R0015277 Set Drive pinions in position

Instructions to correctly set drive pinions into positions on shafts

Difficulty **Medium** | Duration **1 hour(s)**

Contents

Introduction

Tools Required

Standard Hex key set

Parts Required

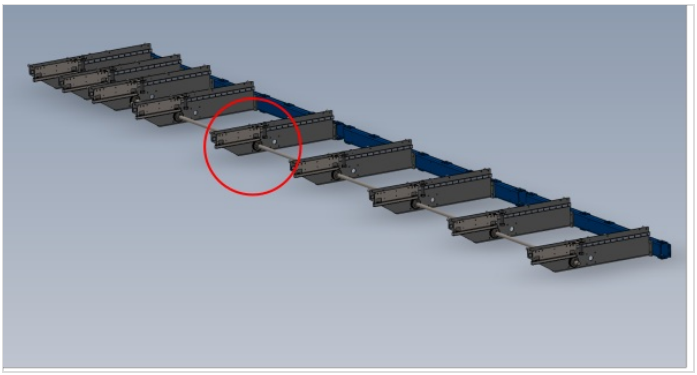
none

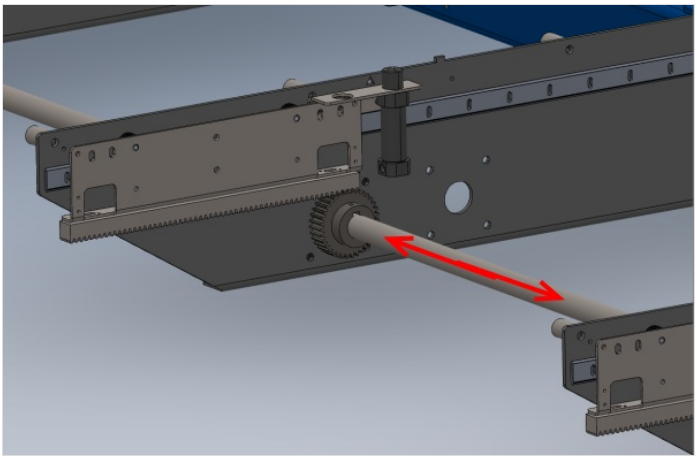
Step 1 - Unless otherwise stated

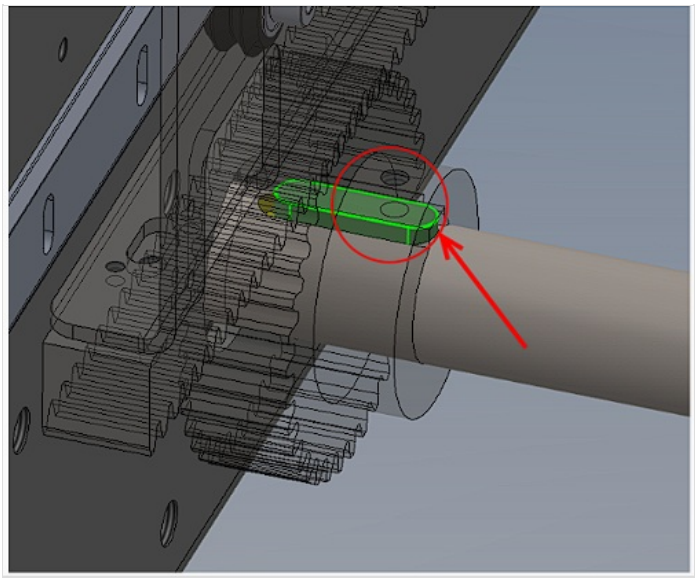
Use Loctite 243 on all fasteners
Use Loctite 572 on all threaded pneumatic connections
Pen mark all fasteners to show finalised

Step 2 - Set shaft position

- The pair of shafts that are joined together can be moved in the directions show to give the optimal contact on keys and drive pinions
- Take all 9 arm positions into consideration and position each shaft accordingly to achieve the best overall position to suit all arms
- Pinion lock points should always be above keyways

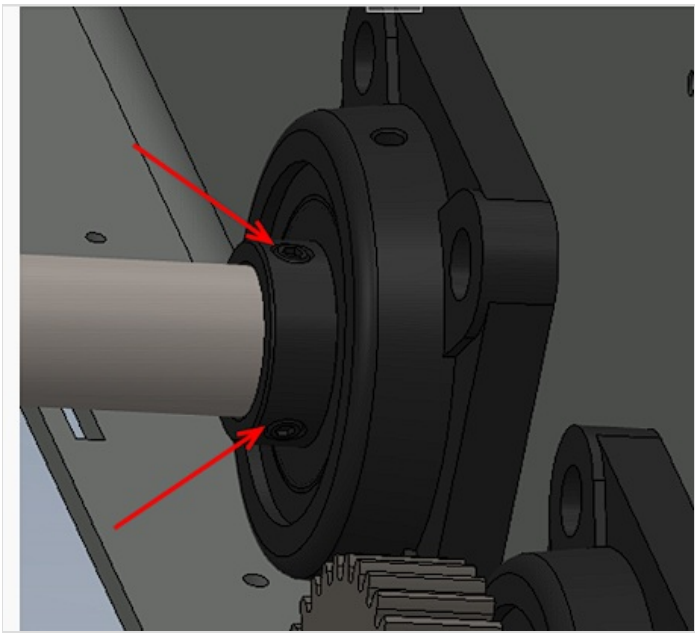






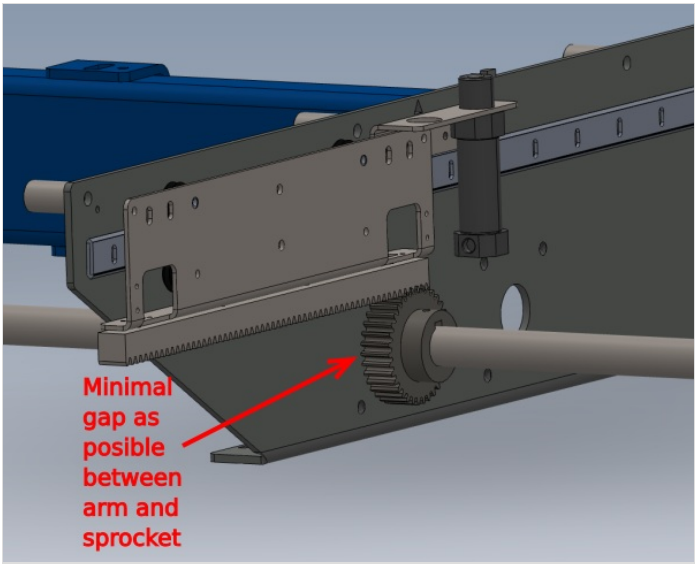
Step 3 - Lock shaft position

Individually remove and apply Loctite 243 to all grubscrews on spherical bearings.
2 off grubscrew per bearing
9 off bearing
18 off grubscrew in total



Step 4 - Set pinion position

9 off pinions can now be set in position and finalised
Set position of pinion to achieve as much contact as possible with drive rail, without contacting side of support arm



Step 5 - Lock Pinion

lock each pinion in position as follows.
M6 x 10 kcp Grubscrew in hole that contacts key on shaft
M6 x 10 flat bottomed grubscrew on fixing hole that contacts directly onto shaft