


R0015275 Fit shafts and pinions

instructions for installing main drive shafts to support arm assembly

 Difficulty **Medium**

 Duration **2 hour(s)**

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Comments

Introduction

Tools Required

Standard Hex key set

Parts Required

Previously assembled parts from R0015287 Bench Assemble Shafts, Bearings and Pinions

B0001100 x 12

B0001153 x 1

B0001165 x 1

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners

Use Loctite 572 on all threaded pneumatic connections

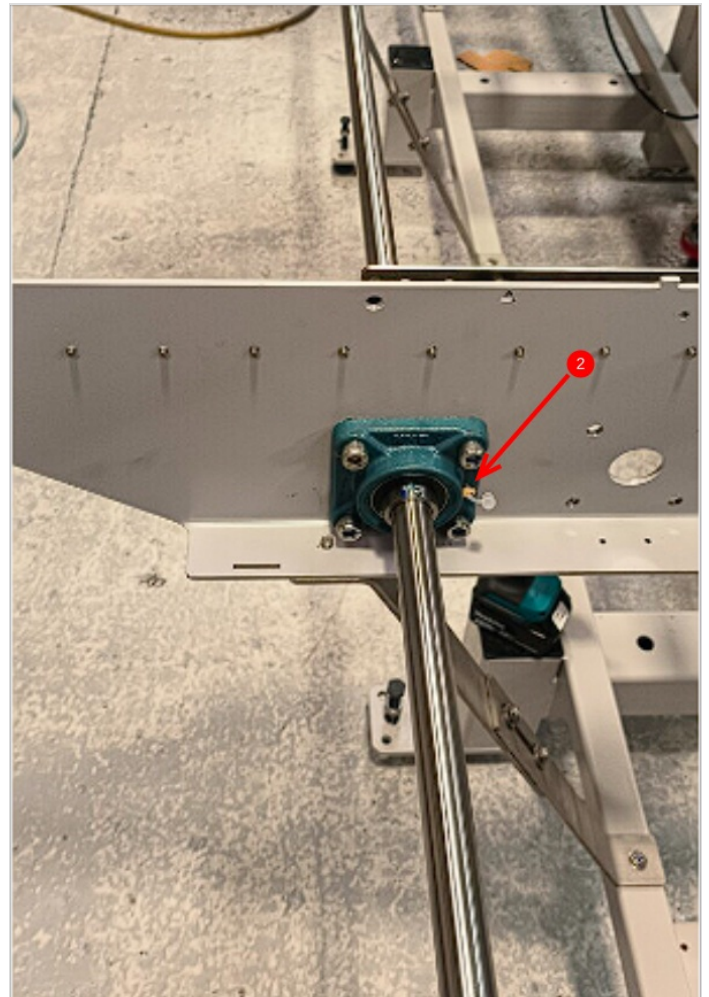
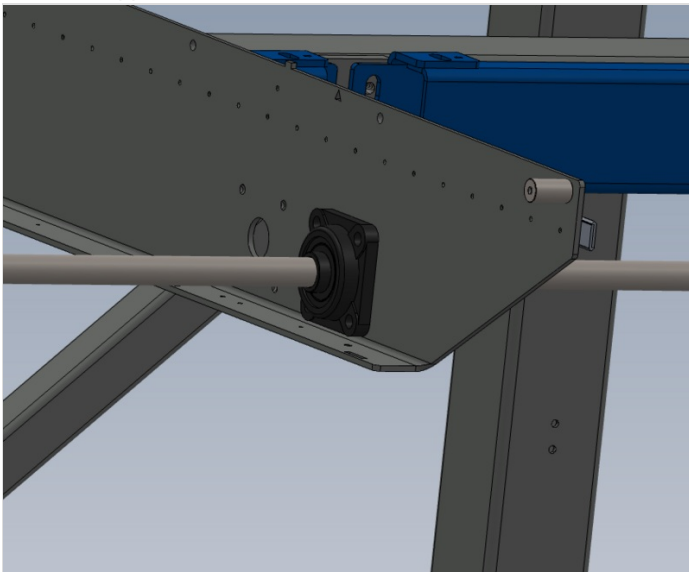
Pen mark all bolts to show finalised



Step 2 - Bearing position Clarification

1 Bearings should be located as shown on each arm

2 Grease nipples to face as shown



Step 3 - Attach Bearings

1 Use 2 off M10 x 40 Countersunk bolts to centralise position of bearing block

2 Add 2 off M10 x 20 socket cap and fix in two holes indicated and tighten.

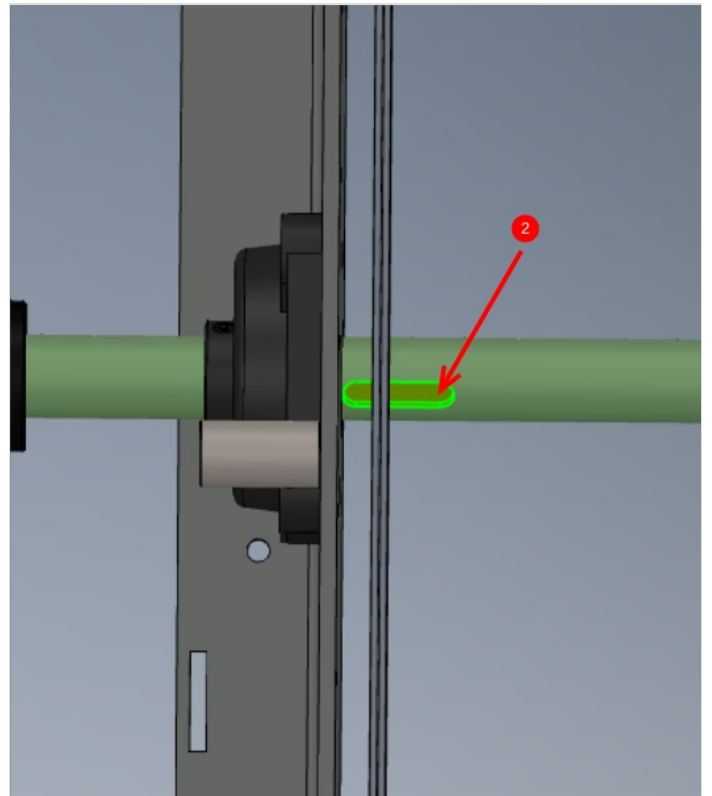
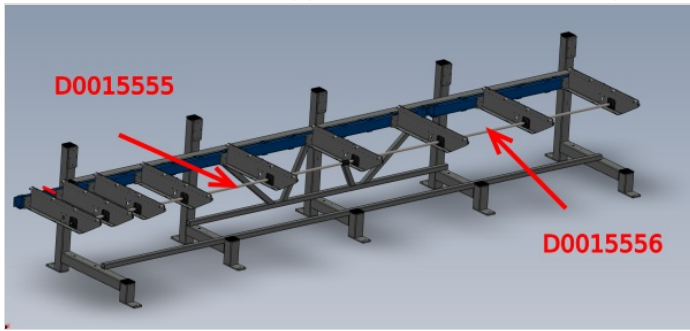
3 Replace M10 counter sunk bolts with another 2 off M10 x 20 socket caps
repeat for all bearing mounting positions



Step 4 - Location of shafts

1 Shafts need to be correctly orientated

2 Each arm should have a key positioned as shown for drive pinions



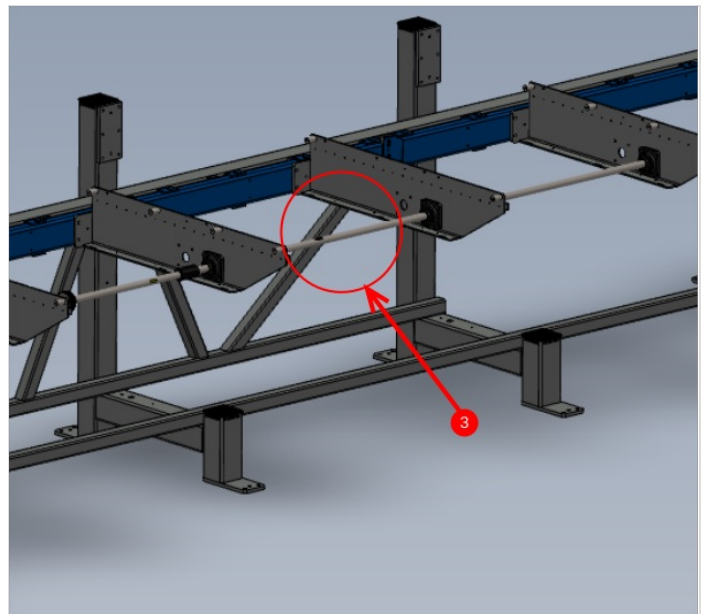
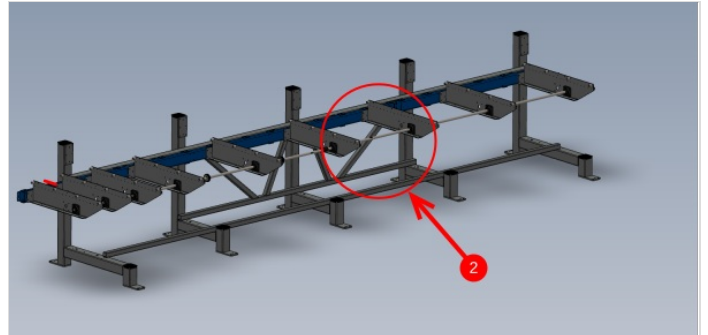
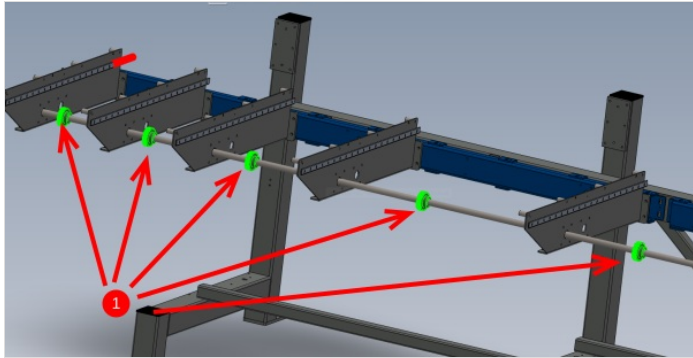
Step 5 - Fit shafts and pinions

Double check for dokit needed on this section. please take photos and gather information please.

- 1 Shafts should be slid through bearing blocks to install. Drive pinions should be added to shaft between each arm as the shaft is fitted.
- 2 B0001165 1 off drive sprocket will also require adding to shaft as they are fitted . See images for location
- 3 B0001165 should be orientated as shown

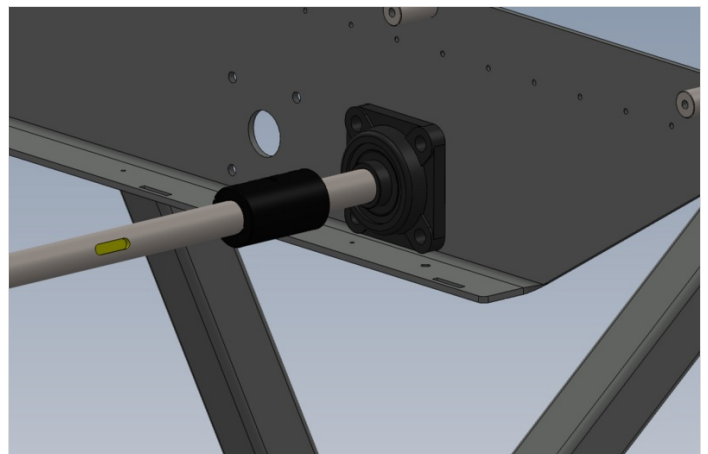


...Do not fix any pinions into position, leave floating on shafts Do not fix any bearing grubscREW lock points



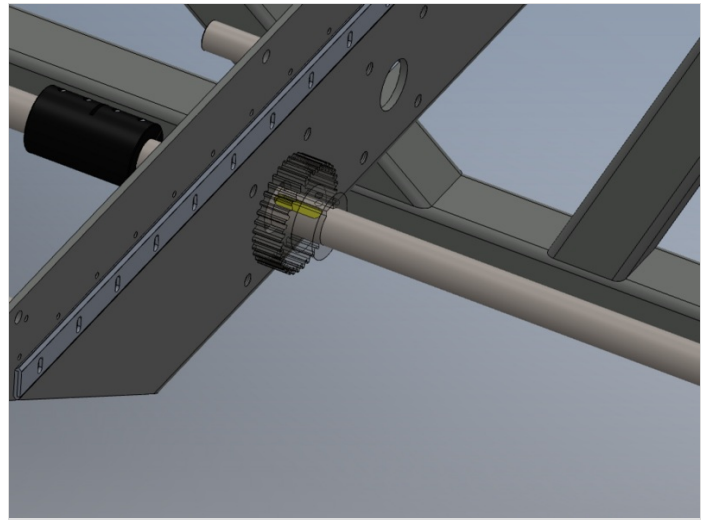
Step 6 - Couple shafts

Couple shafts together with 1 off B0001153 shaft coupler and 2 off B0001100 key



Step 7 - Fit keys

fit 10 off keys to relevant keyways and slide 9 drive pinions and 1 off drive sprockets into approximate positions



Step 8 - Lubrication

all bearings should be lubricated with grease gun and trojan grease

