


# R0015250 Bench Assemble Support Arms

Instructions for bench assembly of support arms

 Difficulty Easy

 Duration 5 hour(s)

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Step 1 - Unless otherwise stated

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Comments

## Introduction

### Tools Required

Standard hex key set

Standard tap set

Setting jigs

### Parts required

B0001170 Spacer 180 off

B0001155 open rail 18 off

D0015552 Transfer Support arm R/H (right to left machine) OR D0015553 Transfer Support Arm L/H (Left to Right machine)

D0015554 x 18

## Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

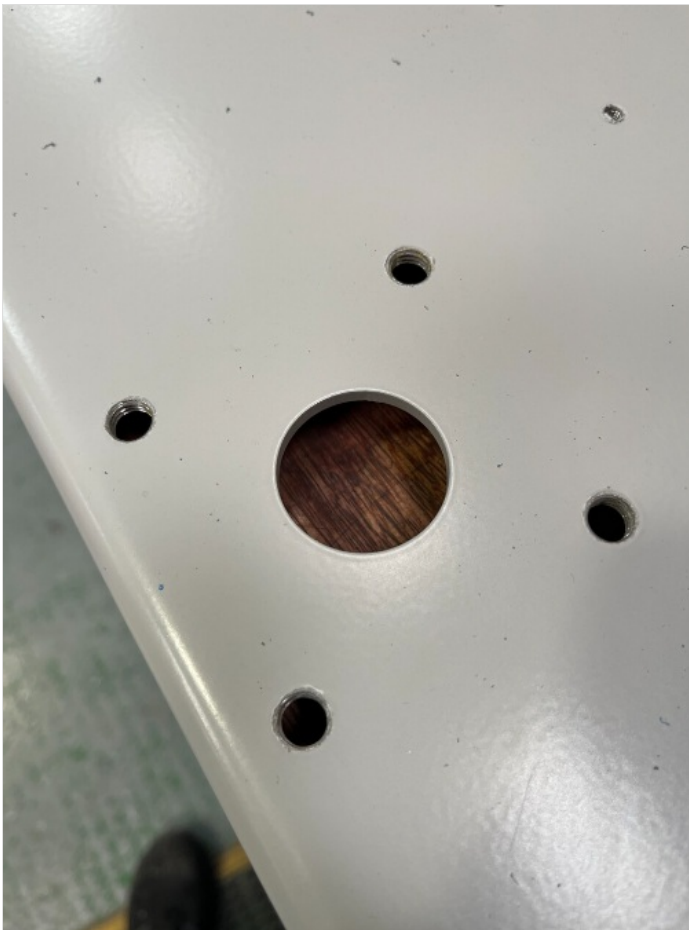
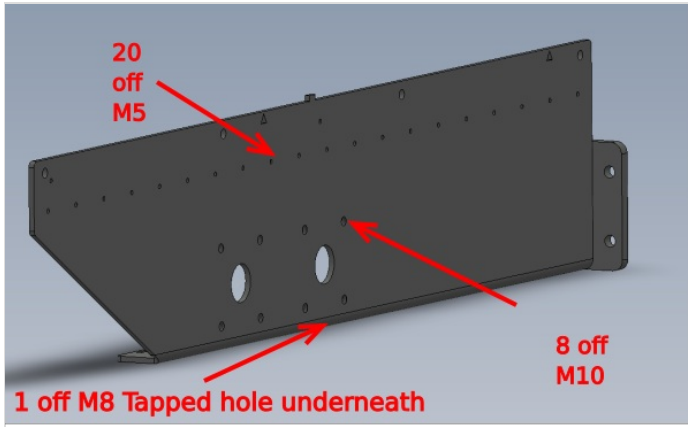
Use Loctite 572 on all threaded pneumatic connections

Pen mark all bolts to show finalised



## Step 2 - Clean all threads

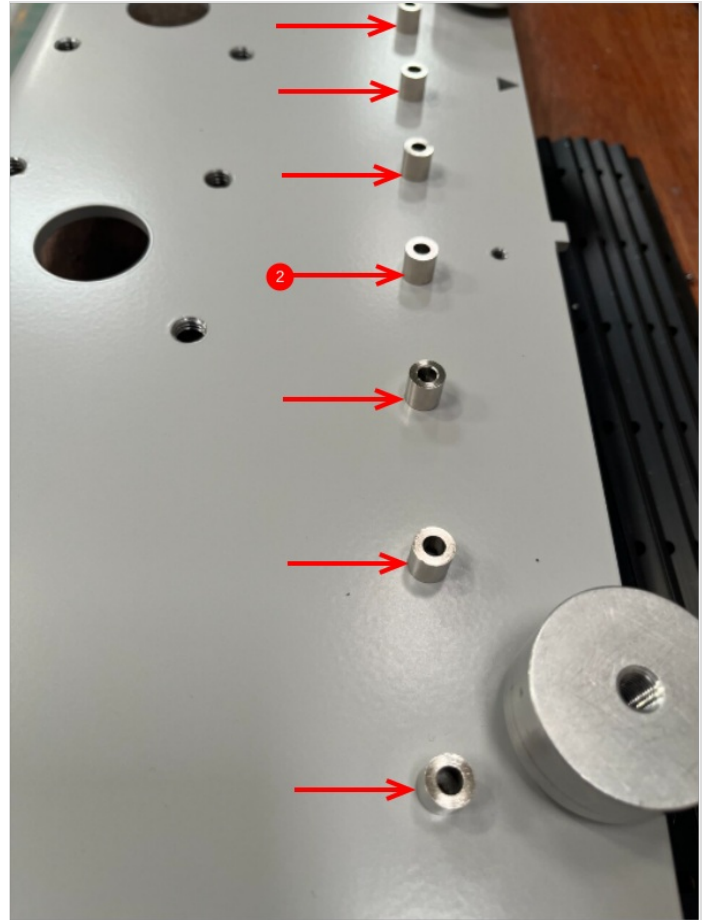
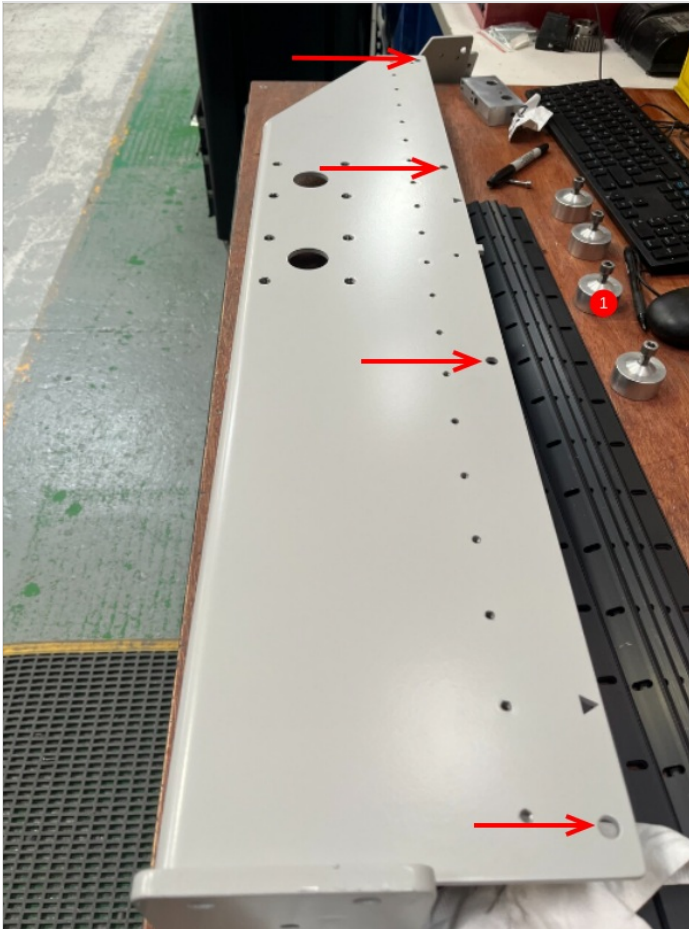
Use Drill on speed one torque 15 and tap to remove debris build up from coating process in all tapped holes in each support arm



## Step 3 - Align spacers and fit setting jigs

1 Mount 4 off setting jigs to arm on the indicated points

2 Align 20 off B0001170 spacers over all m5 holes

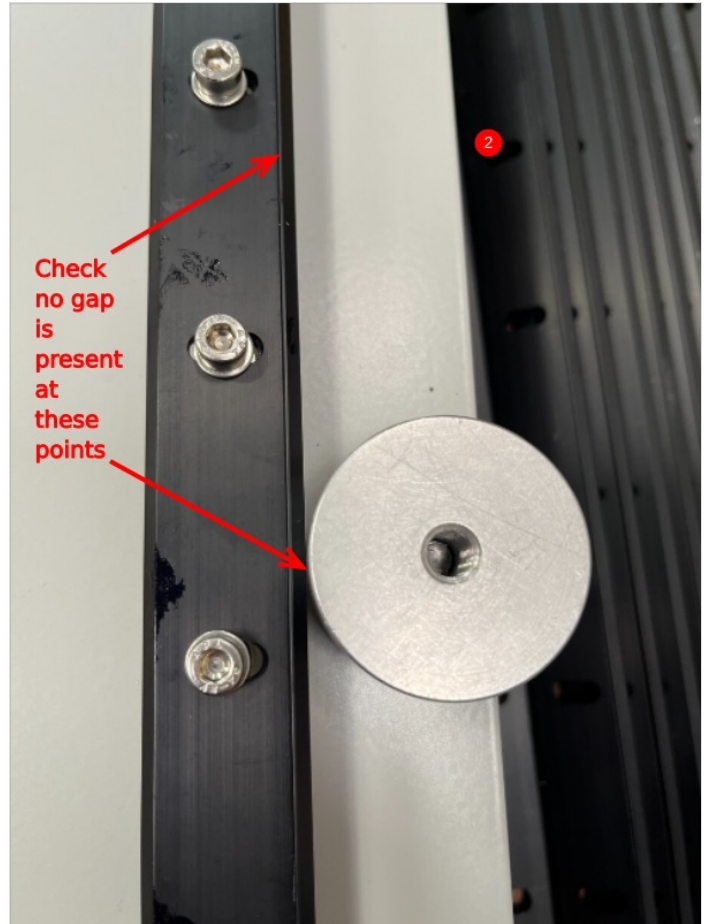
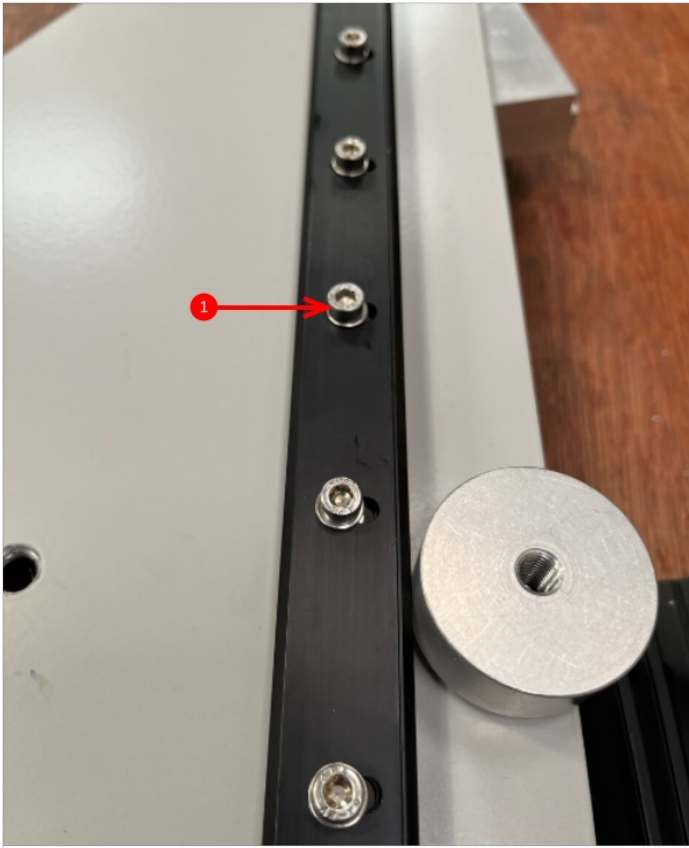


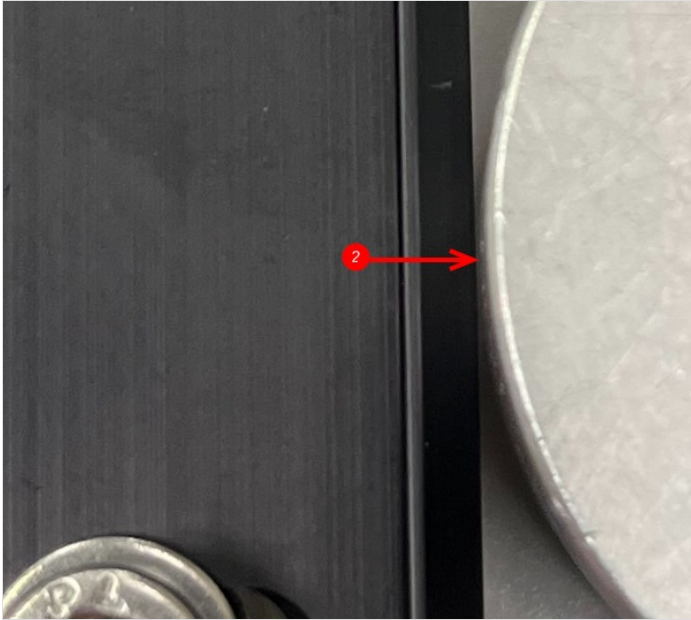
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## Step 4 - Fix Rail to arm

1 Use 20 off M5 x 25 socket caps and A form washer with loctite 243 to fix rail to arm

2 Ensure rail touching setting jig as indicated and two rails are pushed completely together





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## Step 5 - Fit support arm spacers to arms

2 off per arm

Secure with M8 x 20Hex head Set bolt and finalise with Loctite 243 adhesive

Please provide photo

