R0015267 Assemble Backfences, Fit and Align

Alignment requirements and details for Backfence

| 🎛 Difficulty **Medium** | 🕐 Duration **2 hour(s)** |

Contents

Introduction

Step 1 - unless otherwise stated

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Step 3 - Assemble backfences

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Step 6 - Wire line setting

Step 7 - Quality

Comments

Introduction

Tools Required

Standard Hex Key set
Wire Line
150mm Rule

Parts Required

D0015420 M/C Infeed Backfence Plate x 9
D0015468 Infeed Backfence Bracket x 9

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

Step 2 - Ensure mains air is connected to module

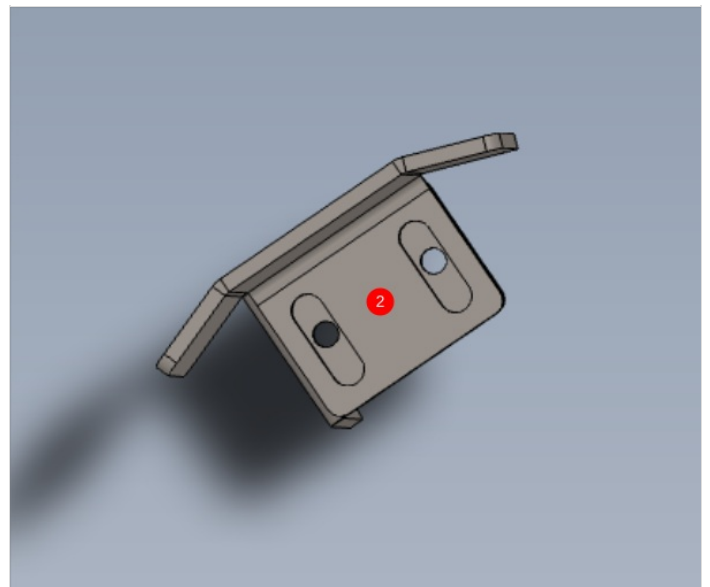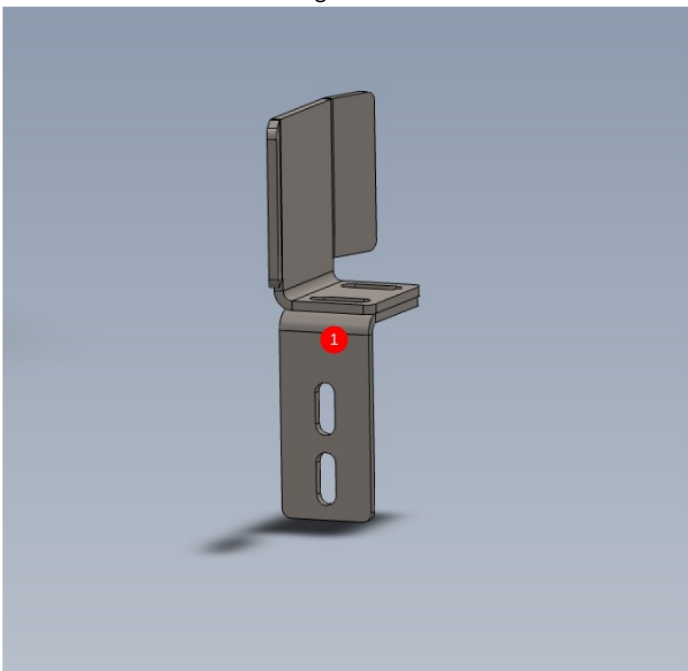Connect mains air to module to allow setting of roller beds

Step 3 - Assemble backfences

1 Mount D0015420 M/C Infeed Backfence Plate to D0015468 Infeed Backfence Bracket as shown

2 position at middle slot as shown

Use 2 off M6 x 12 Socket cap and A form washers to fix parts together

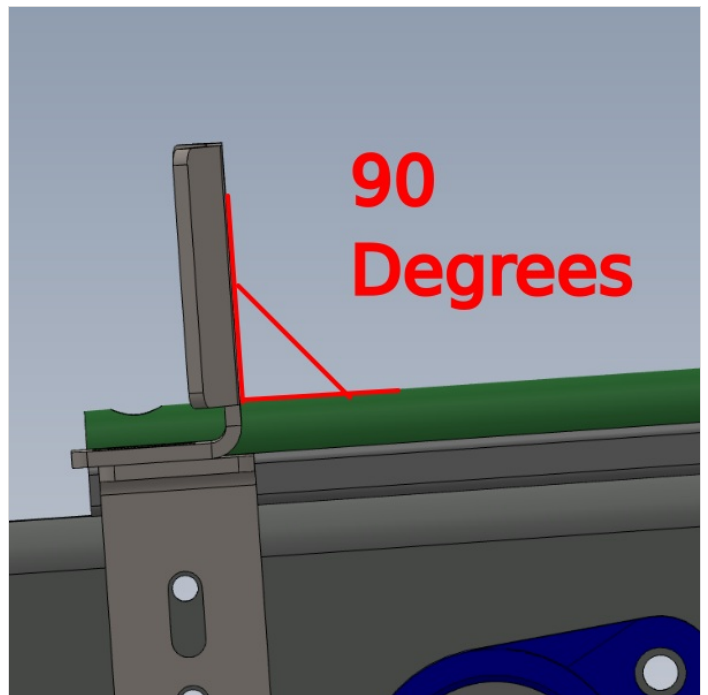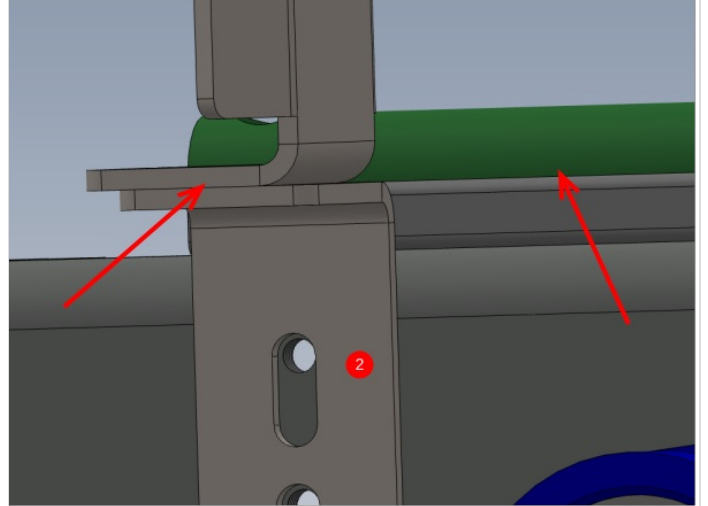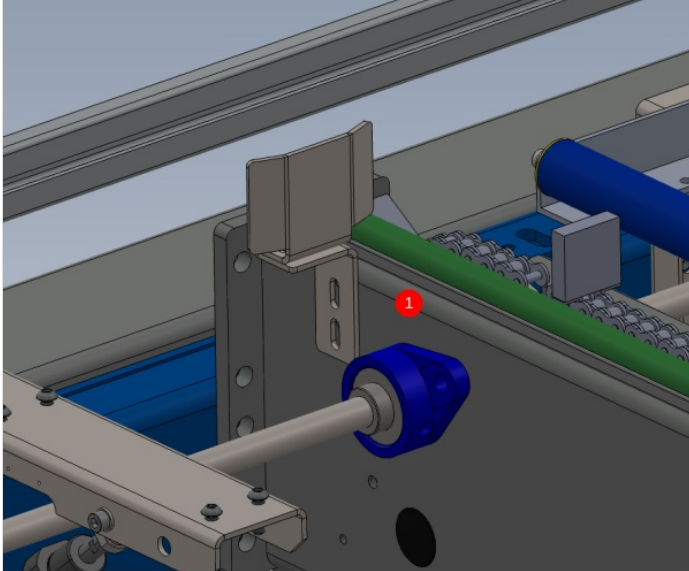Do not add adhesive at this stage

Step 4 - Mount backfences to frame

1 Mount assembled backfences to frame in position shown on each loader arm
(parts removed for clarity)

Use M6 x 16 Socket caps with m6 penny washers to fix
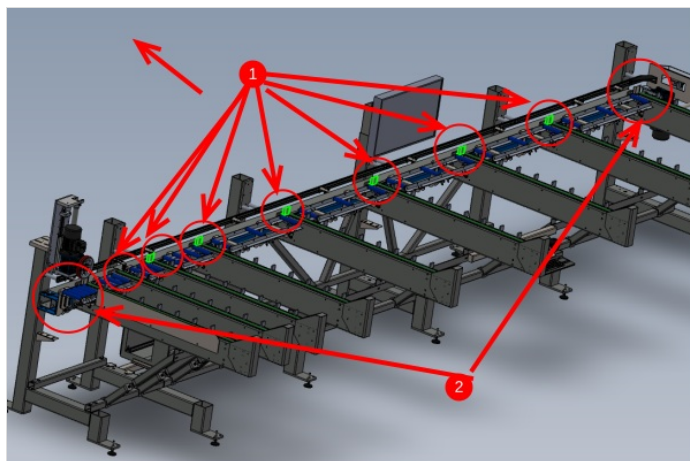
2 Set height to be as shown

3 Ensure back fence is vertical and at 90 degrees to green runner strip

90 Degrees

Step 5 - Retract middle positions of backfences

1 retract indicated backfences in the direction shown to maxuimum movement in slot

2 Check positions shown are middle slot

Step 6 - Wire line setting

Use dokit Alignment guide using wire line for correct process

Set wire line between 1st and last backfence and adjust middle 7 to correct position

Once aligned , add adhesive to all bolts one at a time

Check that no movement occurs when finalising fixings

Step 7 - Quality

Sign off required once alignment is complete