

# R0015100 Fit Guarding

Guarding fitment instructions

 Difficulty **Medium**

 Duration **5 hour(s)**

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Comments

## Introduction

### Tools Required

Standard hex key set

Standard spanner set

## Parts Required

D0001878 Rear Door Saw Mk4 (1879) x 1  
D0004584 Outfeed Side Rest x 3  
D0015703 Air Gun Bracket x 1  
D0016203 Compliance Guard - Saw Lower Front x 1  
D0016204 Compliance Guard - Saw Lower Side x 1  
D0016265 Saw Front Door: Bernstein Mount Plate x 1  
D0016266 Saw Front Door: Bernstein Guard x 1  
E0001569 Guard Lock Switch: Bernstein Radius Actuator (Key) x 1  
M0000055 Saw Blade Spanner (24mm Combination) x 1  
M0001051 Bullet Catch 70 x 12 x 1  
P0000010 Elbow Adaptor 6mm - 1/8 BSPT (Taper thread) x 6  
P0001008 Regulator: ARG20 0 - 8.5 Bar c/w Gauge x 3  
P0001009 Panel Mount Nut (To suit P0001008) x 3  
R0015041 Bench Assemble Top Hood Assembly x 1  
R0015337 Bench assemble guarding components x 1  
R0015338 Bench assemble serial plate x 1

## Step 1 - Unless otherwise stated

All bolts to have Loctite 243 adhesive applied unless otherwise stated

All Threaded Pneumatic connections to have Loctite 570 applied

All bolts to be pen marked once adhesive applied and correct tension added




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## Step 2 - Attach interlock key and catch


ECR raised to amend door fixing block holes

1 Drill and tap indicated hole to M5

 ...Do not drill through !!!!

2 Fit interlock blade using 1 off M5 x 20 socket cap and M5 A Forms washer , and align as shown

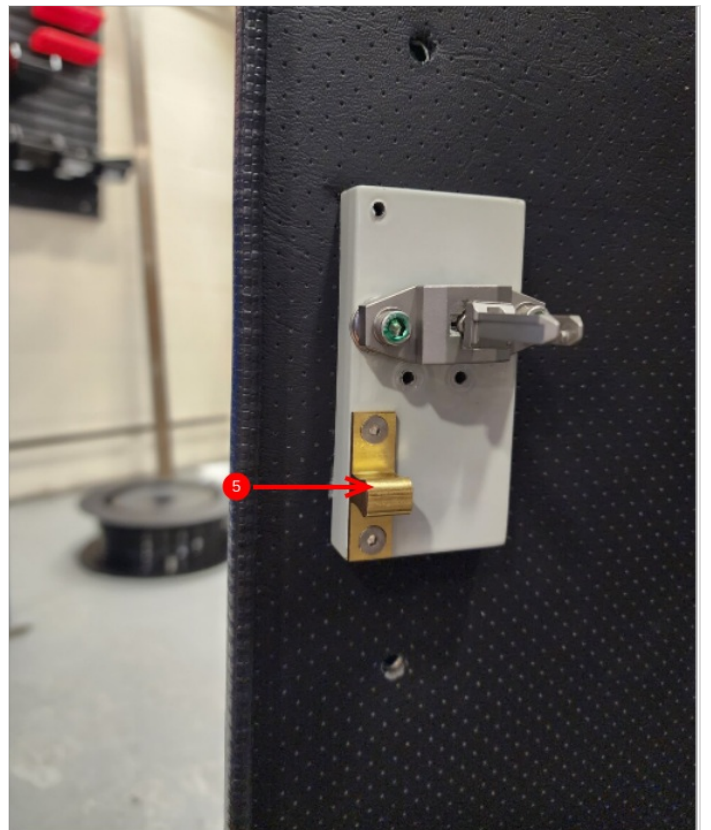
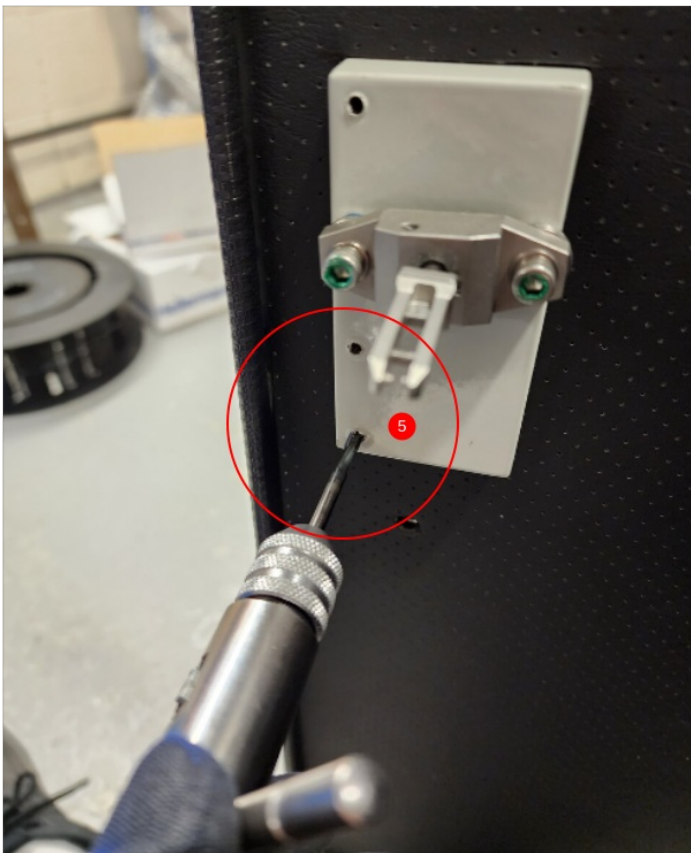
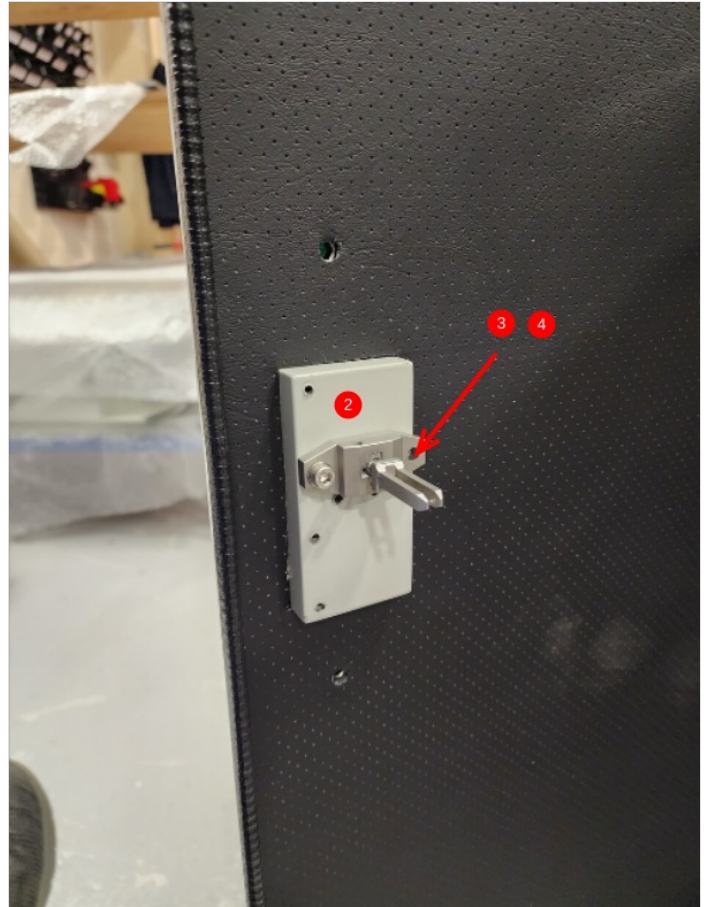
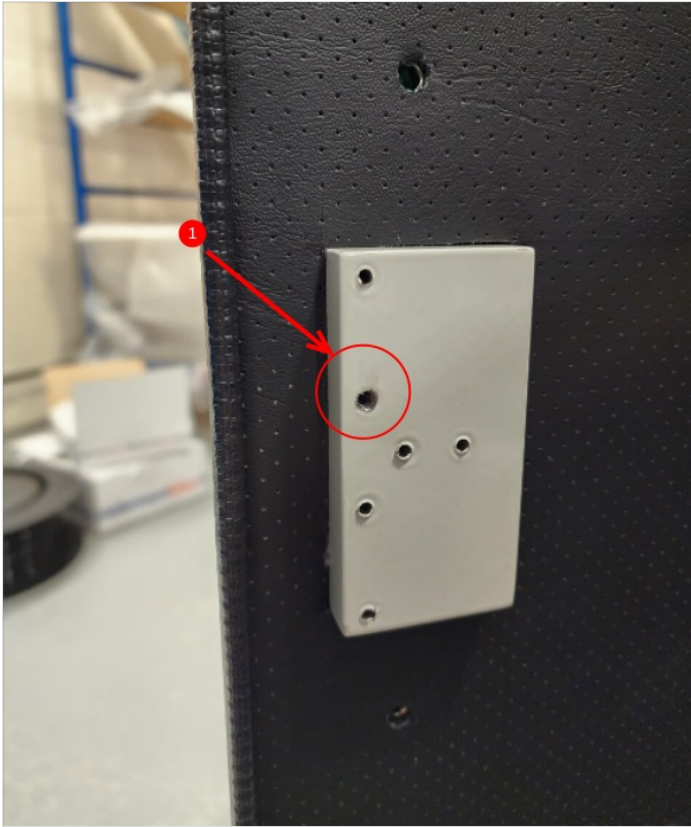
3 Mark position of second fixing hole and drill and tap to M5.

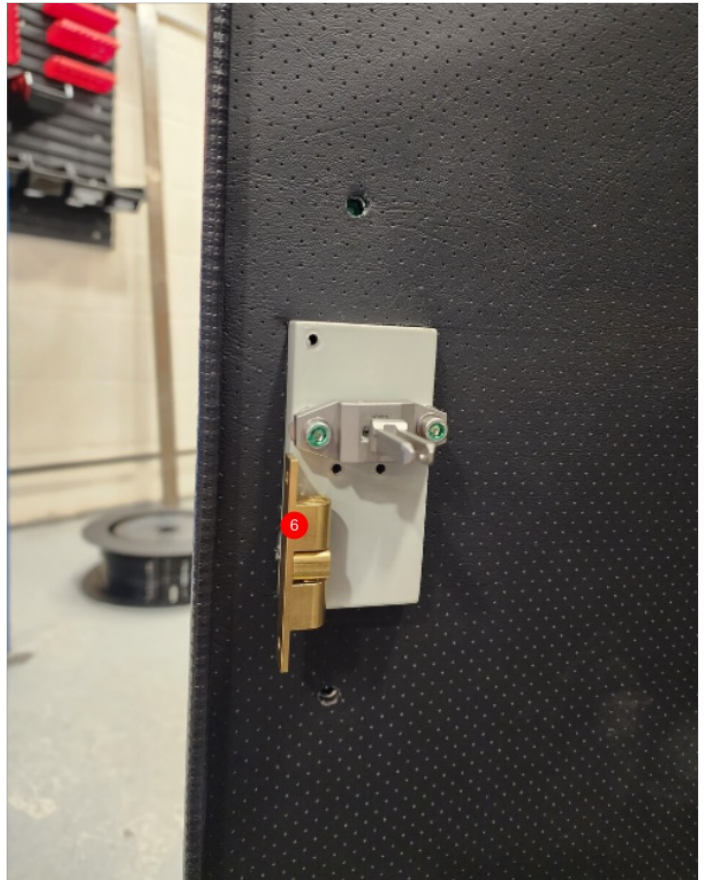
 ...Do not drill through!!!

4 Finalise interlock with second M5 x 20 socket cap and A Form washer

5 Tap holes to remove debris and Fit 1st part of door catch using 2 off M4 x 10 countersunk bolts

6 Fit Second part of catch as shown





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### Step 3 - Quality Check

Please note there has been quality instances of the front door being stiff to close

Please ensure when the following steps are followed, that this is checked during the process .

Front door should close easily and have no additional force required to close final movement to the closed position

Please check with supervisor if unsure if quality of fit is acceptable



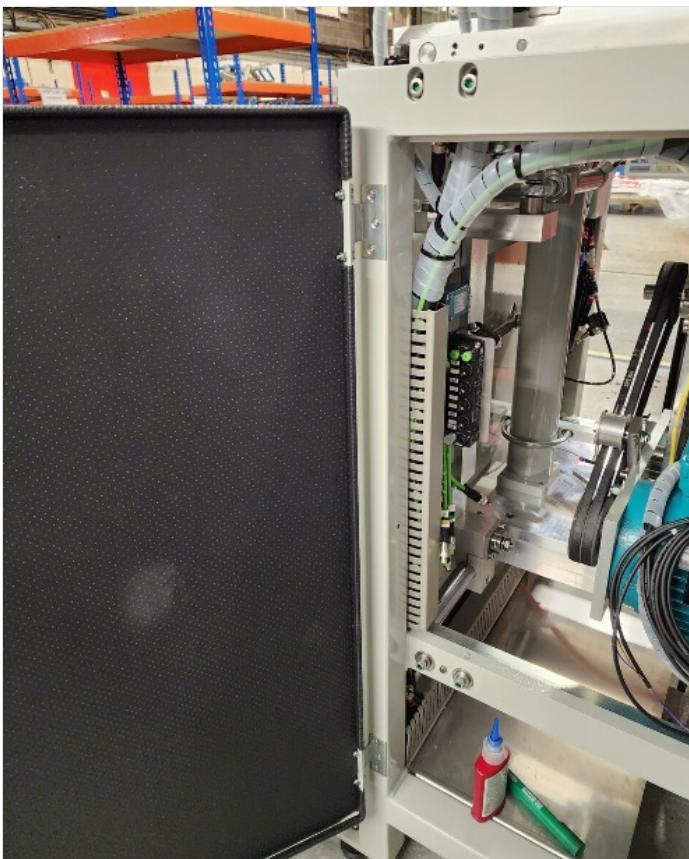


## Step 4 - Fit front door

Fit pre assembled front door to frame

Use 6 off M4 x 12 button sockets only to fix hinges to frame.

Ensure door sits square to frame



## Step 5 - Front door interlock alignment

It is vital that the front door interlock is correctly aligned to the interlock.

Interlock blade must enter interlock smoothly and fully insert into body.

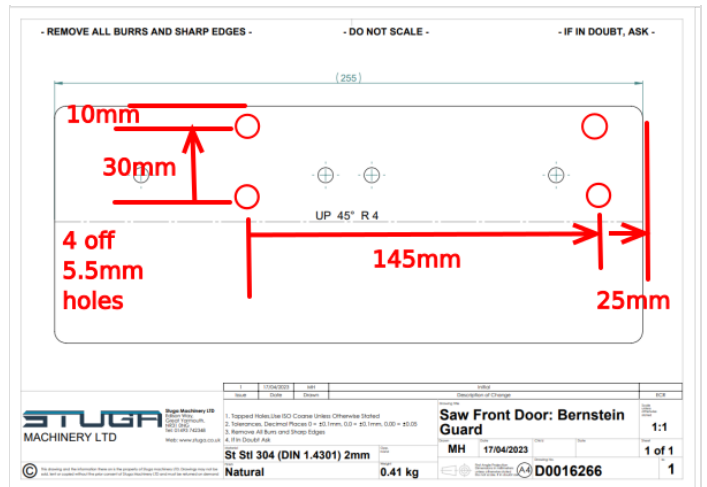
If unsure how to check, please speak to supervisor



## Step 6 - Rework D0016266

ECR Raised 13/12/23

Rework part to attached dimensions until ECR process issues amended part

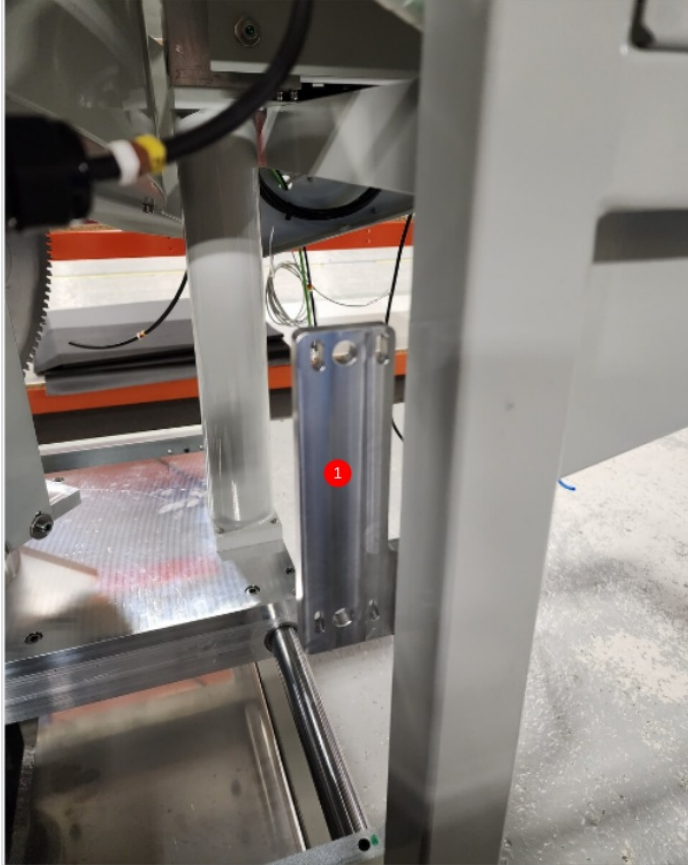




## Step 7 - Fit front door interlock assembly

1 Fit mounting bracket using 2 off M6 x 30 socket caps and heavy M6 washers

2 Attach interlock and guard panel using 4 off M5 x 60 socket caps, M5 penny washers and M5 Nyloc nuts



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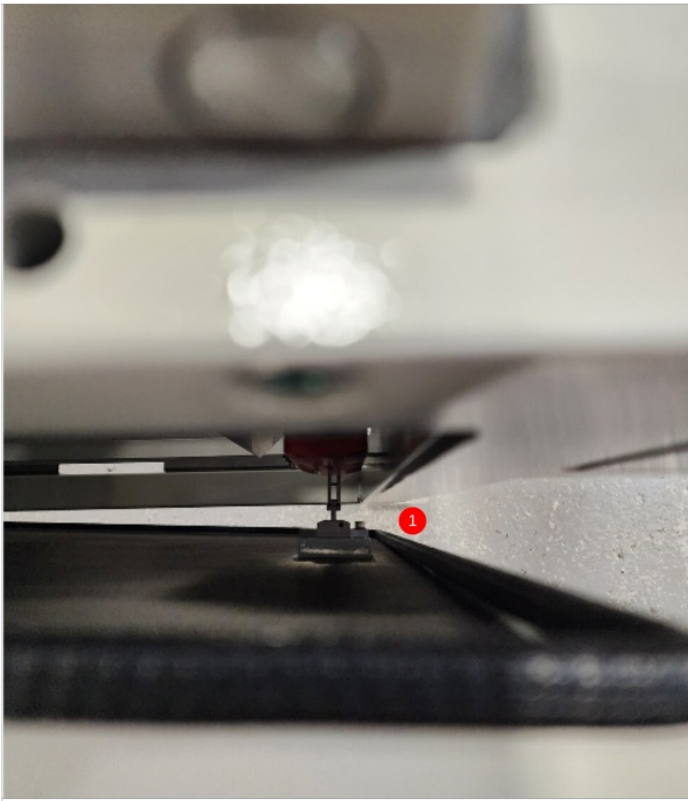
## Step 8 - Align interlock and drill Catch

1 Adjust interlock switch assembly to align exactly with fixed position of blade .

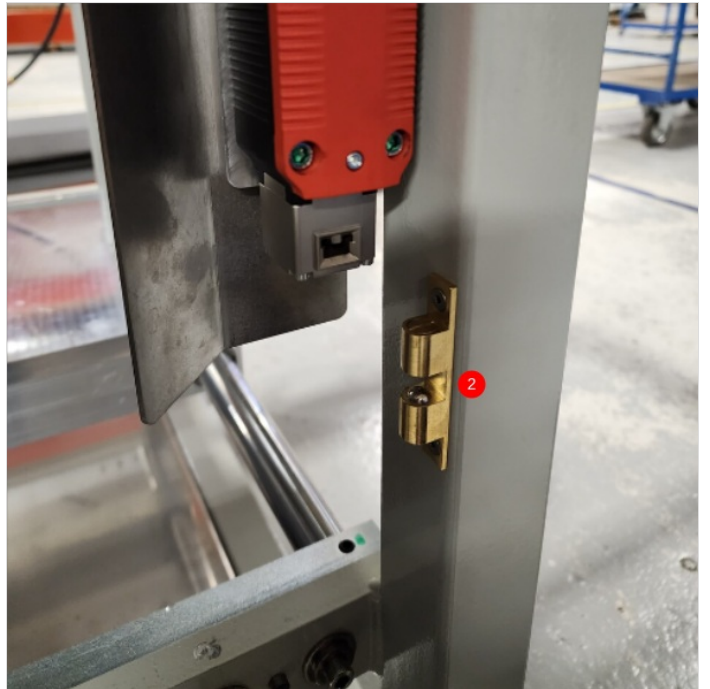
Entry of blade into switch must be smooth and perfectly aligned

2 Mark position of second part of catch assembly with door closed , and drill 2 off M4 tapped holes into frame . Fix with 2 off M4 x 10 countersunk fasteners

3 Check closing and opening of door once all components are fitted in correct and well aligned . Not excessive force should be needed to overcome latch assembly





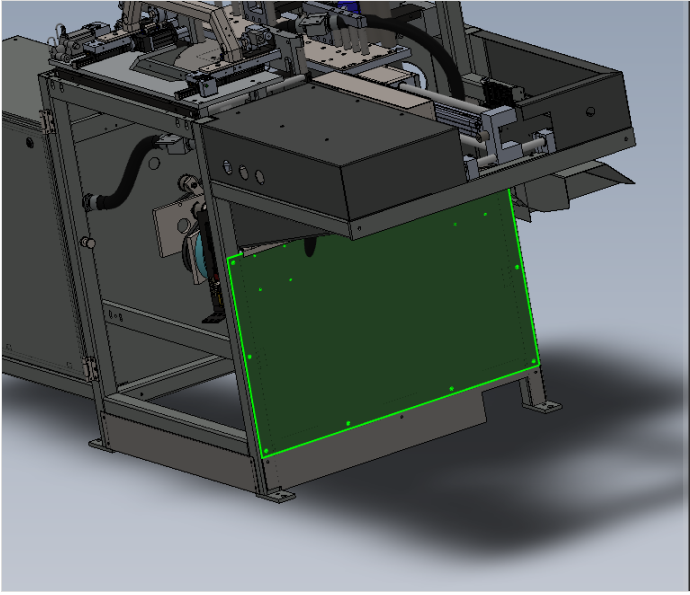


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## Step 9 - Fit hinge panel to frame

Use 12 off M6 x 12 socket caps with A Form washers to fix hinge panel to frame as shown

Once fitted check that holes indicated are well aligned and fasteners can easily be removed







## Step 10 - Fit serial plate

Mark position for serial plate as shown

Mark and drill 1 hole only to 3.3mm

Insert rivet into serial plate and drilled hole ( do not swell rivet) and mark remaining 3 holes

Drill 3 off to 3.3mm

Fix with 4 off rivets and finalise

Fix with rivets



## Step 11 - Fit chute inserts

Fit 2 off chute inserts using 2 off M6 x 12 socket caps and A Form washers

**i** ...Ensure electrical terminations behind these panels are complete before fitting guards



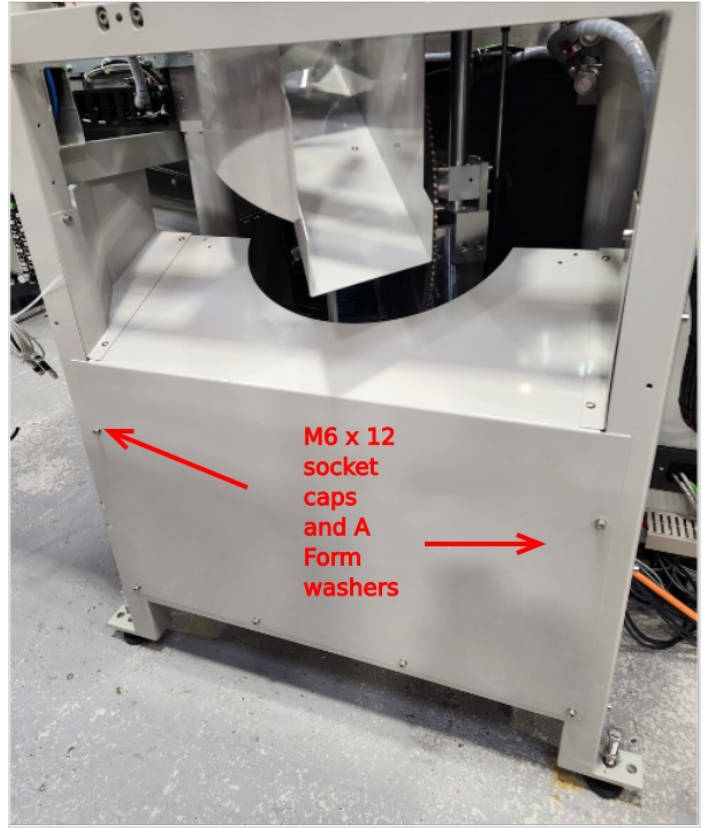
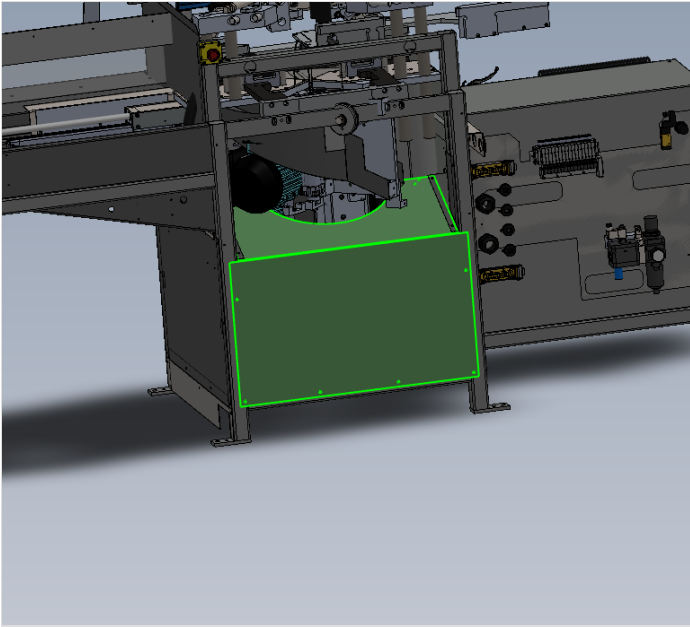
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## Step 12 - Fit rear chute

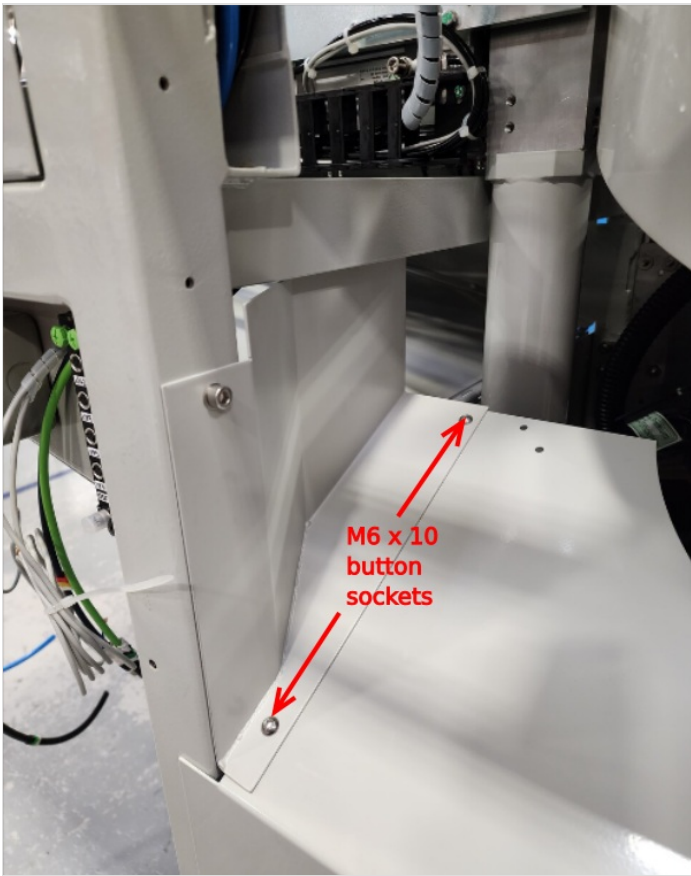
Fit rear chute

Use 4 off M6 x 10 button sockets to connect inserts to chute

Use 6 off M6 x 12 socket caps with M6 A Form washers to connect chute to frame





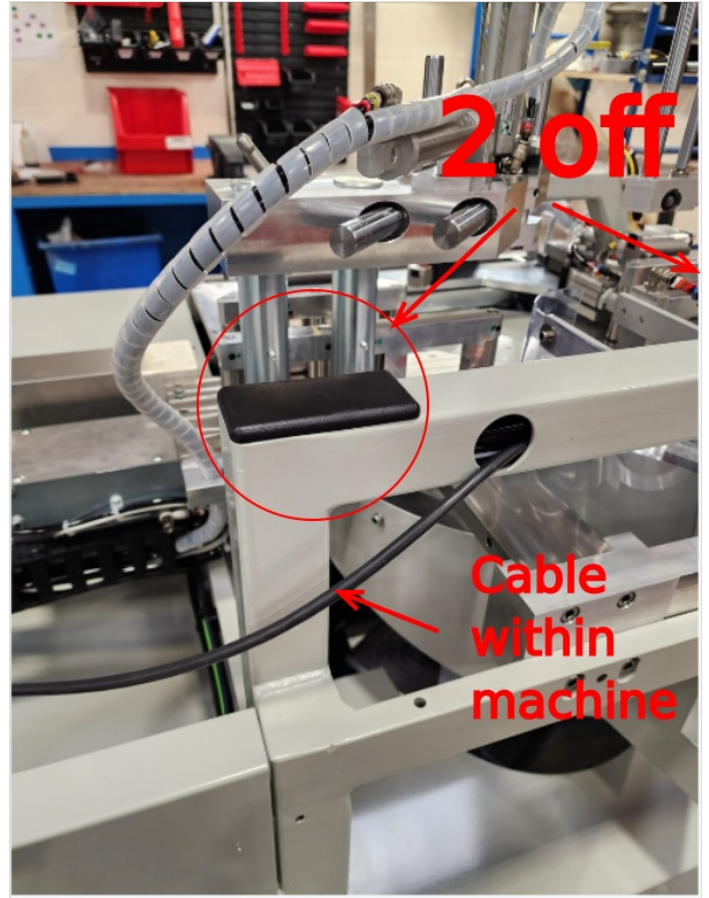


## Step 13 - Prepare to fit top hood

Prepare frame for hood fitting

Ensure cable indicated is as shown .

Check frame bungs are fitted

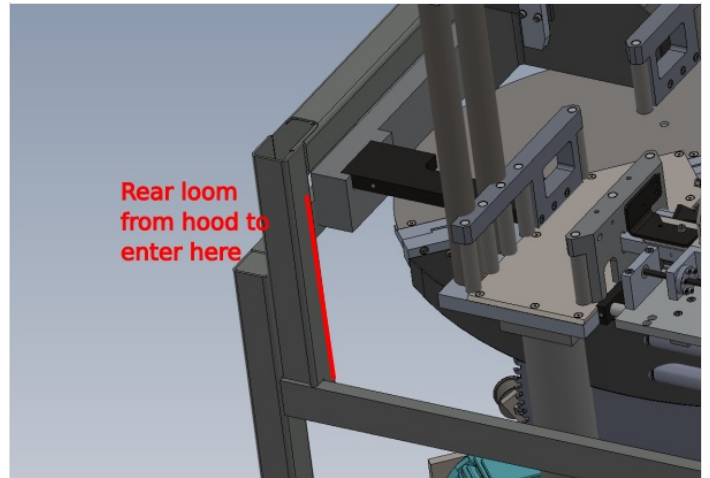
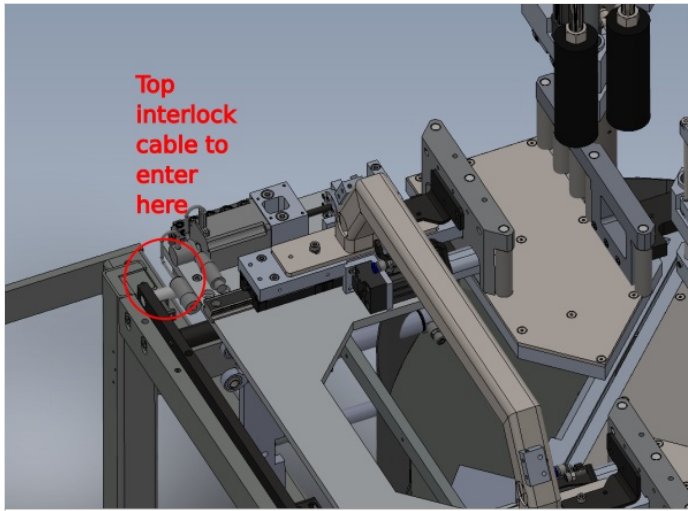


## Step 14 - Position top hood

3 Person lift

Lift and position top hood onto frame

Ensure cables feeding from saw top hood front corner are feed into area shown as the hood is fitted



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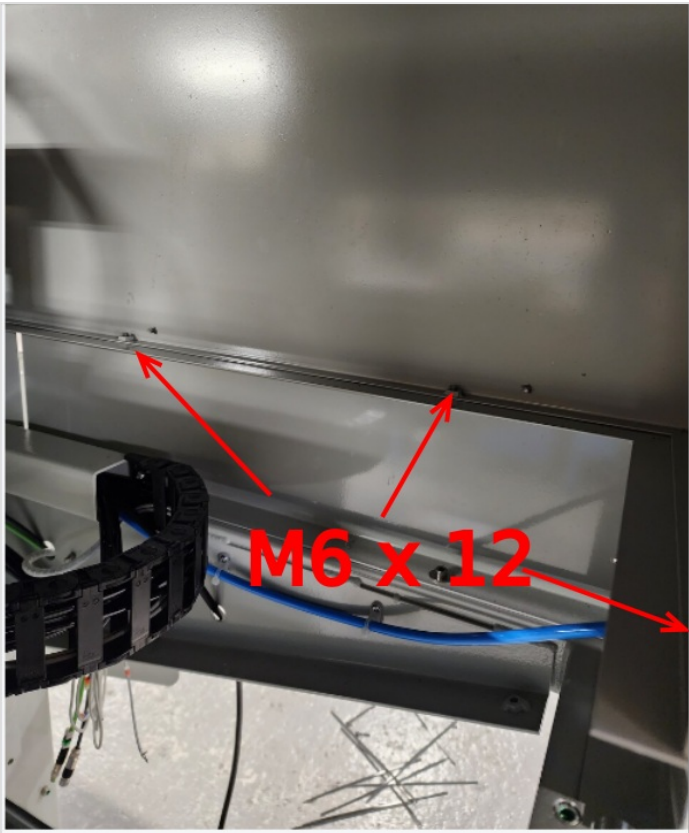
## Step 15 - Fix top hood

Fit 4 off M6 x 60 socket caps with A form washers as shown

Fit 3 off M6 x 12 socket caps and M6 A Form washers as shown

Fit 2 off M5 x 12 socket caps and A form washers as shown







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## Step 16 - Quality check fasteners

Check all fasteners are finalised. Inclusive of all upper and lower tray fasteners





## Step 17 -

Check table alignment

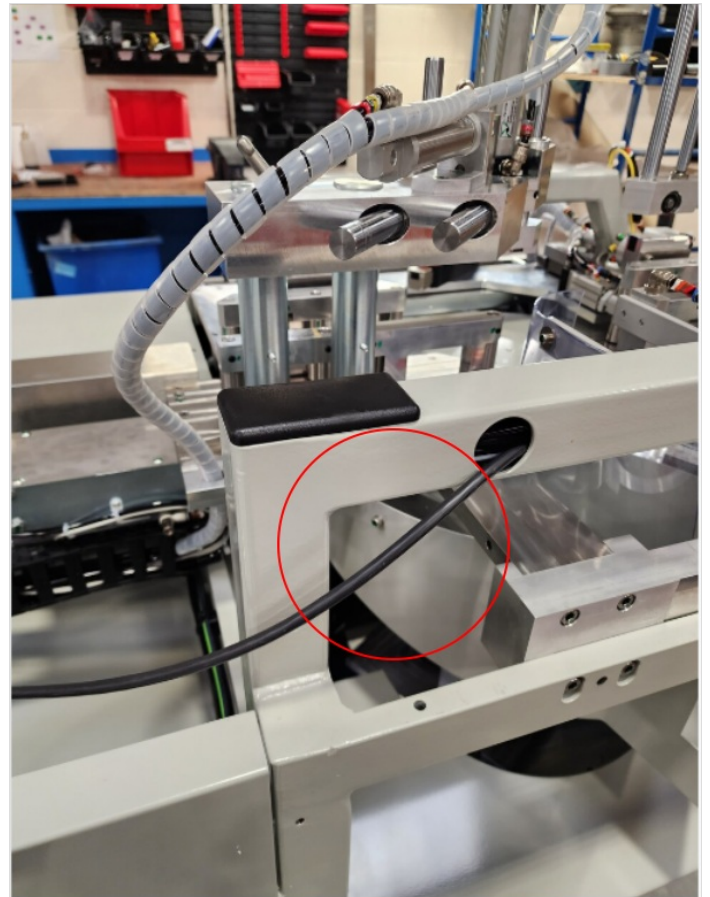
Once top hood is fitted and fastened down, cut table alignment should be checked for movement

See R0000571 Fit and Level Cut Tables , Finalise Eject for correct method of checking flatness of tables



## Step 18 - Exit cable for emergency stop

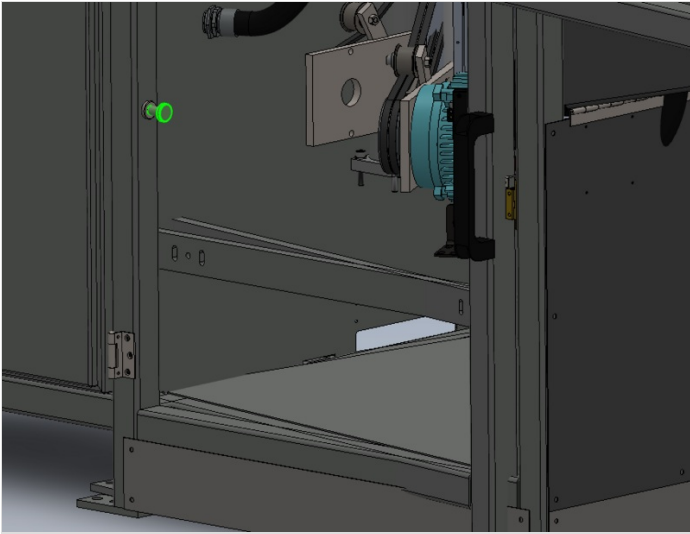
Insert cable through emergency stop from within machine



## Step 19 - Fit blade spanner

Fit blade spanner to frame as shown

- Use 1 off M6 x 30 socket cap
- 1 off M6 penny washer
- 2 off M6 standard nut
- 1 off M6 A form washer





## Step 20 - Fit compliance guard front

Fit front compliance guard

Position central on frame and 15mm up from lowest point of frame

Drill and tap to suit M6 4 off

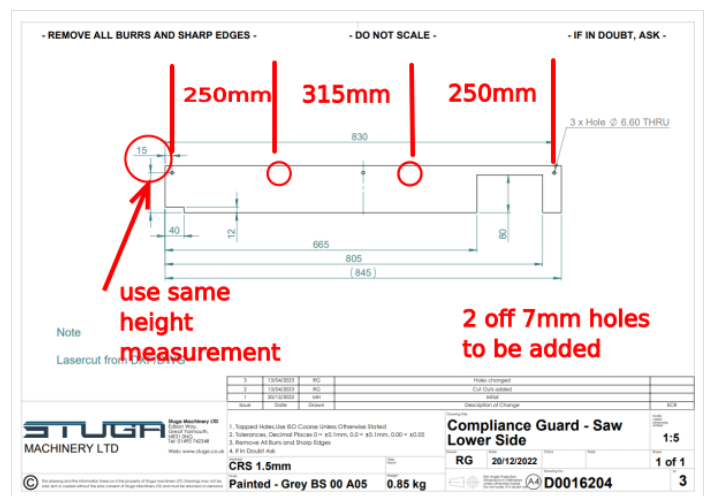
Fix with 4 off M6 x 12 socket caps and M6 a Form washers



## Step 21 - Rework D0016204

ECR raised 13/12/23 to amend and add holes

Until processed rework at assembly to attached drawing




## Step 22 - Fit compliance guard side

Remove lower fasteners from hinge panel and fit compliance guard in position



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## Step 23 - Fit side rests

 ...ensure M6 hole 50mm from end of side rest is at the end shown

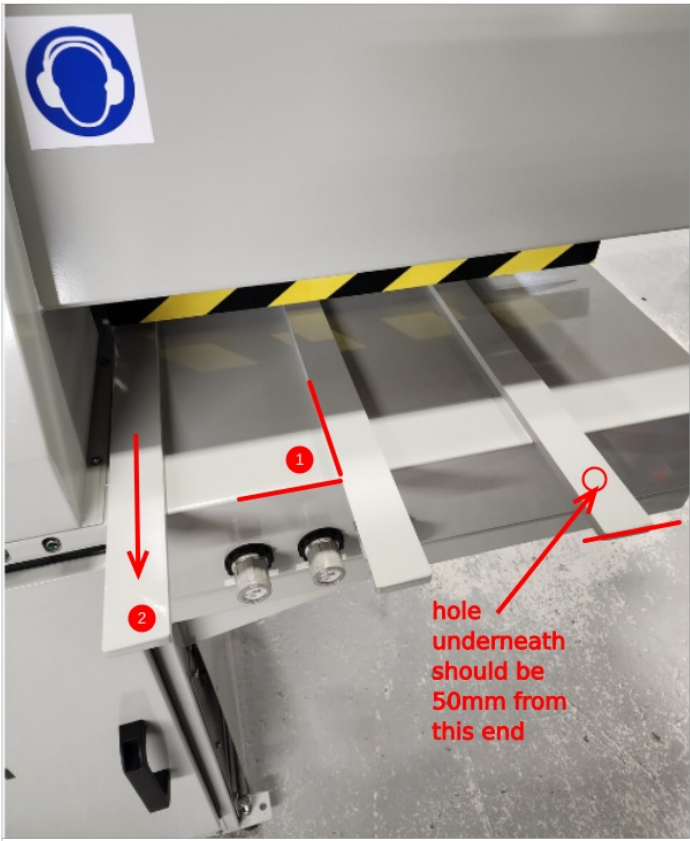
Fit 3 off side rests as shown

Use 6 off M6 x 10 socket caps and M6 penny washers

1 Set square to front tray

2 Ensure in fully forward position

Set all 3 off to these settings





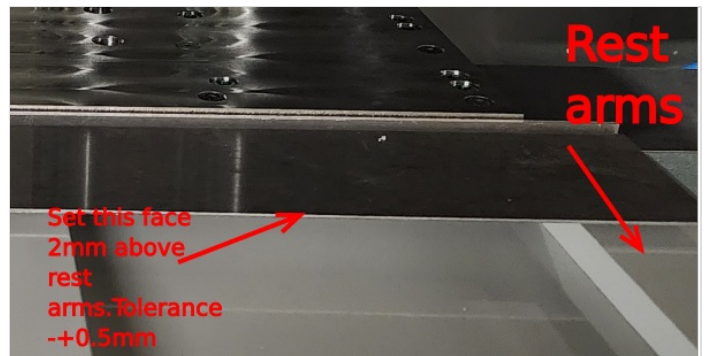
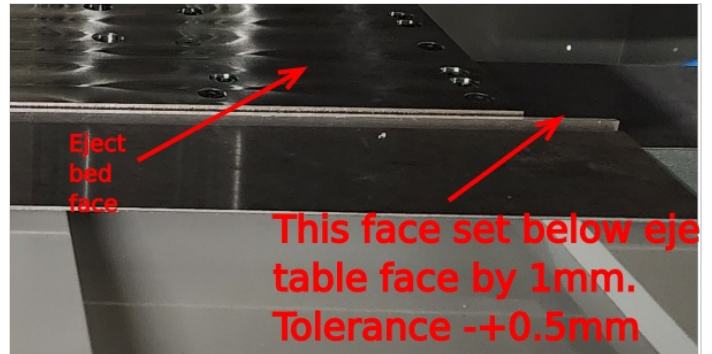
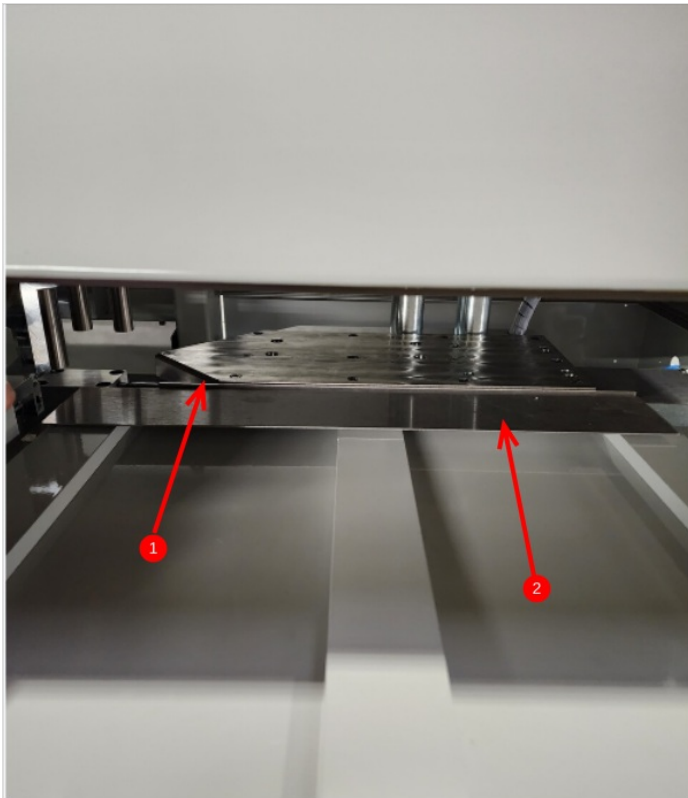


## Step 24 - Finalise position of tip strips

Finalise position of tip strips to the following

1 Set this part 1mm below top face of eject table. Ensure it is set parallel to the eject bed face

2 Set this part to be 2mm above the side rests. Ensure the height is set parallel to the arms. Ensure both ends of this plate are set at 2mm



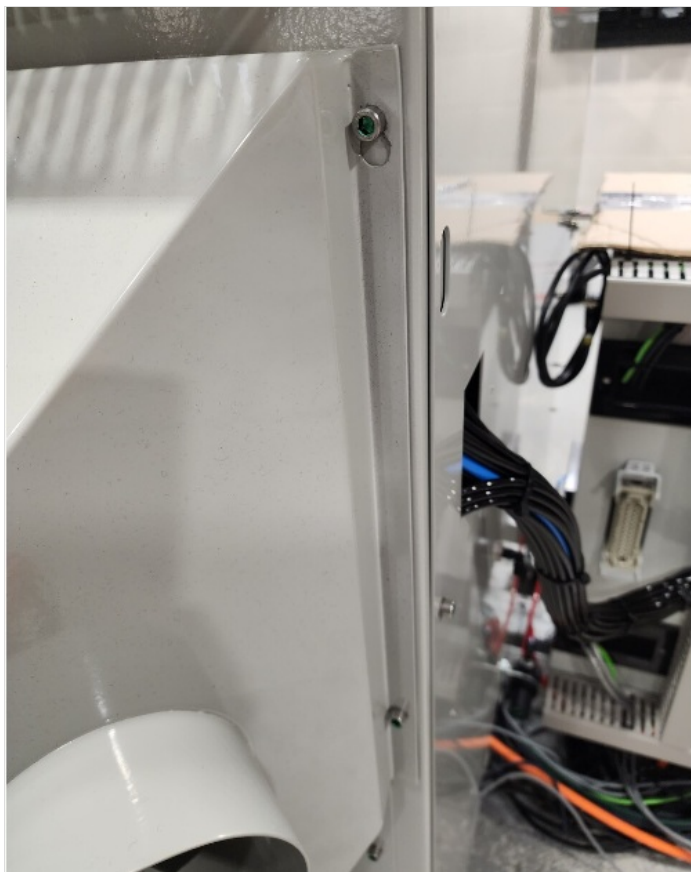
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## Step 25 - Fit Rear door

Fit rear door as shown using 4 off M6 x 12 socket caps

Fit A Form M6 washers to lower 2 off socket caps only





## Step 26 - Fit air gun hook

Fit air gun hook as shown .  
Fix with original panel fixing

