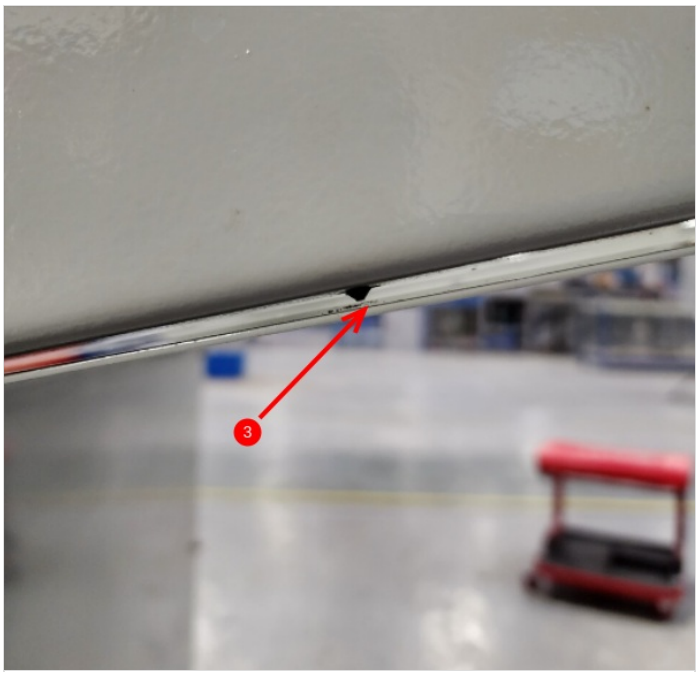
3 Mark 4 off holes with M6 pointed grubscrew

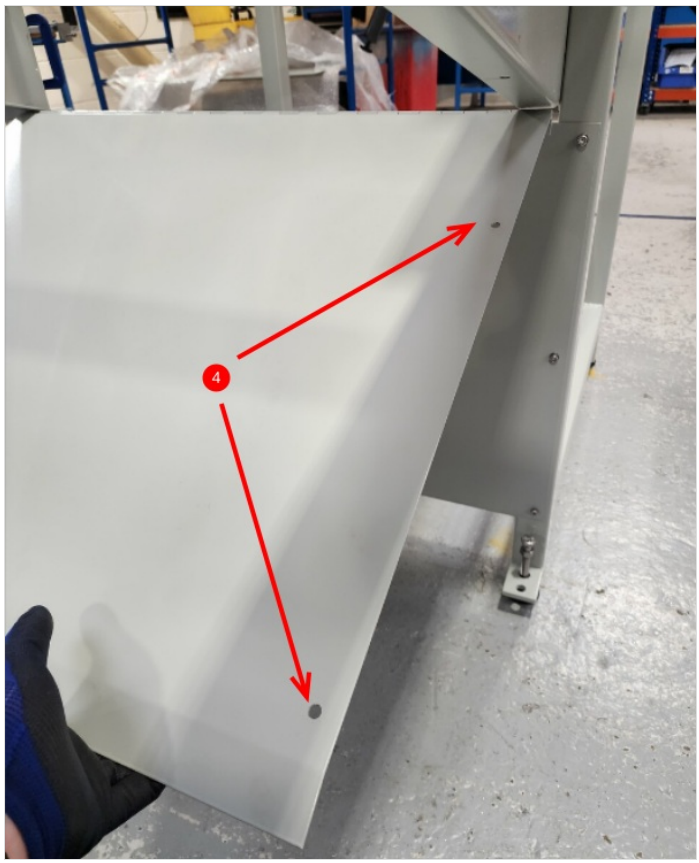
4 Drill 4 off to 7.5 mm

5 Check correct drilling by fixing panel with M6 socket caps







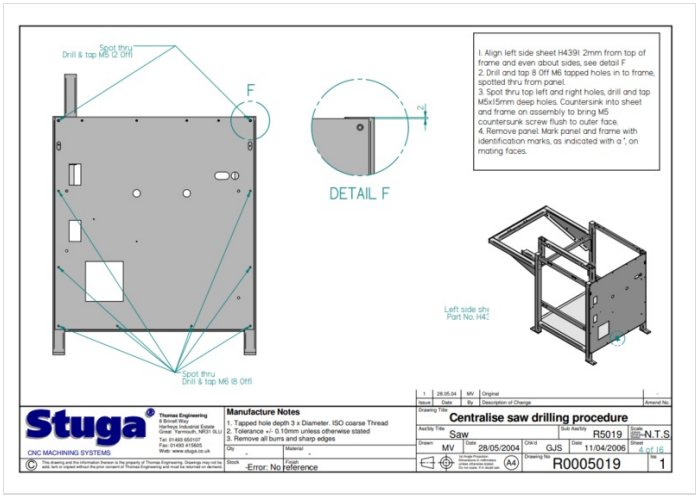


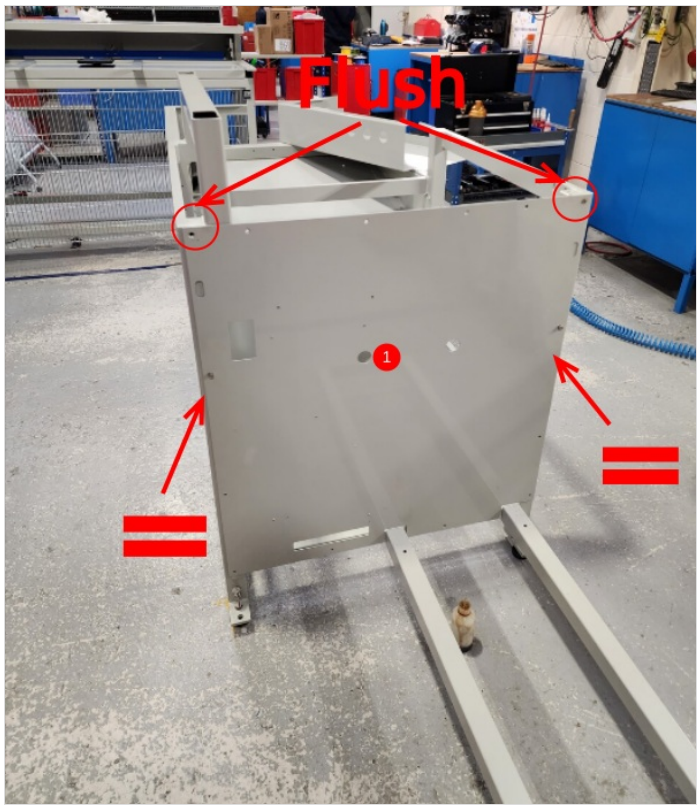
Step 2 - Drill Side sheet

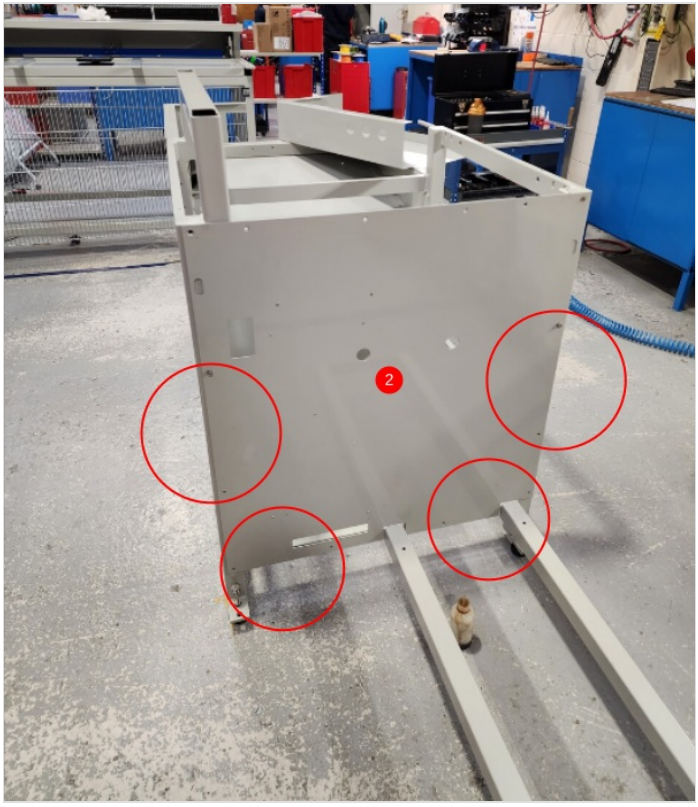
1 Clamp panel in place. Set equal position side ways and flush to top face

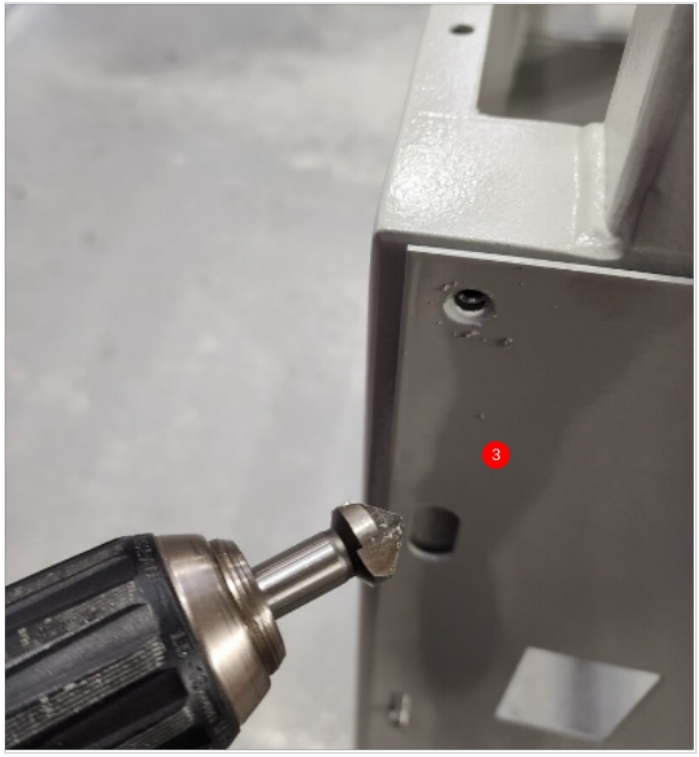
2 Drill 8 off M6 tapped holes as shown

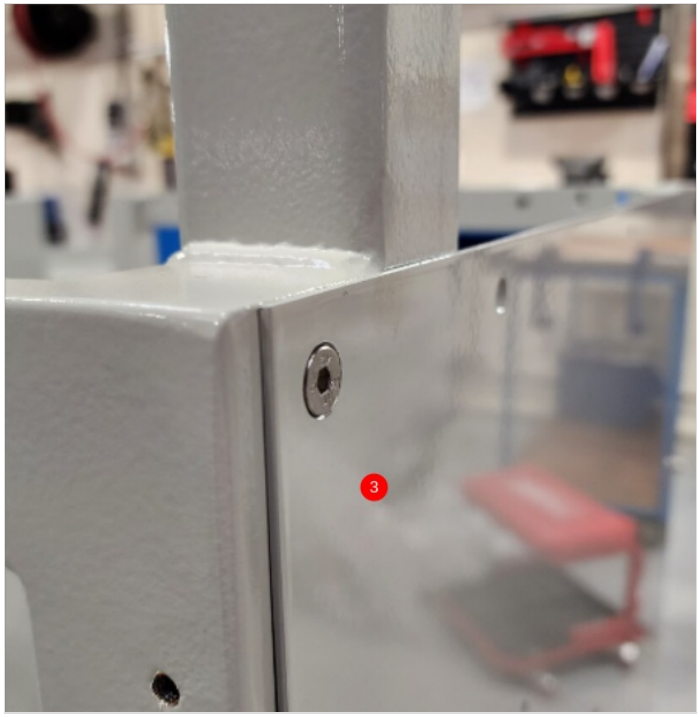
3 Drill and tap M5 , then countersink to allow flush fitment of M5 countersunk bolt







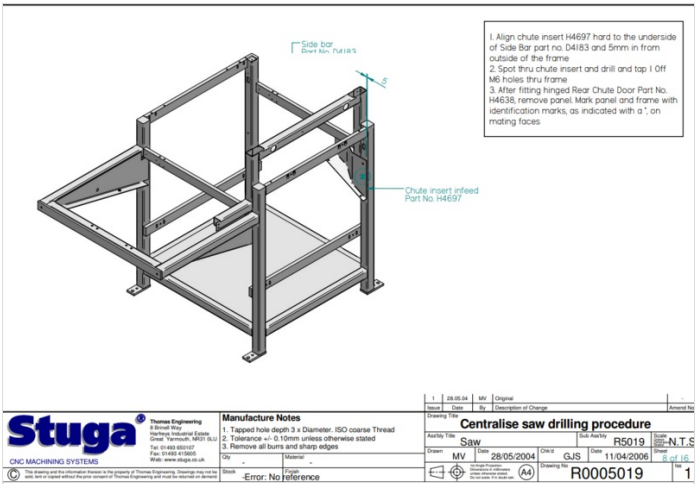


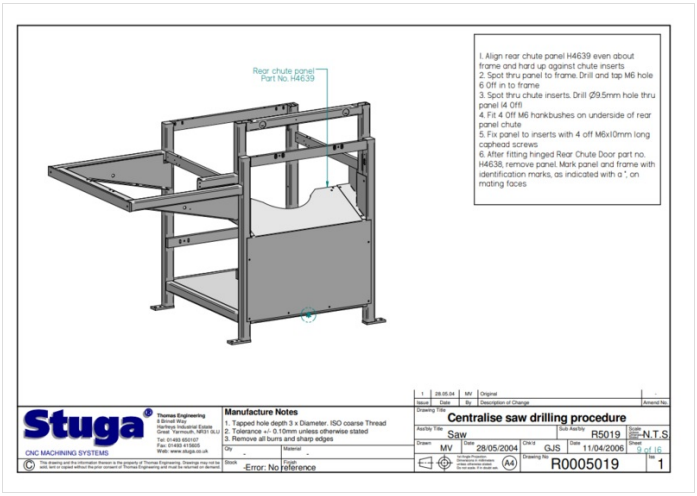


Step 3 - Drill rear chute and inserts

1 Drill infeed and outfeed chute inserts 1 off M6 tapped per insert
Align as shown

Pictures required please
2 Drill and fit main rear chute as detailed


Side bar
Part No. D4183
Chute insert infeed
Part No. H4697
1. Align chute insert H4697 hard to the underside of Side Bar part no. D4183 and 5mm in from outside of the frame
2. Spot thru chute insert and drill and tap 1 Off M6 holes thru frame
3. After fitting hinged Rear Chute Door Part No. H4638, remove panel. Mark panel and frame with identification marks, as indicated with a ", on mating faces
Stuga
CNC MACHINING SYSTEMS
Manufacture Notes
1. Tapped hole depth 3 x Diameter. ISO coarse Thread
2. Tolerance +/- 0.10mm unless otherwise stated
3. Remove all burrs and sharp edges
-Error: No reference
Centralise saw drilling procedure
Saw
R5019
N.T.S
MV
28/05/2004
GJS
11/04/2006
R0005019
1


Rear chute panel
Part No. H4639
1. Align rear chute panel H4639 even about frame and hard up against chute inserts
2. Spot thru panel to frame. Drill and tap M6 hole 6 Off in to frame
3. Spot thru chute inserts. Drill Ø9.5mm hole thru panel (4 Off)
4. Fit 4 Off M6 hankbushes on underside of rear panel chute
5. Fix panel to inserts with 4 off M6x10mm long caphead screws
6. After fitting hinged Rear Chute Door part no. H4638, remove panel. Mark panel and frame with identification marks, as indicated with a ", on mating faces
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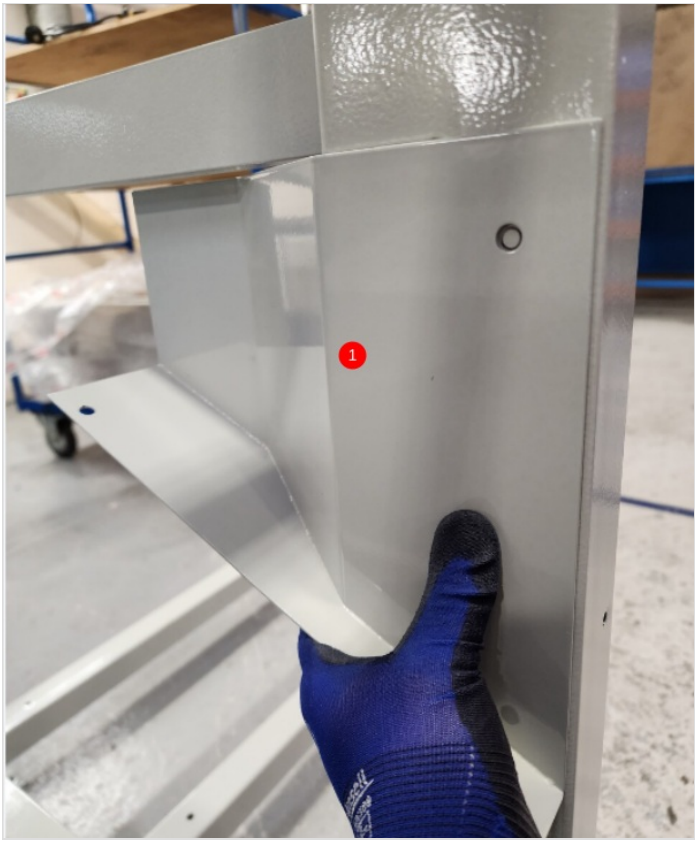
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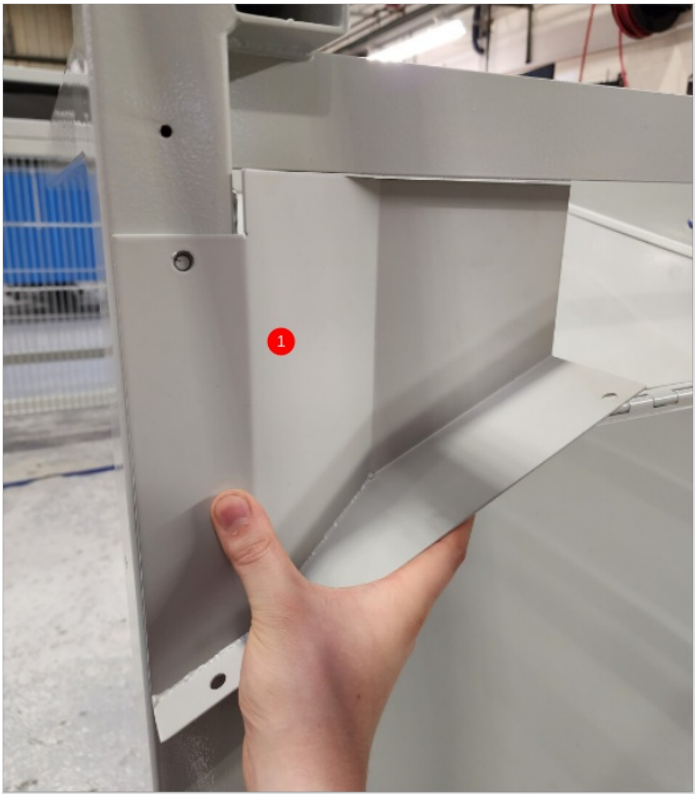
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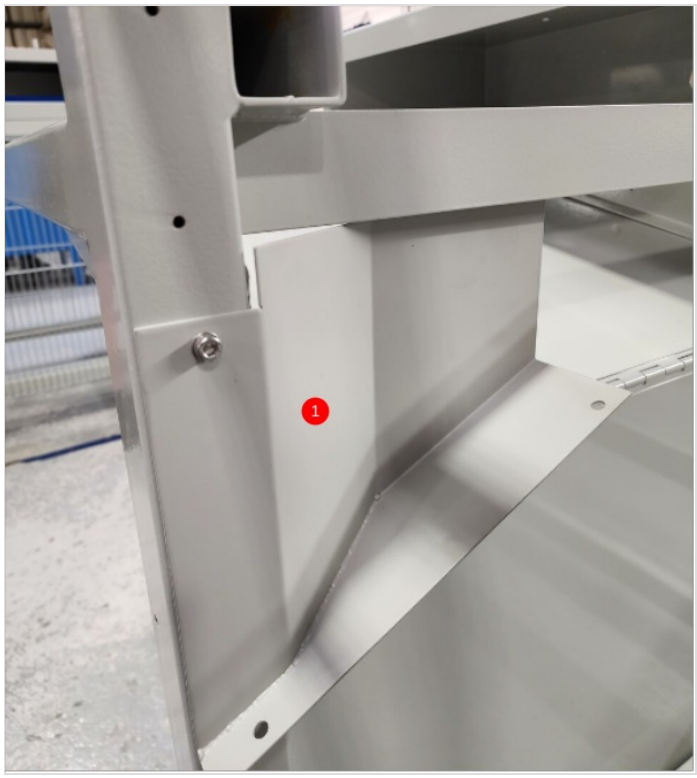


Step 4 - Drill rear door

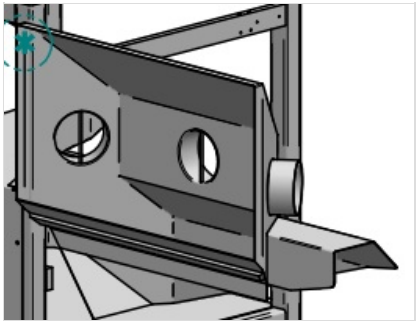
1 Position door above rear chute panel

Pictures of below required please

2 Align height so inner door lip is below chute panel lip

3 check to of door is above frame top crossmember

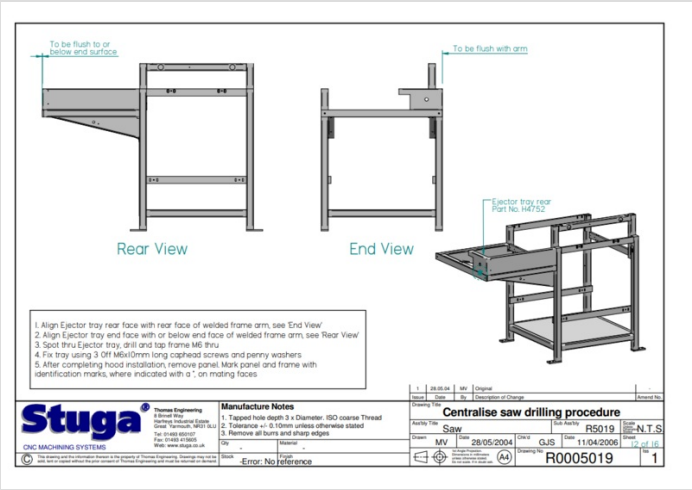
4 Drill 4 off M6 tapped holes for fixing to frame

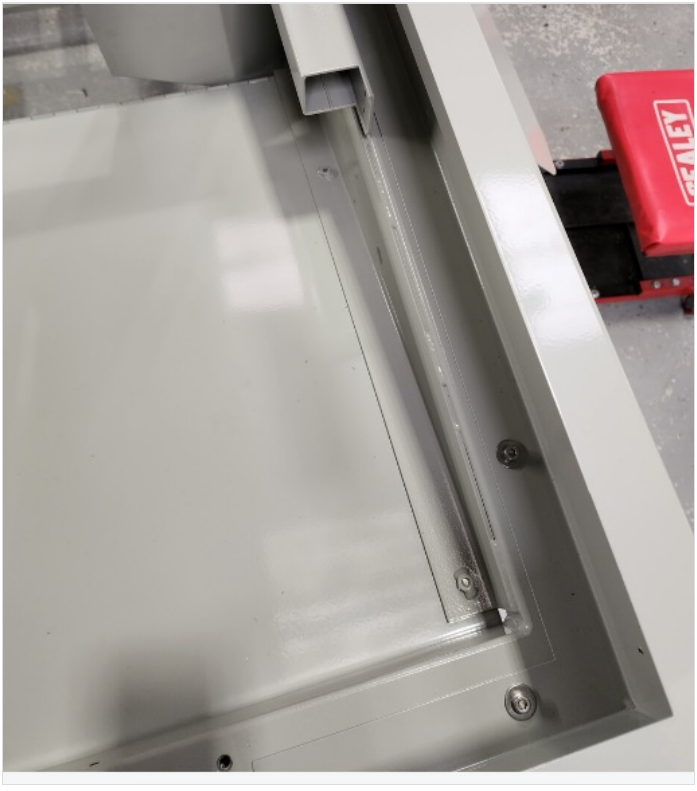


Step 5 - Drill rear tray

Set rear tray flush with all edges shown

Mark and drill Panel M6 tapped,





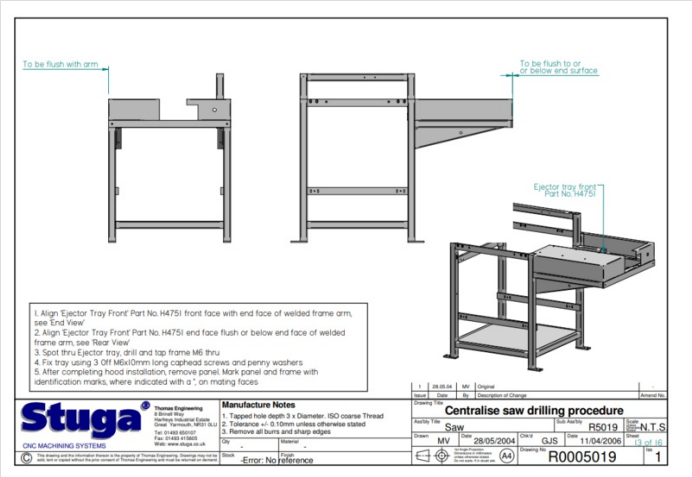
Step 6 - Drill front tray

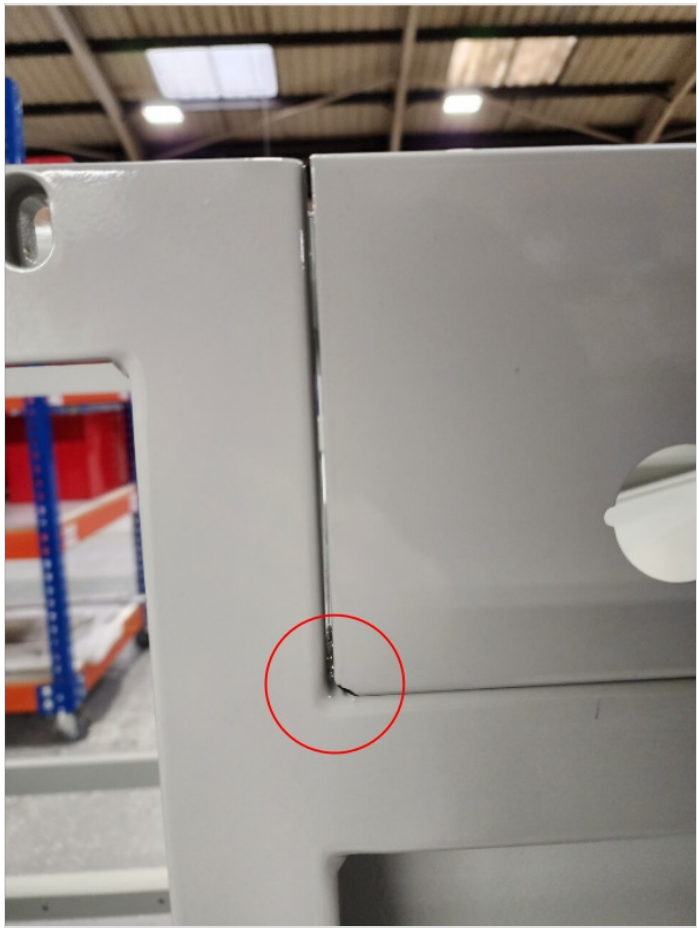
Set front tray flush with all edges shown

Mark and drill Panel M6 tapped,

Ecr raised to amend panel 10/11/23

> ...Front corner shown may catch weld on frame when mounting, this may require rework

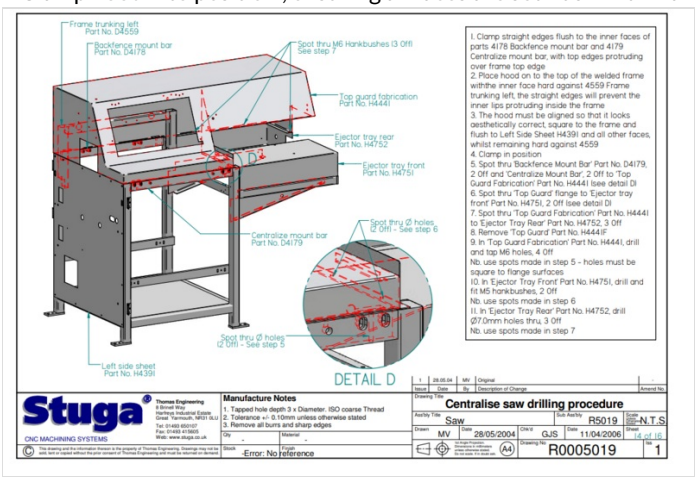


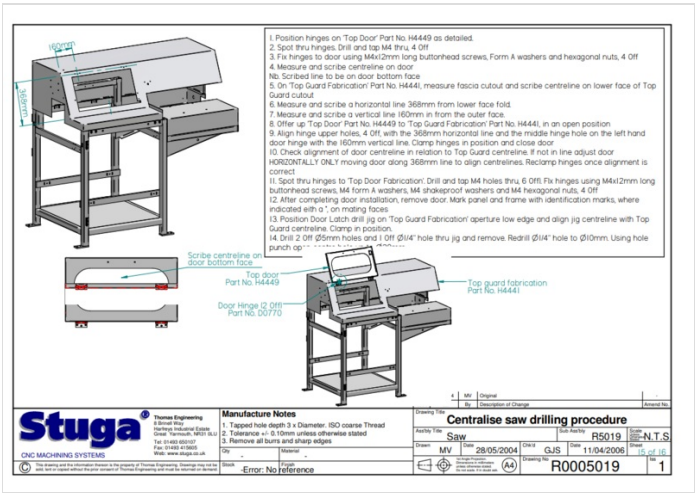


Step 7 - Fit top hood and position

1 Lift hood onto frame

2 Clamp hood into position , ensuring all faces are set flush with frame






1
2


2


2
Ansell

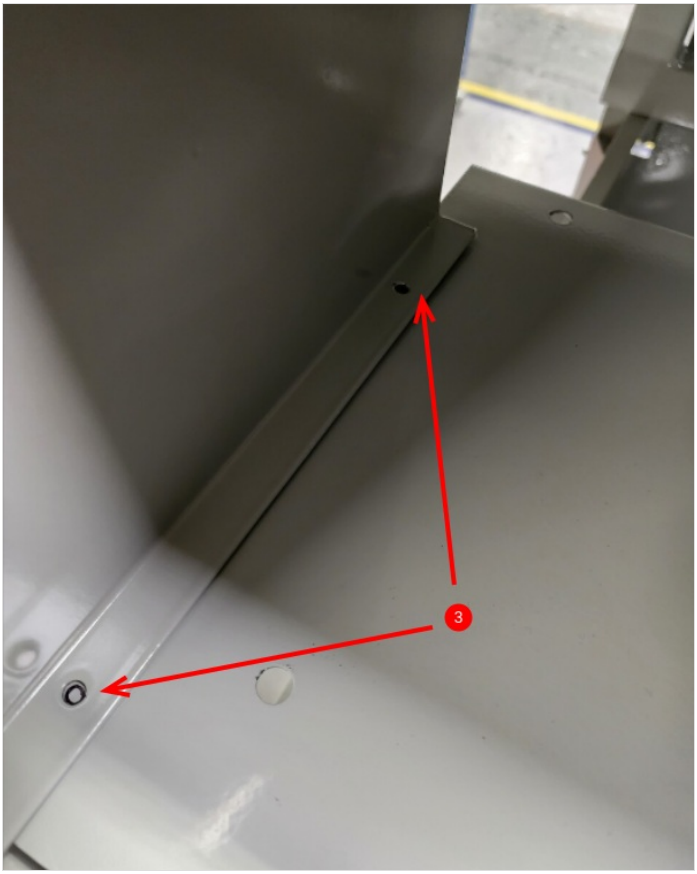
Step 8 - Mark Fixing points

1 Mark 4 off fixing points with 7.5mm drill

2 Mark 3 off rear hood points by using M6 x 10 pointed grubscrews , winding into lower panel and impacting with hammer

3 Set top hood position even to front tray

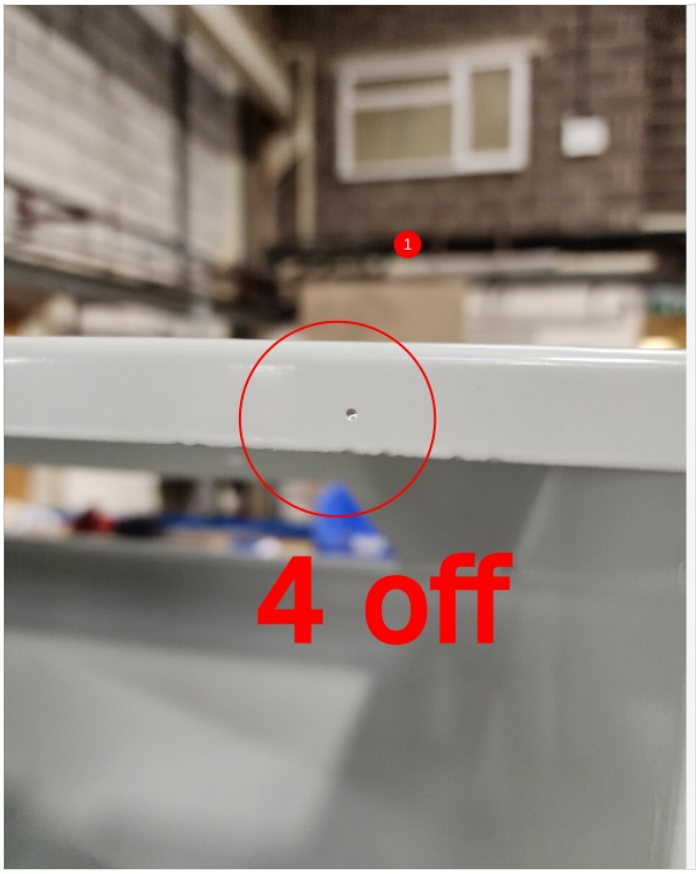
4 Remove hood from frame

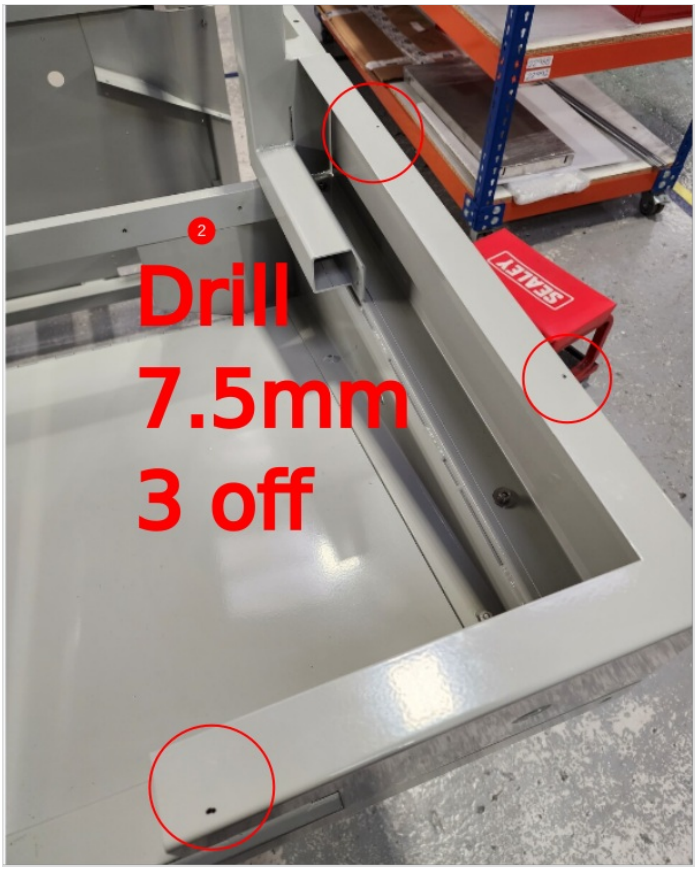


Step 9 - Drill hood and rear tray

1 Drill 4 off marked holes on hood to M6 tapped , add small countersink to face indicated to aid fitment to frame

2 Drill rear tray to 7.5mm at points indicted by grubscrews

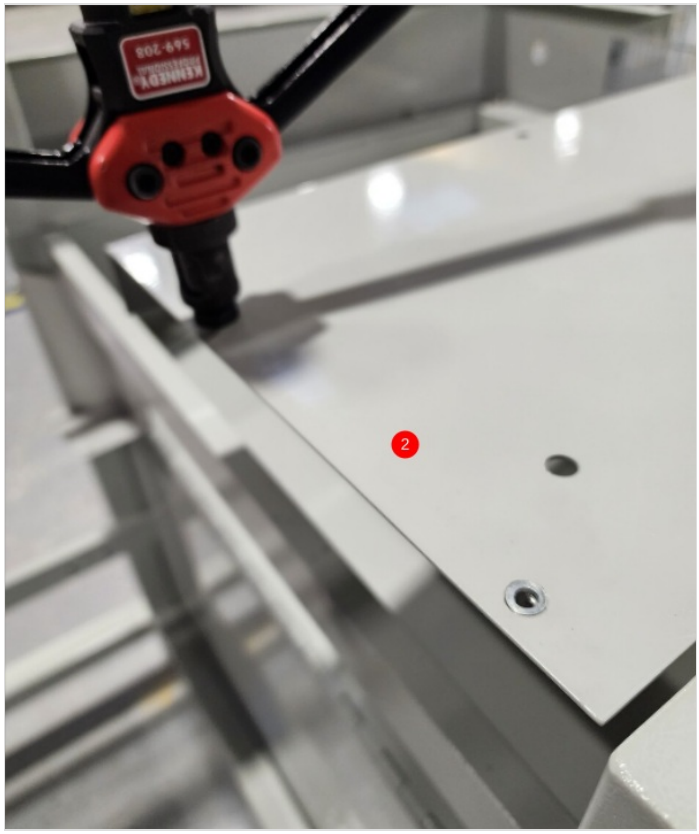

1
4 off


2
Drill
7.5mm
3 off

Step 10 - Drill and add rivnut Front tray

1 Drill marked positions to correct core size (please provide size) for M5 rivnut. Add small countersink to hole to allow flush fitment

2 Use rivnut applicator to insert and fix 2 off M5 rivnuts



Step 11 - Remove all fitted panels

Remove all panels

Clean all swarf from frame and clean paintwork

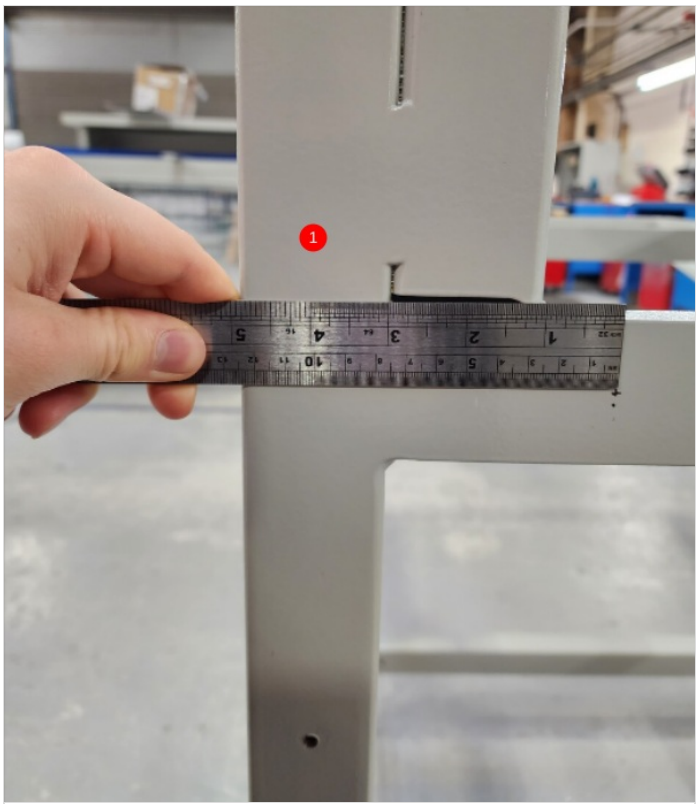

BECKHOFF

Step 12 - Drill additional tie base

Drill and tap additional M5 at point indicated, drill through

1 position 125mm

2 position 25mm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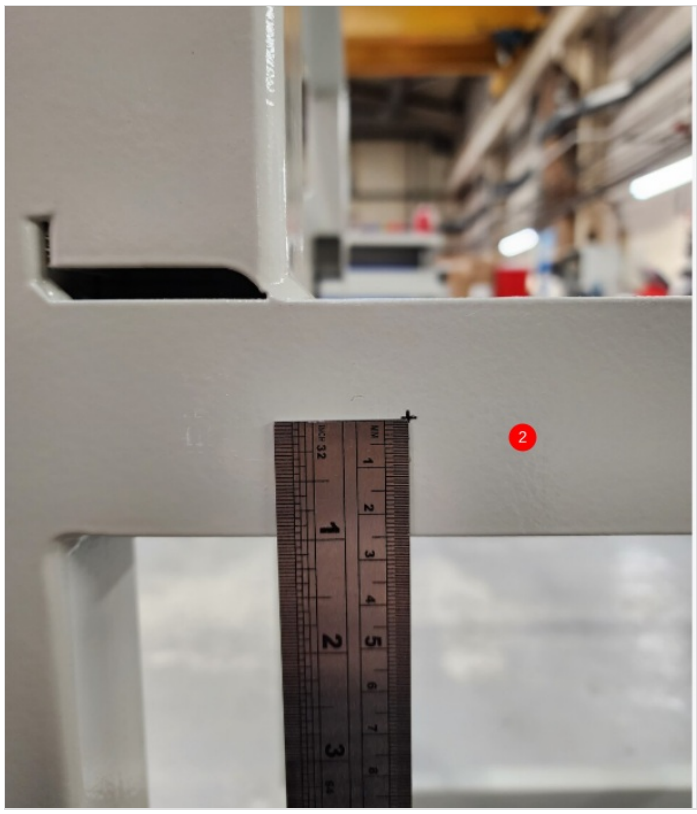
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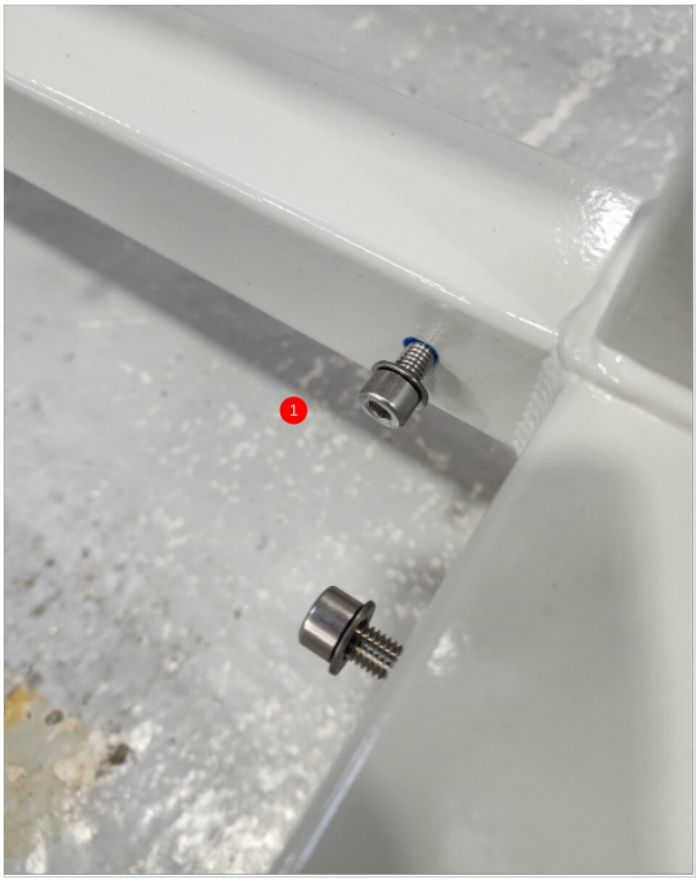
Step 13 - Fit stainless undertrays

1 Fit 16 off M8 x 16 socket caps with M8 A form washers at the points indicated. Add loctite 243 as fitting bolts

Leave enough clearance for trays to slot over

2 Position stainless trays as shown

3 Adjust height of trays to fit flush with top of frame and finalise bolts to secure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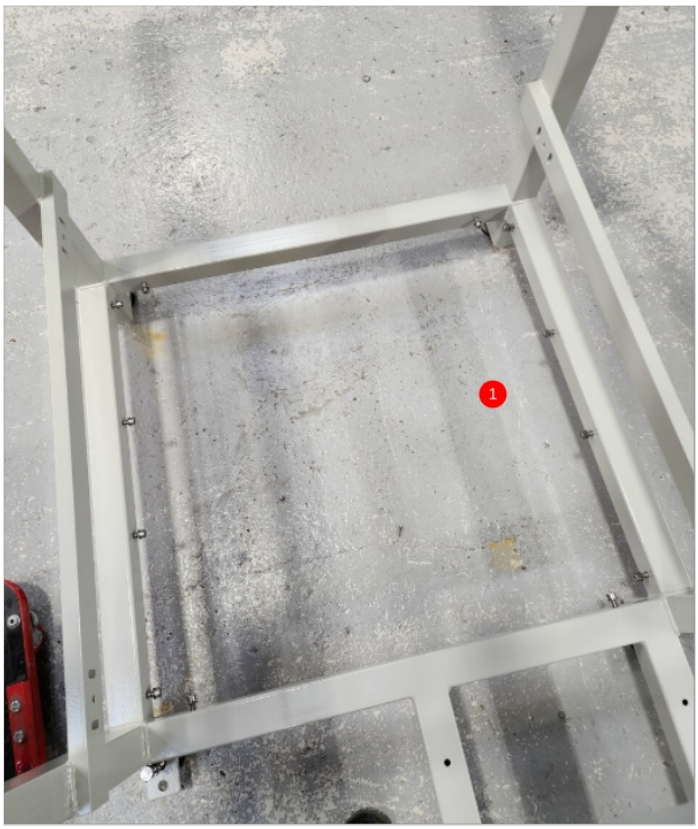
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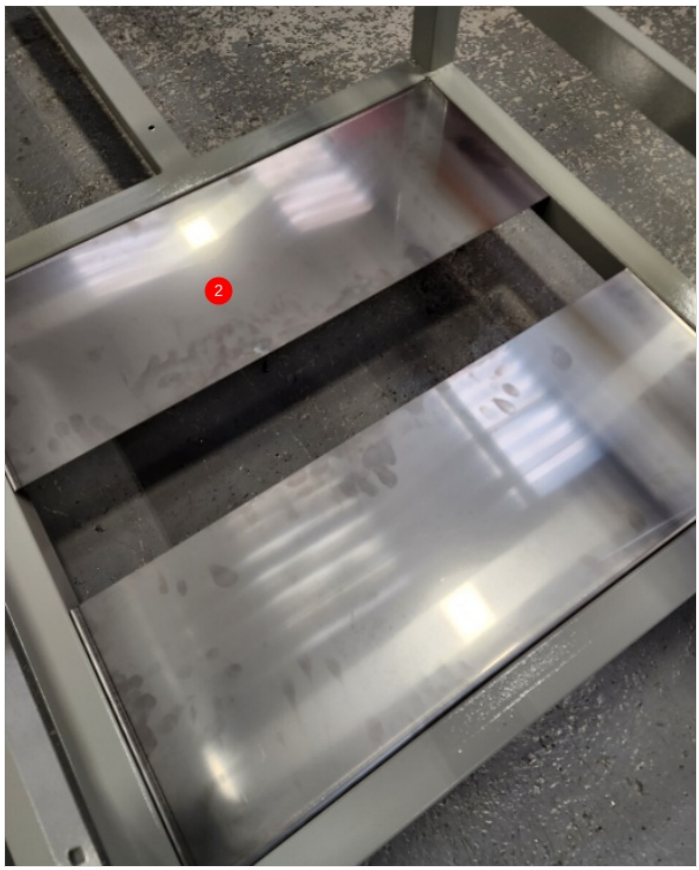
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