


# R0015242 Level and Adjust Roller beds module C and E

Details for correct setting of roller bed assemblies

 Difficulty **Hard**

 Duration **8 hour(s)**

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Comments

## Introduction

### Tools Required

Standard hex key set  
Standard spanner set  
Engineers level  
2mm shim spacer  
2 meter straight edge

### Parts Required

Installed transfer beam assemblies

## 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 - Air Supply

The following steps require air supply to be active on the home line of the roller beds. Connect air to feed pipe from manifold bank to lift roller assemblies to home position



## Step 3 - Level roller beds

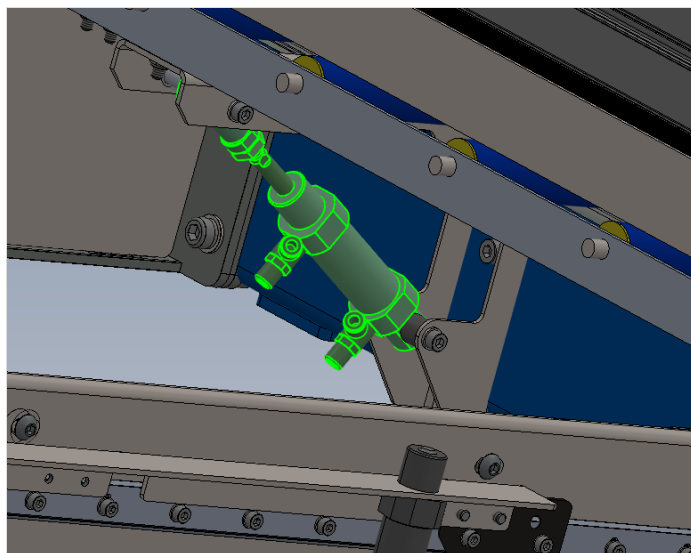
It is vital roller beds are levelled and positioned correctly

The following steps should be repeated for each and every roller bed assembly



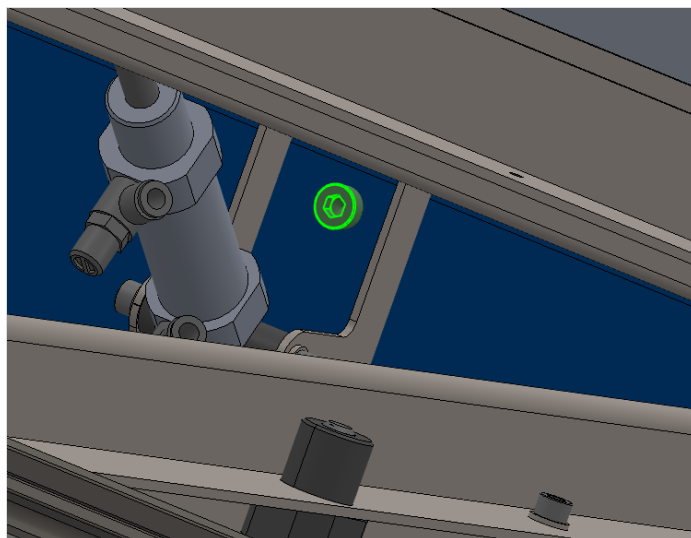
## Step 4 - Cylinder adjustment

Each cylinder assembly will require adjusting to level roller bed correctly



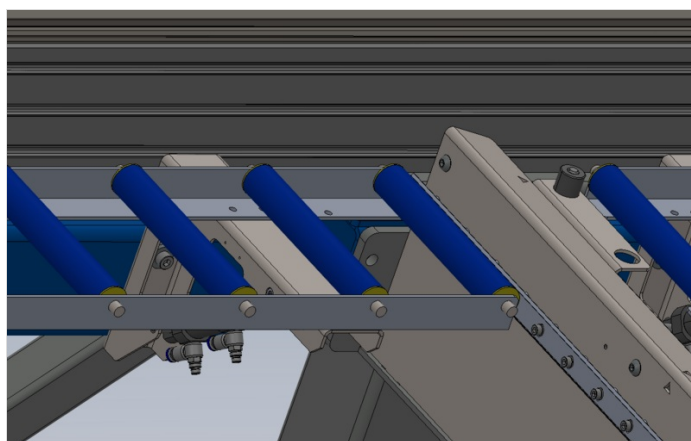
## Step 5 - Check fasteners

Check fasteners holding roller assembly to frame are tensioned correctly. Not adhesive is required at this stage



## Step 6 - Position Engineers level

Engineers level should be positioned directly above cylinder assembly



## Step 7 - Adjust cylinder stroke

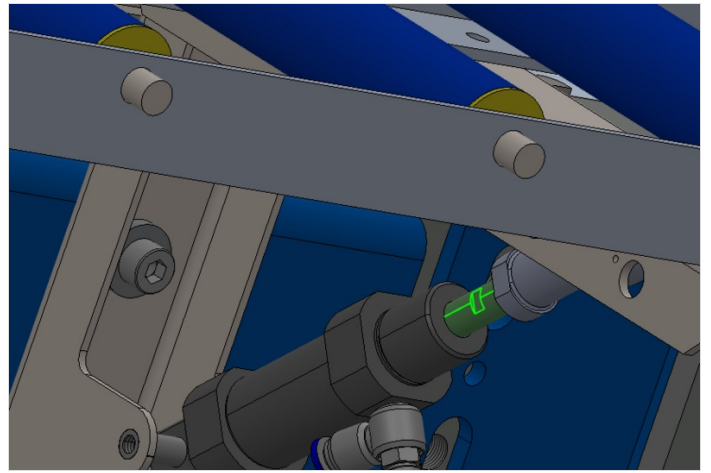
Wind back cylinder lock nut and apply 1 drop of Loctite 243 to exposed cylinder thread

Adjust cylinder stroke to bring engineers level to level position

Lock Locking nut in position ,Ensure that 2 spanners are used to hold spherical bearing and cylinder lock nut when tensioning

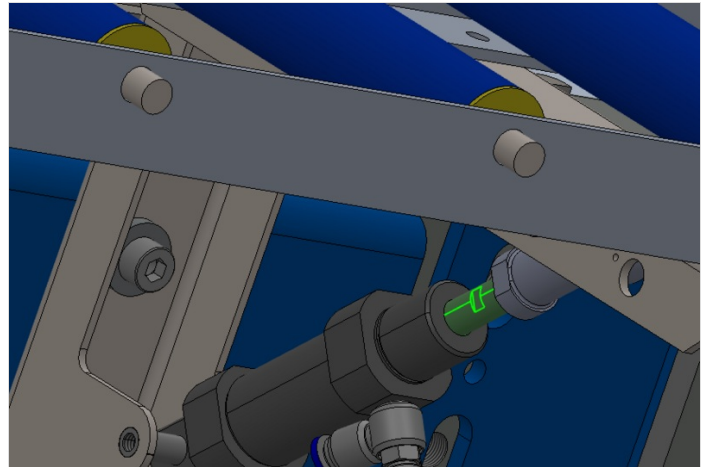
Ensure level is not affected on tensioning. If so, re adjust to correct

Apply final tension to cylinder lock nuts and mark as finalised



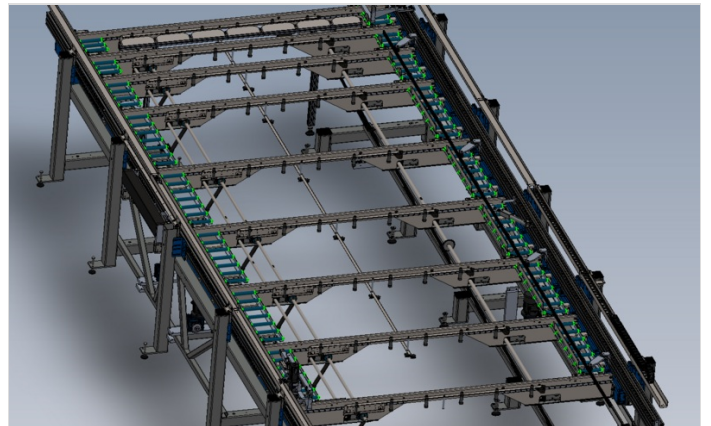
## Step 8 - Double cylinder roller beds

If a double cylinder roller bed is levelled , it is vital to check the first cylinder again after setting second cylinder level position



## Step 9 - Repeat

Repeat levelling process for all roller beds on module C and E



## Step 10 - Quality check on roller beds

Use a 2 meter straight edge to roll across the top face of all the roller beds when in the up position.

Transition should be smooth and bump free from each roller bed to the next

Check in both directions of travel



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## Step 11 - Height setting

It is vital the roller beds are set at the correct height in relationship to the gripper assembly

The following steps should be used to correctly set roller bed heights



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## Step 12 - Please Note!!

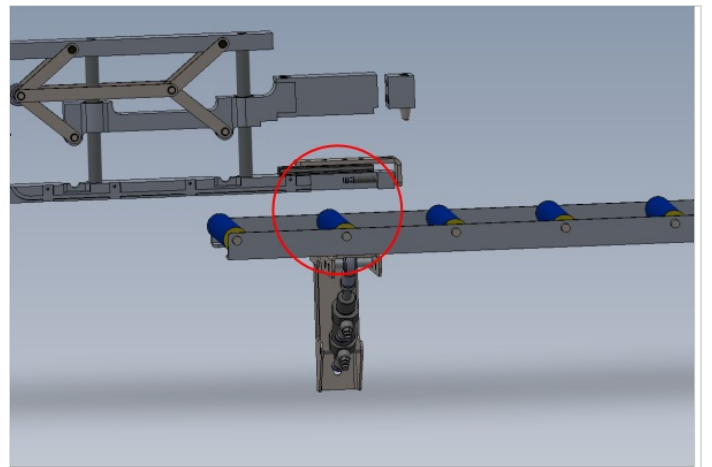
When adjusting height of roller bed assemblies, do not use impact from hammer to adjust . This leads to damage of the small top hat bush within the assembly . adjust height position with fasteners slack , so no force is applied to these bushes



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## Step 13 - Position gripper

Gripper should be positioned directly above cylinder to be adjusted

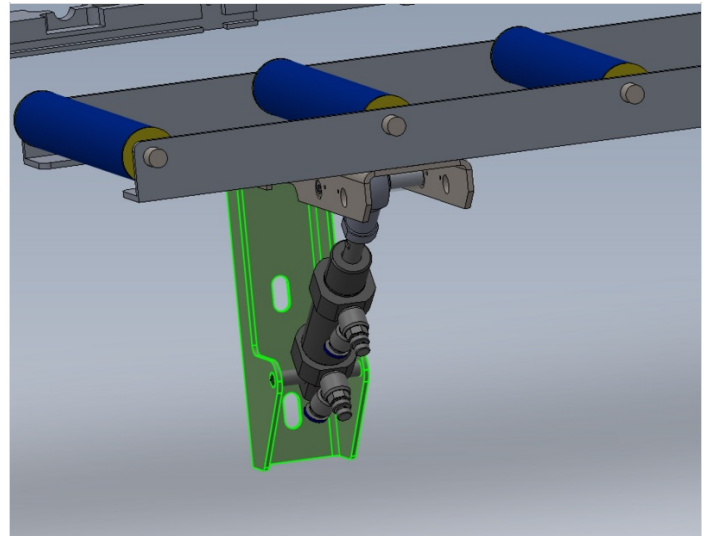
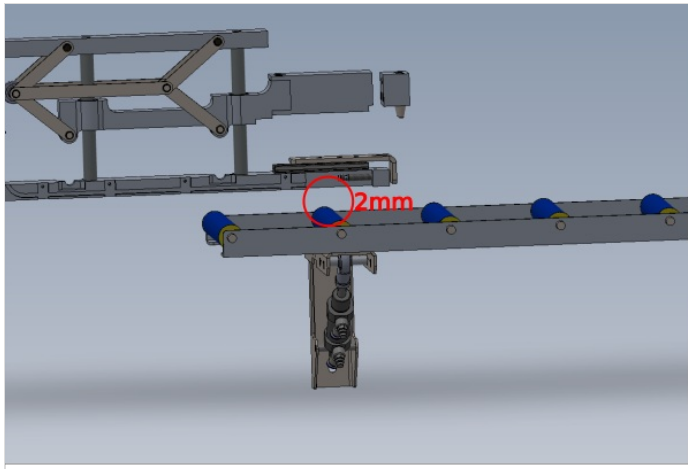


## Step 14 - Gap Setting

Gap requires setting to 2mm between bottom of gripper and top of roller

Use a 2mm shim to set this distance

To adjust roller bed height, slacken bracket fixings and move bracket on slot



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## Step 15 - Double cylinder assemblies

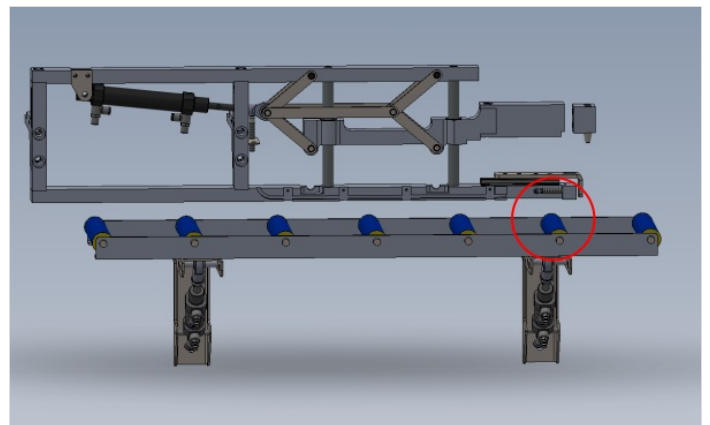
Double cylinder assemblies will need additional setting.

Adjust first cylinder position height

Move gripper to second cylinder

Adjust second cylinder position

Move gripper back to first cylinder and check position hasn't altered

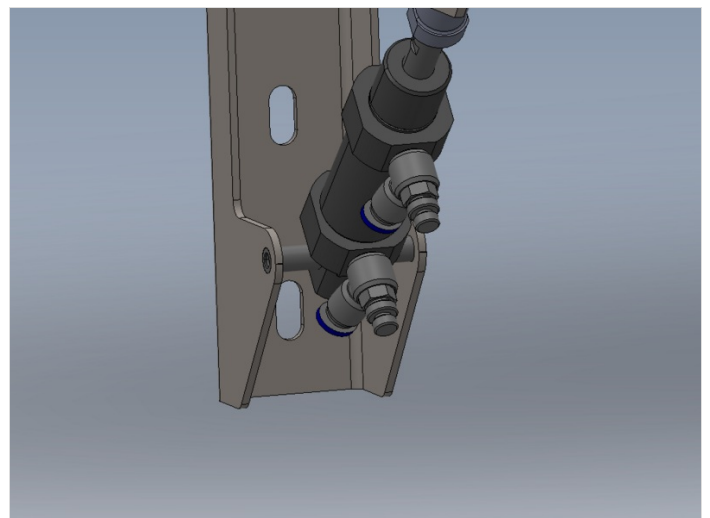


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## Step 16 - Finalise fixings

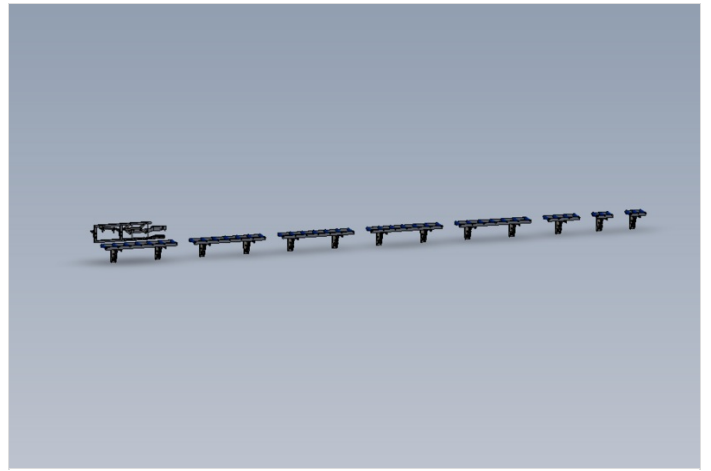
Once correct height has been set, adhesive will need individually applying to each fastener

2 off M8 per bracket require finalising



## Step 17 - Repeat above steps

Repeat above steps to set all roller beds on module C and E using the gripper as the datum for each roller bed



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## Step 18 - Check transitions

Use a 2 meter straight edge to 'Roll' along the levelled and set roller bed assemblies

Transition from one roller bed assembly to the next should be smooth with with no jump or drop onto neighbouring roller beds

If discrepancies are found, double check height and levelling, and if correct report to supervisor

