

R0015119 Mount Assemblies

Assembly instructions

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set
Standard spanner set
Standard hss drill set
Standard tap set

Parts Required

D0004600 Outfeed Eject Bar
R0015342 Bench Assemble Outfeed Parts

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 570 on all threaded pneumatic connections

Pen mark all bolts when finalised



Step 2 - Check correct position for mounting

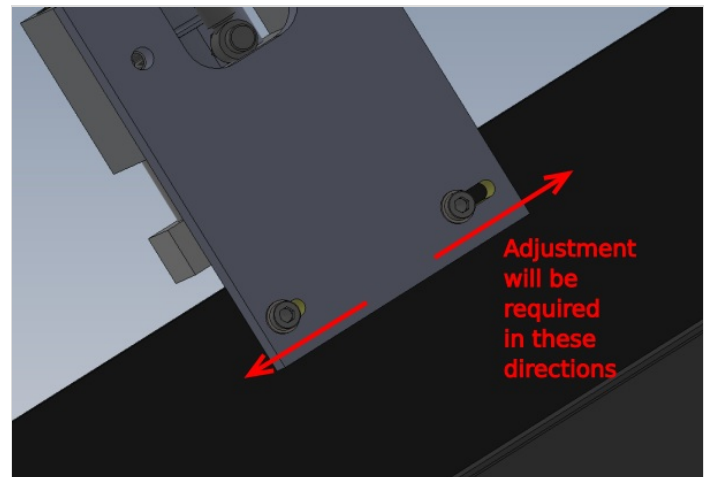
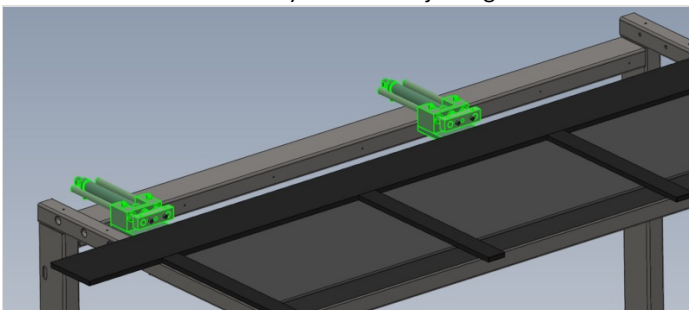
Note that main fixing bar is unhandled and will have various mounting points for components.

Double check correct holes are used for fixing assemblies. Follow steps below to identify correct mounting points



Step 3 - Mount cylinder assemblies

Attach 2 off pre built cylinder assemblies from R0015342 as shown using 4 off M6 x 20 socket caps and M6 heavy washers . Do not apply tension to these bolts as they will need adjusting



Step 4 - Attach push eject bar

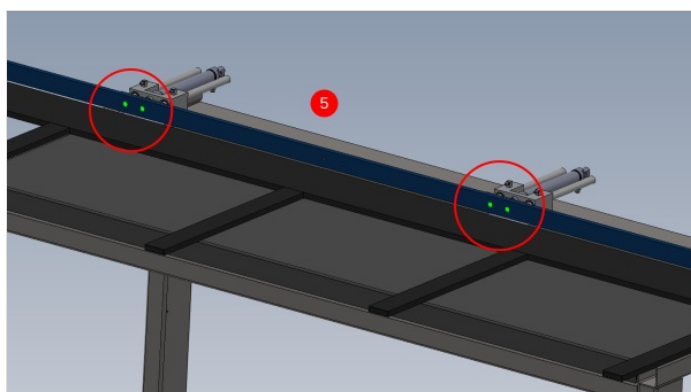
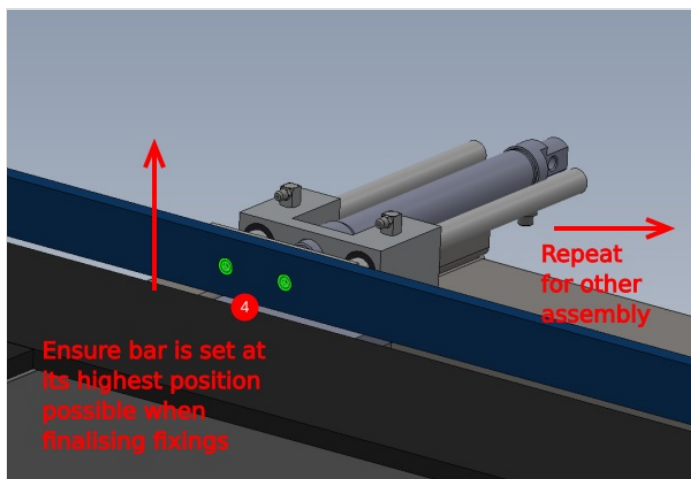
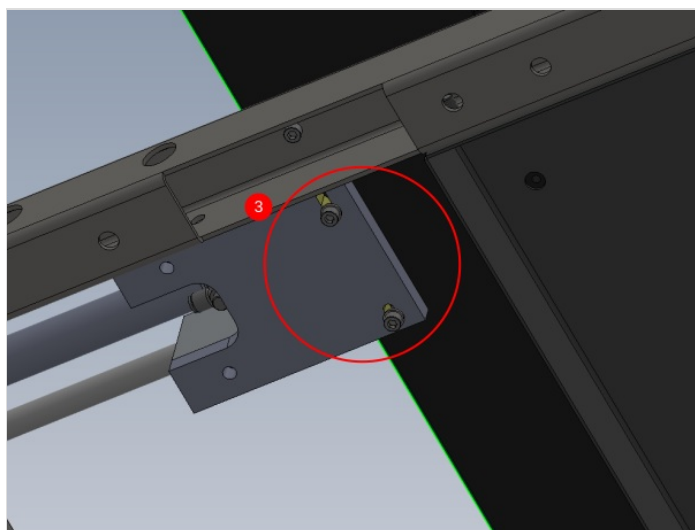
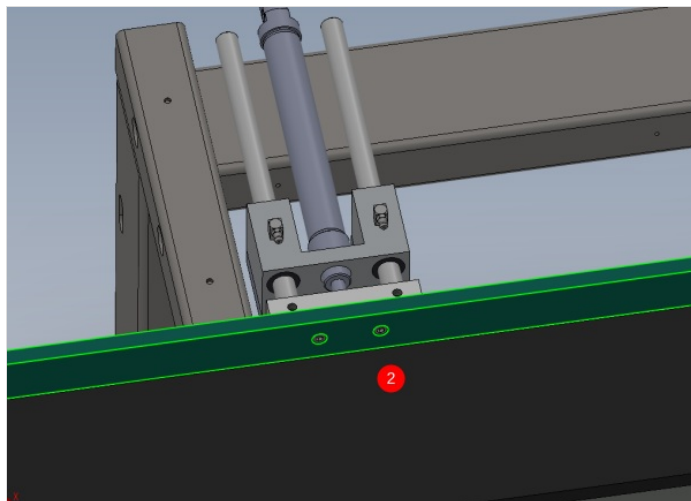
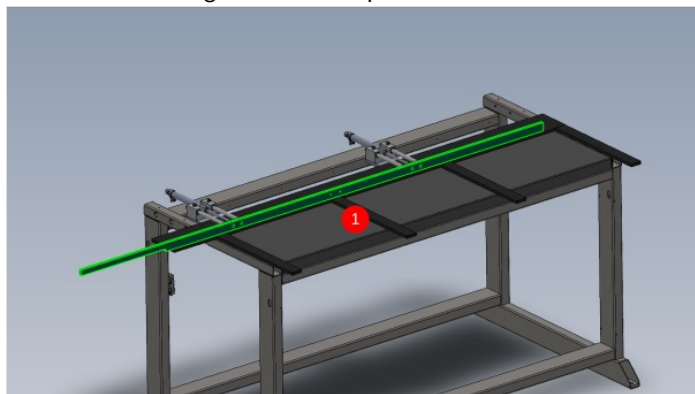
1 Attach D0004600 Outfeed Eject Bar x1 as shown using 4 off M6 x 25 socket caps. Apply only light pressure to these fixings

2 Ensure cylinder assemblies are retracted to the position shown

3 Finalise fixings (4 off 2 per cylinder assembly) shown to set correct pitching between cylinder assemblies

4 Set correct push bar position. Slacken indicated fixings and set push bar at its highest point as indicated

5 Finalise 4 off fixings that hold the push bar

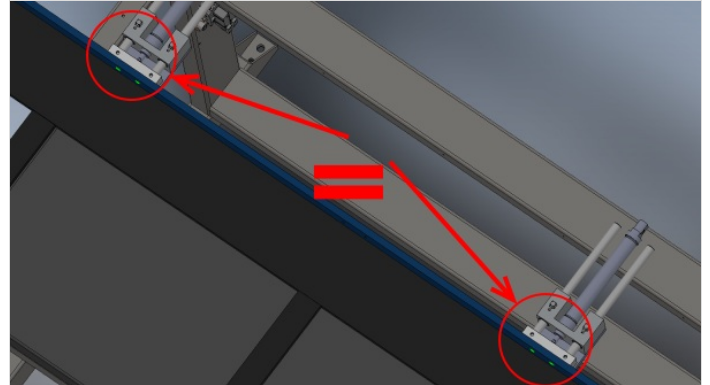
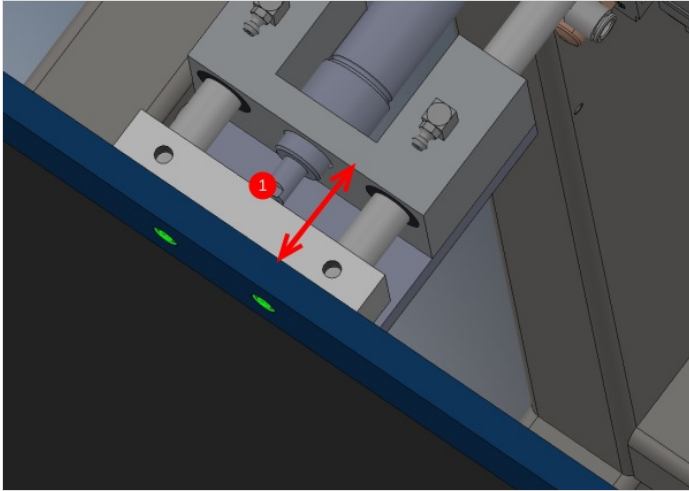


Step 5 - Finalise position of cylinder stroke

1 Measure 1 cylinder assembly at position shown

2 Adjust cylinder stroke of second assembly to replicate this first measurement

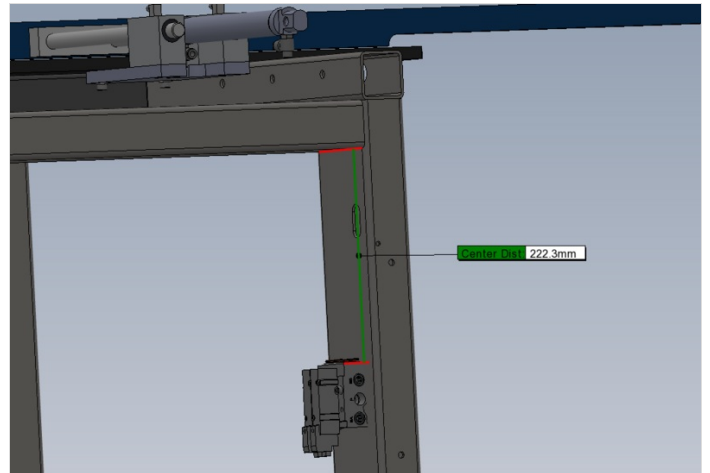
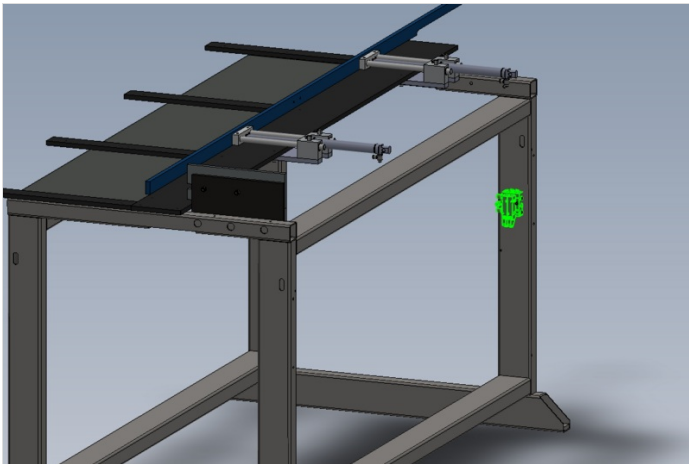
3 Double check all fixings have been Finalised including cylinder stroke lock nuts

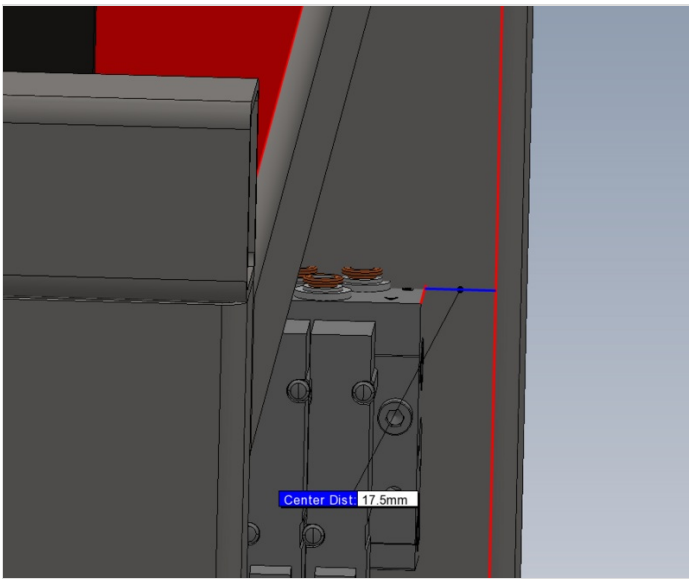


Step 6 - Mount valve bank

Ecr raised 01/11/23 to correct incorrect hole size for mounting valvebank. Rework to M4 fixing until ecr is processed
Mount Pre assembled valve bank from R0015342 at the position shown. Use 2 off M4 x 40 socket caps and A form washers to fix.

If pre drilled holes are not present, drill 2 off M4 tapped holes to position the valve bank to the measurements shown





Step 7 - Mount safety gate assembly

Do not apply adhesive or finalise fixings

Use 3 off M8 x 20 socket caps with M8 heavy washers to fix safety gate into position shown
To Fix cylinder base to frame, use the following fasteners
1 off M6 x 50 socket cap 2 off M6 A Form washer 1 off M6 standard nut 1 off M6 Nyloc nut
See Photo for orientation

