


R0015101 Bench Assemble Take Up Assembly

Instructions to bench assemble take up parts

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set
Standard spanner set

Parts Required

D0008281 Takeup Boss Cap x 4
D0015581 Fixed Pivot Bracket x 4
D0015584 Cylinder Trunnion Plate x 1
D0015590 Takeup Arm ZX5 x4
D0015593 Takeup Arm Pin ZX5 x 4
D0015595 Takeup Arm Washer 4mm x 4
D0015596 Takeup Bearing Block Short x 4
D0015605 Fixed Pivot Bracket End Plate x 4
D0015736 Hard Stop Backplate x 1
D0015737 Hard Stop Shaft x 1
M0001077 Rubber bump stop M6 x 1
P0000010 Elbow Adaptor 6mm - 1/8 BSPT (Taper thread) x 1
P0000049 Cylinder Spherical Bearing M10 x 1.25 x 1
P0001075 Trunnion Pin for CG1 Cylinder x 1
P0001076 Trunnion Bracket for CG1 x 1
P0001112 Cylinder 32 x 125s Locking
P0001198 Fitting: Speed Controller 1/8" x 6mm Tube

Step 1 - Unless otherwise stated

Use loctite 243 on all fasteners

Use loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



Step 2 - Assemble cylinder unit

1 Fit air fittings PP0001198 2 off and P0001198 1 off as shown

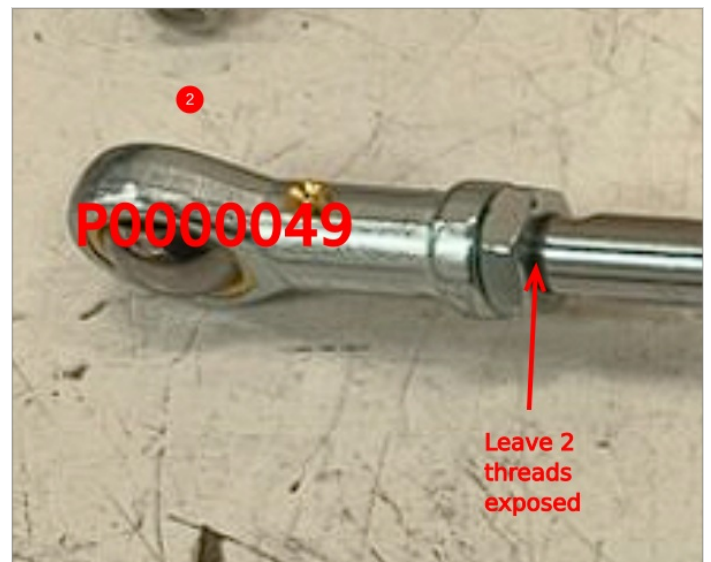
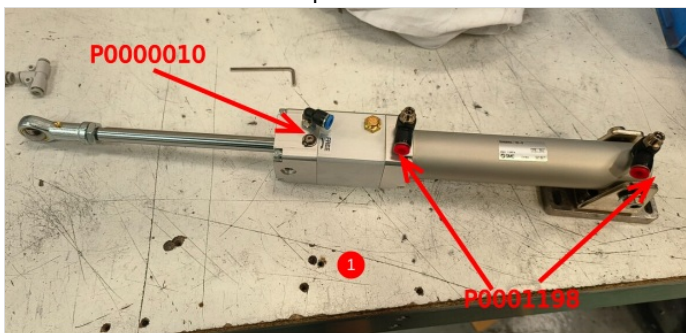
2 Attach P0000049 Cylinder Spherical Bearing to cylinder, use adhesive and finalise lock nut. Leave 2 threads exposed

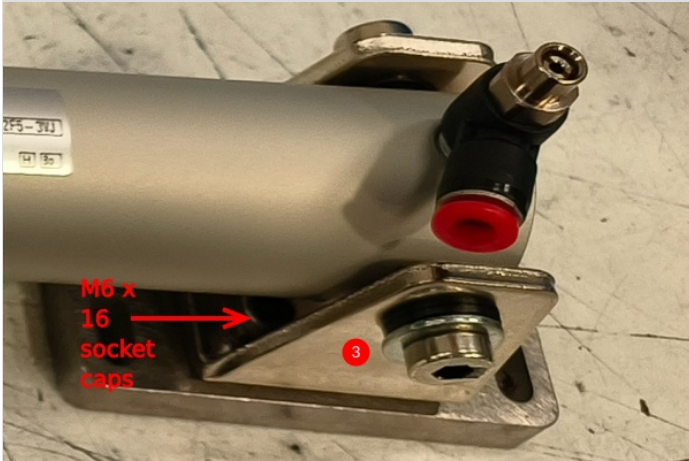
3 Attach Cylinder clevis end using parts

P0001075 Trunnion Pin for CG1 Cylinder x 1

P0001076 Trunnion Bracket for CG1 x 1

Attach with M6 x 16 socket caps

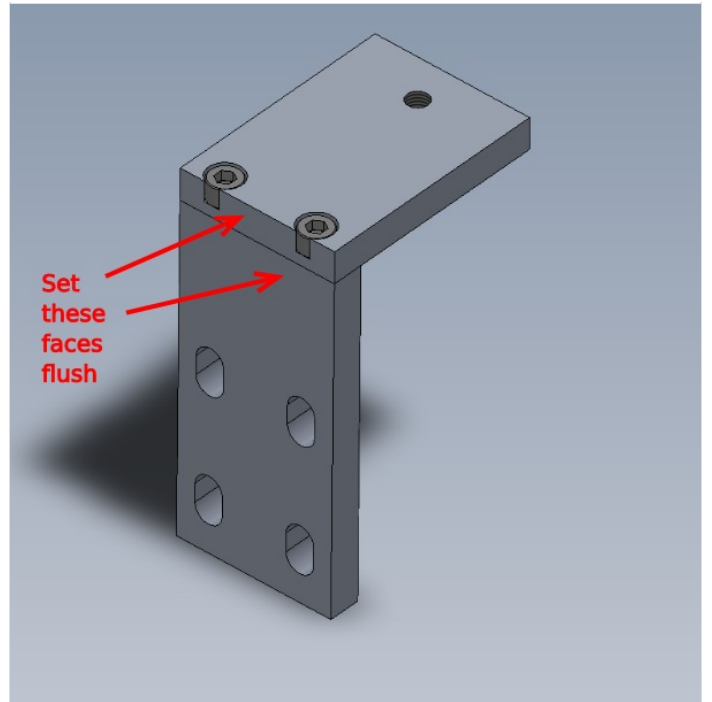
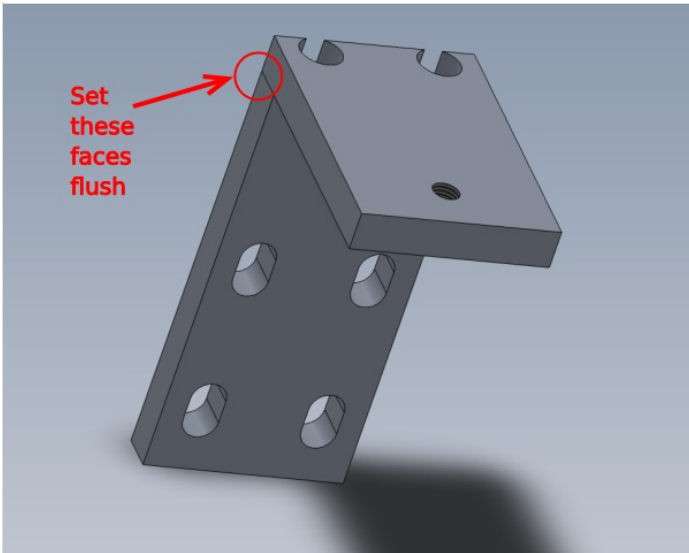




Step 3 - Mounting bracket assembly

4 off

1 Combine D0015605 and D0015581 and fasten with 2 off M6 x 16 socket caps



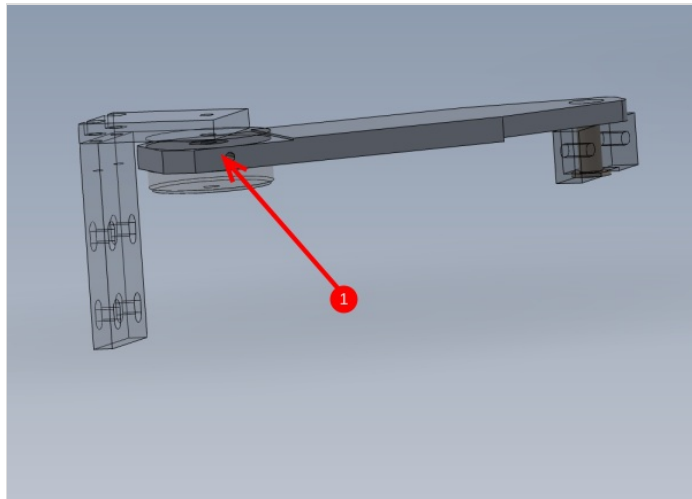
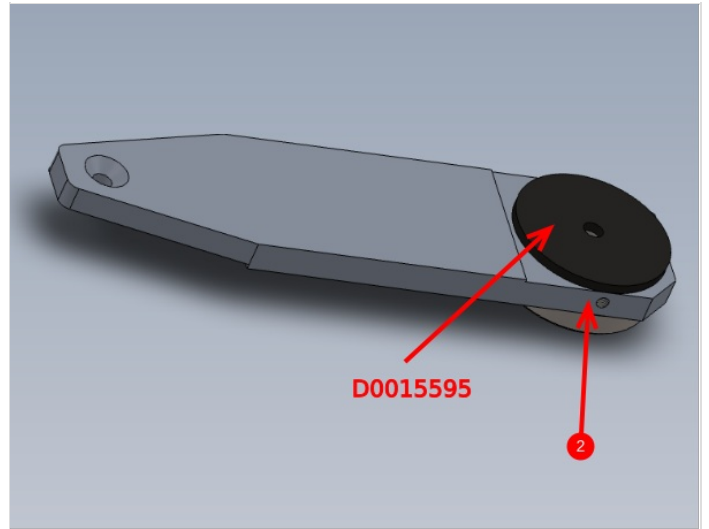
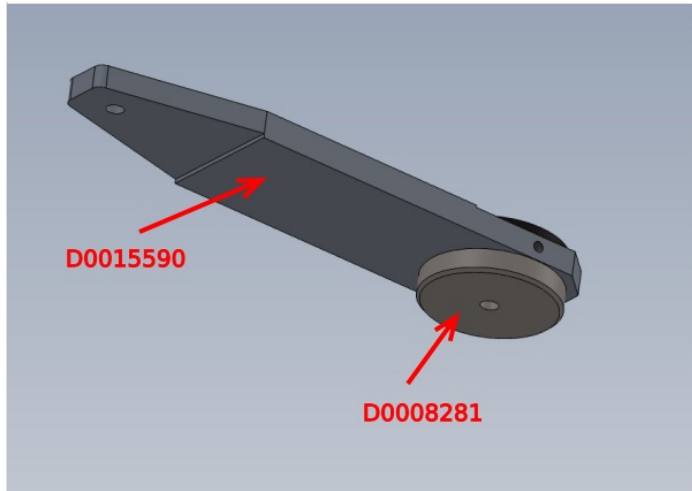
Step 4 - Assemble arm

4 off

Assemble arm parts as shown

1 Add M6 straight grease nipple to indicated face

2 Add M6 x 10 grubscrew to indicated face

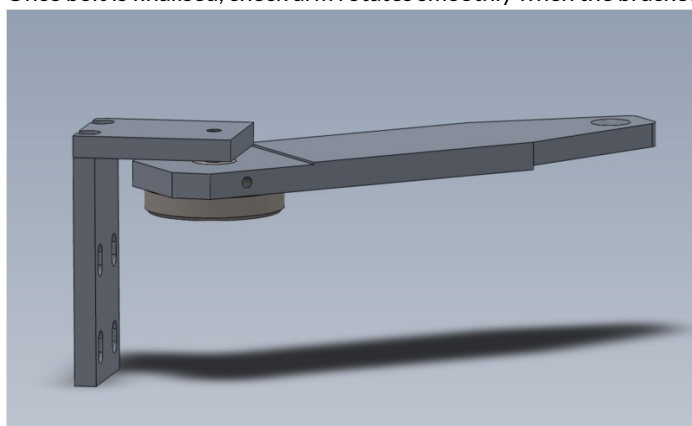


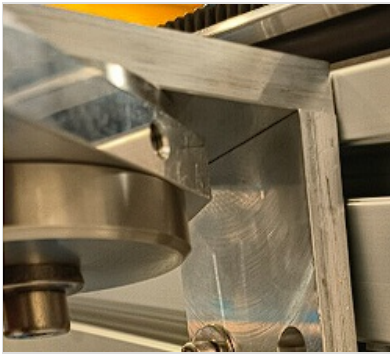
Step 5 - Assemble arm to bracket

4 off

Use M8 x 40 socket cap with heavy M8 washer to combine parts as shown . Use loctite 270 on M8 socket cap

Once bolt is finalised, check arm rotates smoothly when the bracket is held



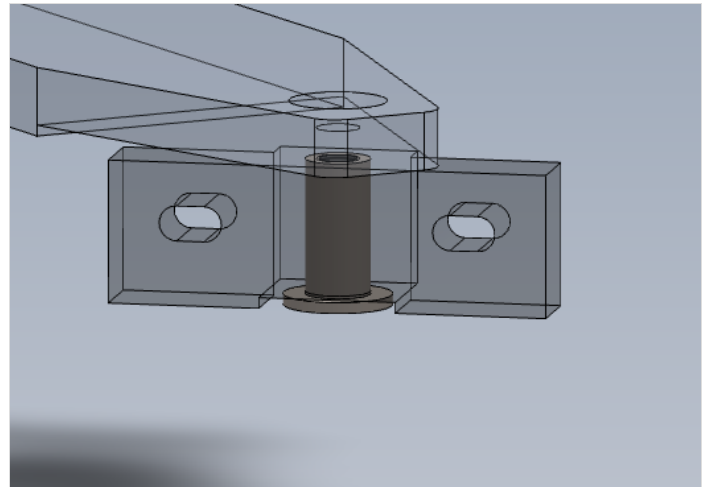
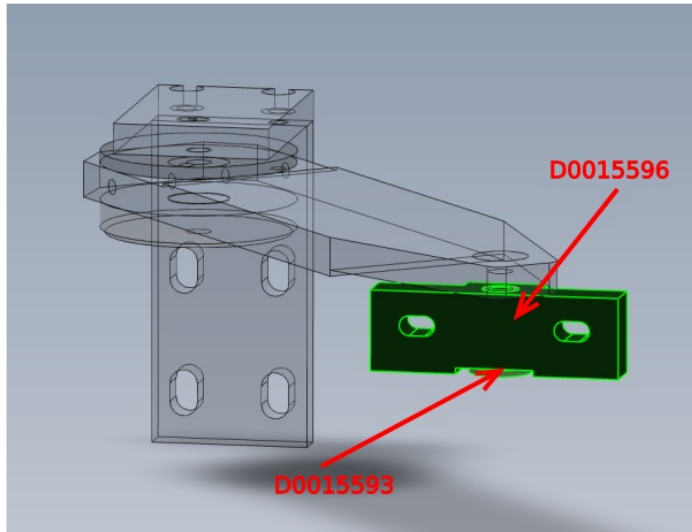


Step 6 - Attach bearing block

4 off

Insert D0015593 pin into takeup bearing block D0015596 and secure to arm using M8 x 30 Countersunk bolt and use Loctite 270 to fix

Check that D0015596 block turns freely once fastened

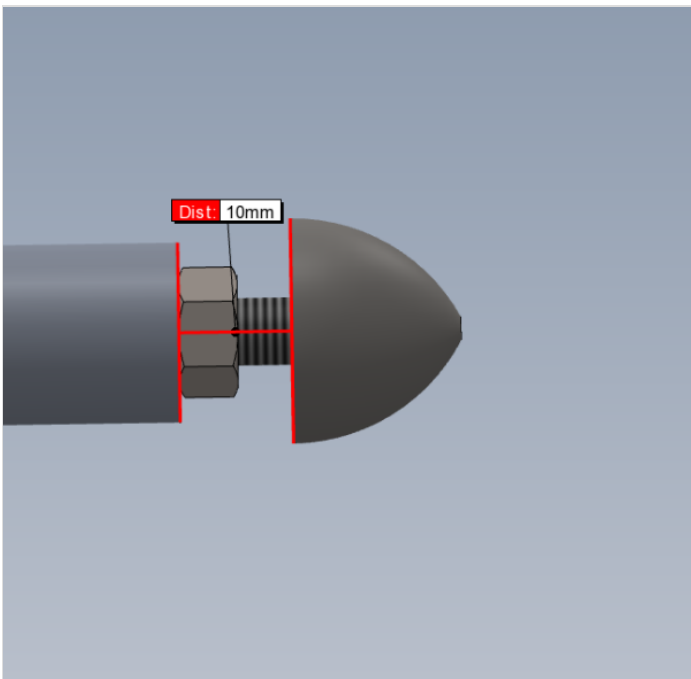
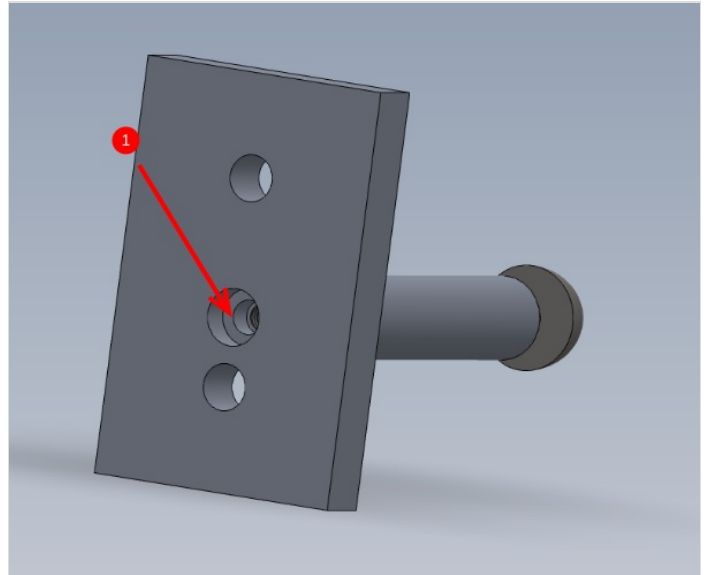
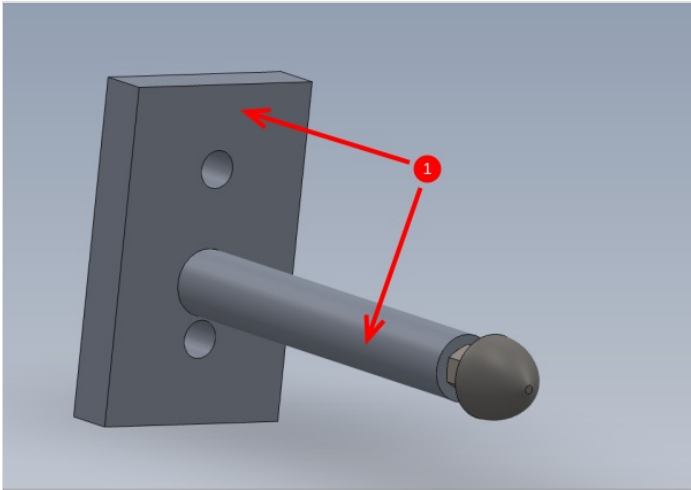


Step 7 - Assemble bump stop

1 off

1 Mount D0015737 shaft to D0015736 Backplate using M6 x 16 socket cap

2 Attach bump stop M0001077 with M6 standard nut, use loctite 243 and set to dimension shown



Step 8 - Lubrication

4 off arms should be lubricated with grease gun and trojan grease via greasing point

