

R0015272 1st Stage fitting Saw Outfeed

Assembly details for 1st stage fitting

 Difficulty **Medium**

 Duration **3 hour(s)**

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Comments

Introduction

Tools Required

Standard Hex key set

Standard HSS Drill Set

Standard spanner set

Standard Tap set

Standard 5mm straight hex key (non ball point)

Hex key extension bar

Parts Required

D0004583 Outfeed Long Rest (5354) x 1

D0004584 Outfeed Side Rest x 4

D0005127 Outfeed Welded Frame (5356) x 1

H0005136 Outfeed Top Tray (5355) x 1

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



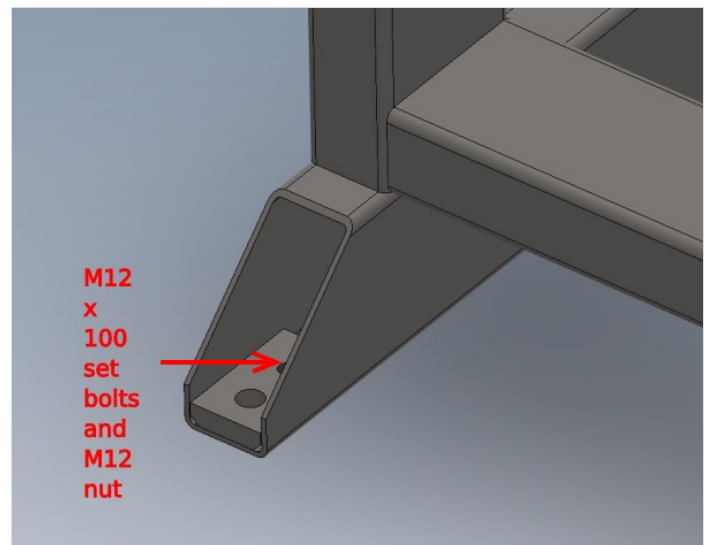
Step 2 - Clean and tap

Use taps to clean all threads present on frame .

Add 4 off m12 x 100 set bolts with M12 nuts and fit to adjusting points

Use 4 off levelling pads (workshop stock) to sit beneath adjustment bolts

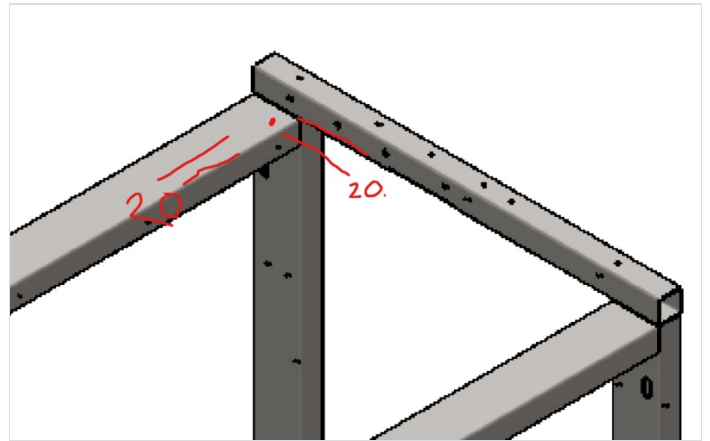
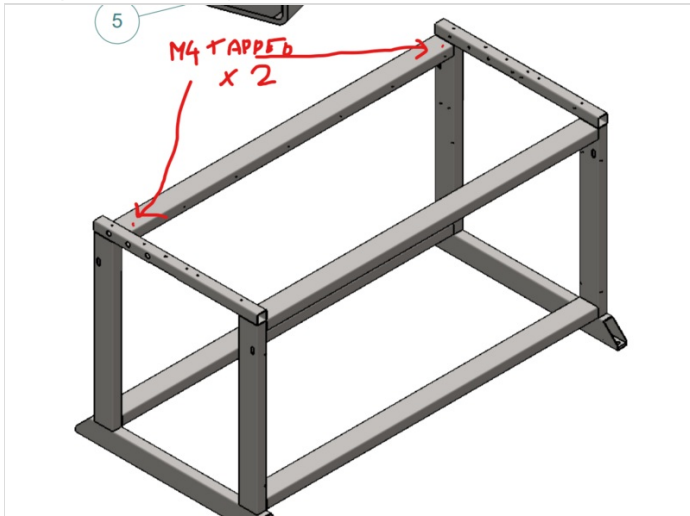
(pictures required please)



Step 3 - Ecr work

Ecr raised 10/10/23 to add 2 off M4 tapped holes to frame.

Until processed add by hand as shown



Step 4 - Check and fit M8 rivnuts

Fit 2 off rivnuts to required mounting points for conveyor .

2 off M8 rivnuts must be installed correctly

1 Face of frame must be countersunk to allow flush fitment and full contact of rivnut shoulder.

2 Rivnuts must be tensioned correctly when installed. If in doubt, please request information from supervisor for the correct fitting of rivnuts.

3 Rivnuts should have a solid fixed into frame and not be able to rotate . To check this, bolt a component to the rivnut and tighten. Then undo fastener and remove component. Rivnut should not move during this process and remain solid



**This is
INCORRECT.
Should be
countersunk**



Step 5 - Mount and check long rest plate

Fit D0004583 Outfeed Long Rest orientated as shown

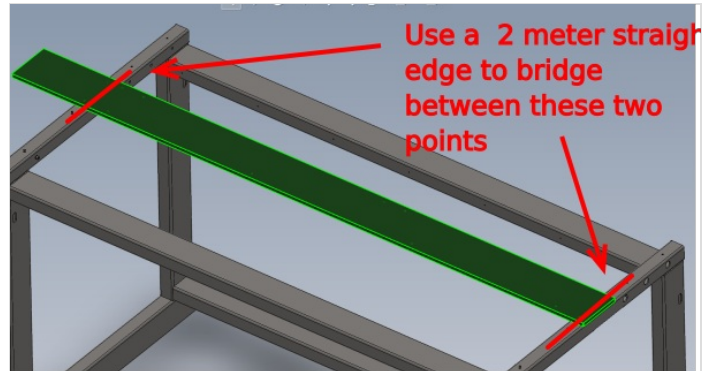
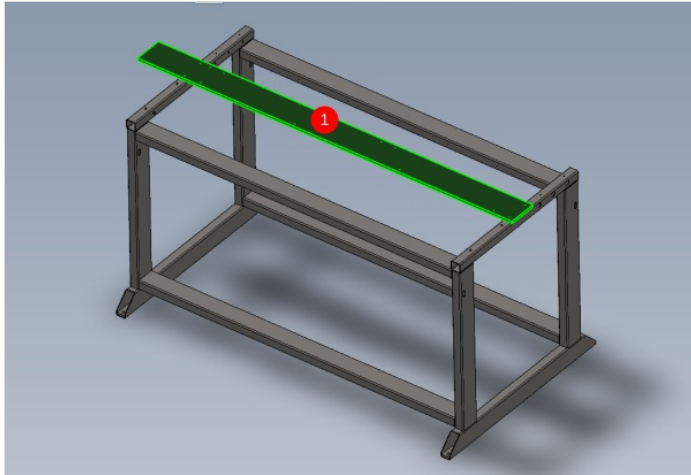
Tap all holes in long rest before fitting. Only use a plug tap to clean threads in long rest

1 Use 4 off M6 x 12 socket caps with M6 A washers and fix to frame

! ...Only use straight hex keys to tension these bolts. Use of a ball ended hex key will result in fastener and tool damage

2 Check flatness with 2 meter straight edge across 2 indicated points.

Straight edge will show a gap in the centre section of the long rest bar



Step 6 - Adjust Outfeed long rest

Shims can be used to adjust the flatness of the long rest plate

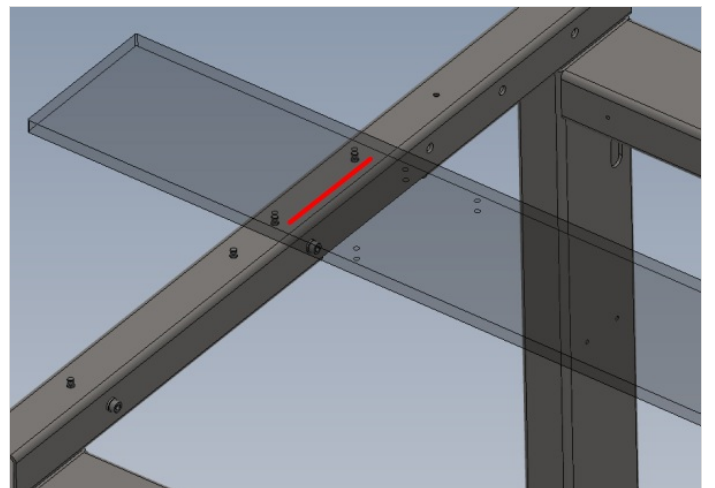
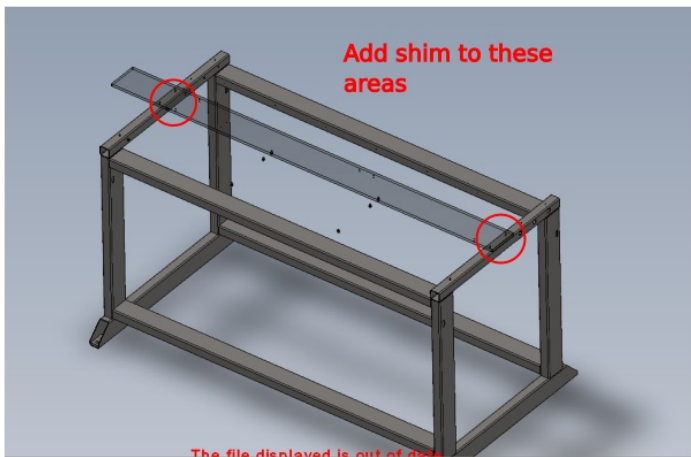
Cut shims to 10mm x 140mm

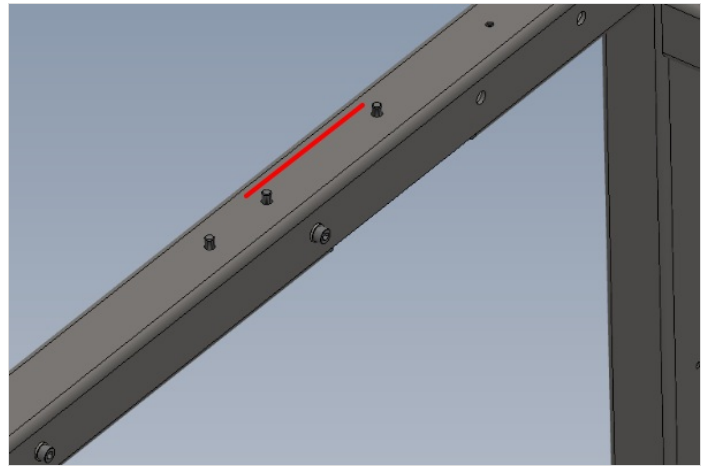
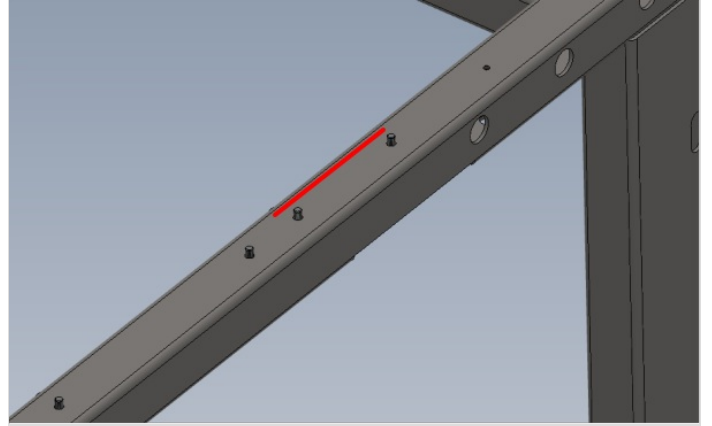
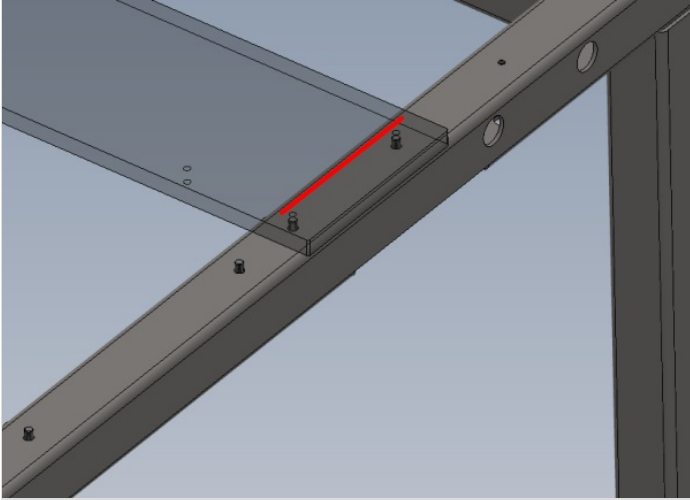
Place at indicated points between frame and long rest bar .

Re tension bolts once shim is added to show true reflection of change made by shim added

Adjust until long rest bar is flat to straight edge

Tolerance + - 1mm



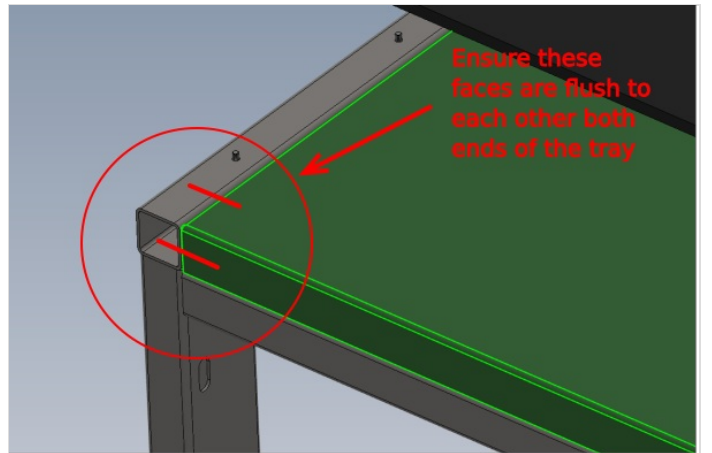
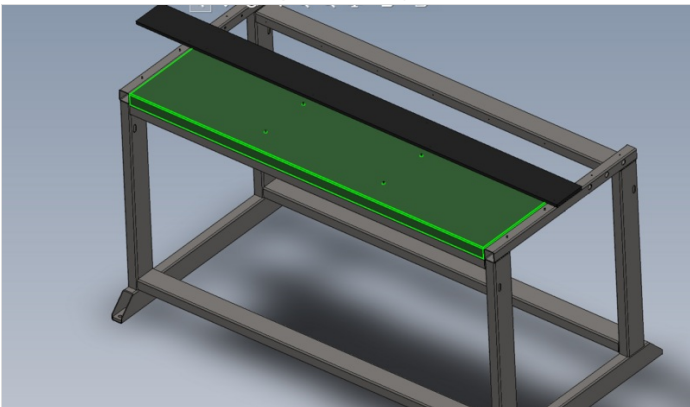


Step 7 - Fit outfeed top tray

Fit H0005136 Outfeed Top Tray as shown

Ensure indicated faces are set flush to frame

Use 8 off M6 x 12 socket caps and heavy M6 washers to fix to frame



Step 8 - Fit side rests

Fit 4 of D0004584 Outfeed Side Rest to positions indicated

When fitting side rests ensure that they are set as shown S

1 Use M6 x 10 socket caps (4 off) to fit indicated arms to frame

2 Use M6 x 12 socket caps and penny washers (4 off) to fit indicated side rests

