


# R0015278 Mount Completed Assemblies Section two

Second page of instructions To complete R0015278 assembly mounting

 Difficulty **Medium**

 Duration **1 hour(s)**

## Contents

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Comments

## Introduction

### Tools Required

Standard Hex key set  
Standard spanner set  
300 mm rule  
1000mm rule

### Parts Required

D0008288 Takeup Pad Left (D7339) (Wet/P F Matt) x 1  
D0015583 Take Up Beam Joiner x 1  
D0015598 Datum Flag: Saw Infeed x 1  
D0015717 Energy Chain Angle Bracket Lower x 5  
D0015718 Energy Chain Angle Bracket Upper x 2  
D0015718B Energy Chain Angle Bracket Double Deck x 3  
D0015720 Carriage Bracket x 1  
D0015721 Energy Chain Tray Deep Long x 1  
D0015723 Energy Chain Tray Shallow x 1  
D0015724 Energy Chain Tray Deep x 2  
D0015725 Energy Chain Tray Shallow Medium x 1  
D0015742 Takeup Pad Right ZX5 x 1  
D0015862 Energy Chain Tray Deep Long x 1  
E0000336 Sensor: M8; 2mm, PNP N/O, M8 conn x 1  
R0015011 Bench Assemble Gripper  
R0015063 Bench Assemble Roller Tables  
R0015096 Bench Assemble Transfer Drive Assembly  
R0015101 Bench assembly take up assembly  
R0015286 Bench Assemble X axis components and energy chain

## Step 1 - This is section two

these steps follow on from dokit

R0015278 Mount Completed Assemblies

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## Step 2 - 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 3 - Quality check

Please quality check finish on below channel bars .

Paint work should match on both bars in regards to colour and finish  
(ie matt /gloss)

Report any discrepancy to supervisor

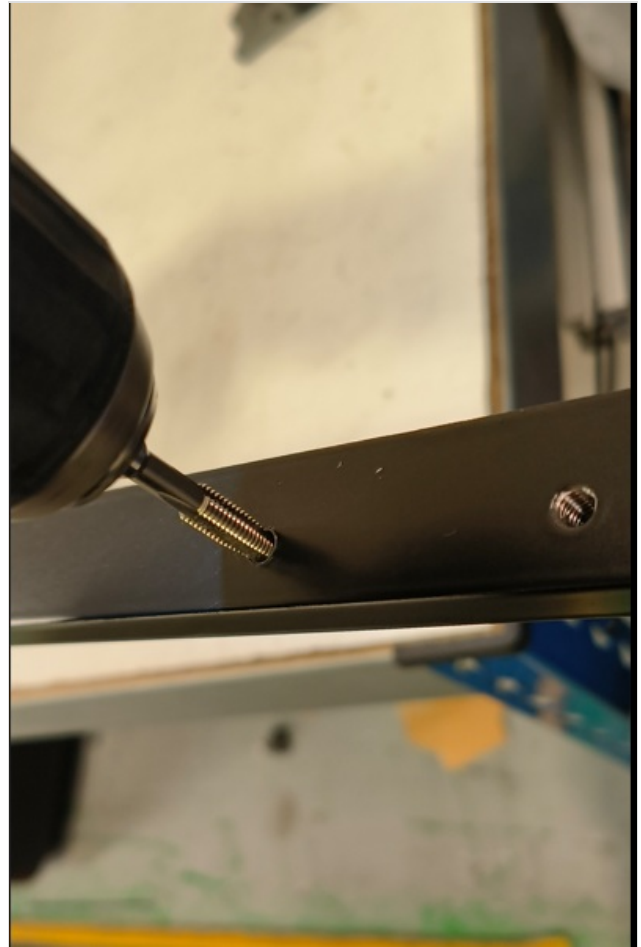
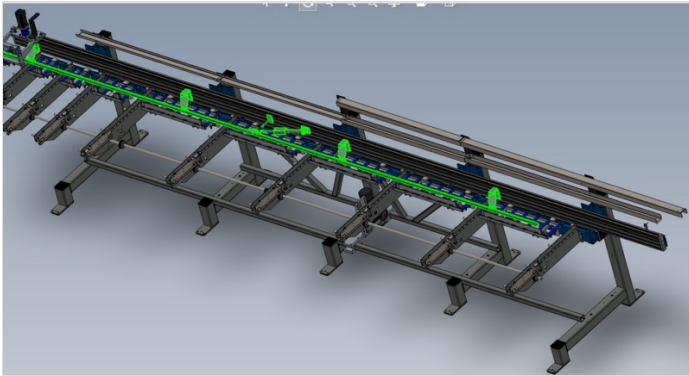


## Step 4 - Clean threads

Clean threads in parts

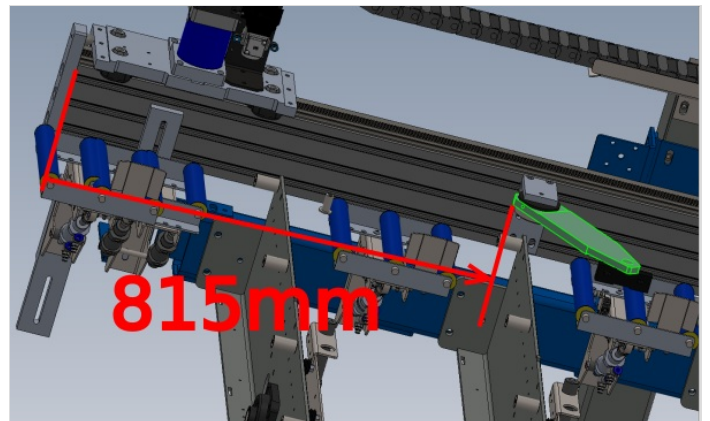
D0015742 Takeup Pad Right ZX5 x 1

D0008288 Takeup Pad Left (D7339) (Wet/P F Matt) x 1



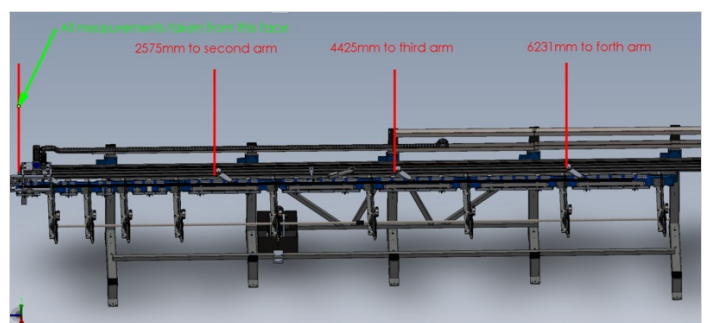
## Step 5 - Mount 1st take up arm

Use 4 off F0000299 M6 d nuts and 4 off M6 x 20 socket caps and M6 penny washers to mount takeup arm at position shown



## Step 6 - Mount 2nd,3rd and 4th arms

Mount remaining 3 take up arms as shown using fasteners stated in previous step



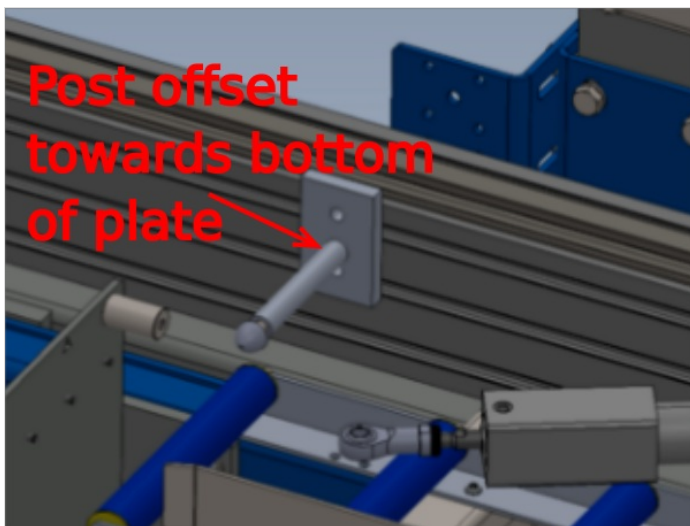
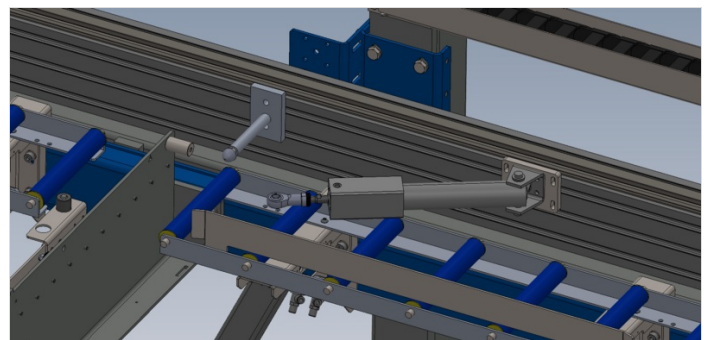
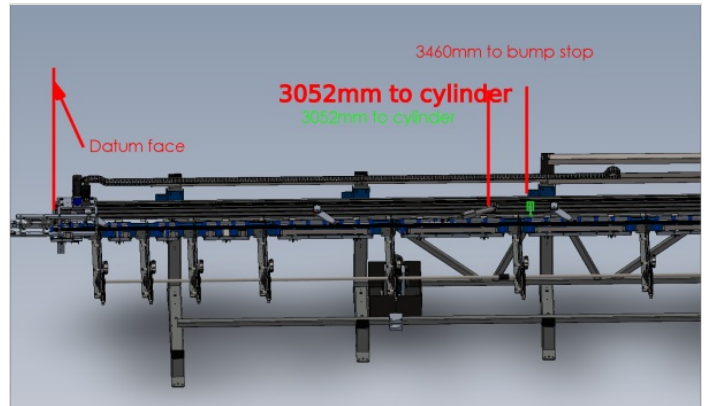
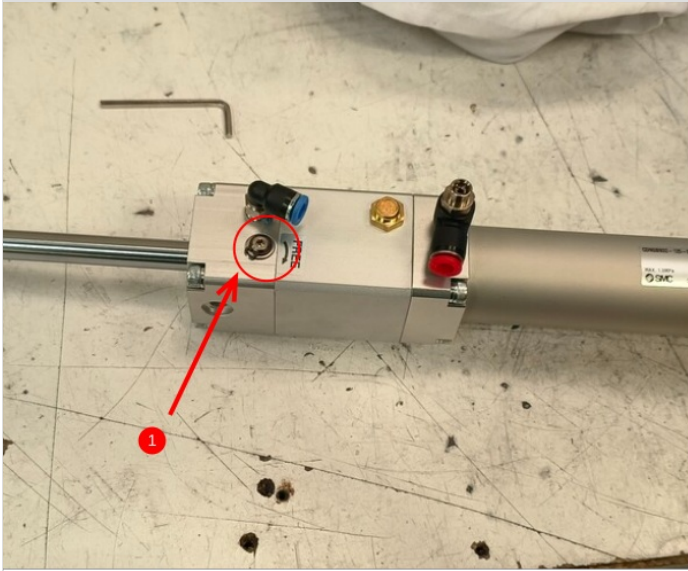
## Step 7 - Mount cylinder assembly and hard stop

**⚠** ...Ensure hard stop is fitted in correct orientation as strike post is offset on mounting plate. See picture for correct orientation

1 Over ride lock function so piston on cylinder can move freely

2 Mount cylinder in position shown . Do Not apply adhesive to these fasteners yet .  
use M6 x 20 socket caps and penny washers to secure cylinder assembly

3 Mount hard stop as shown using M6 x 20 socket caps and 20mm diameter washers at top position , Bottom position uses M6 x 20 socket caps and A form washers



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## Step 8 - Note

Black take up pads D0008288 and D0015742 are not fitted at this point .

These will be fitted at a later stage of build

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