



R0015305A Install Wiring loom for Rotary Ring

Installation of wiring loom and captivating spindle bases

 Difficulty **Hard**

 Duration **3 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set

Ball pein hammer

6mm drift/punch

Drill driver

6mm hex drill attachment

Parts Required

D00000291 spindle plate x 8

M0000025 Ident numbers x 1

D0007703 r stop pin x 1

D0007990 cylinder anchor x 1

D0007777 Trunking backplate x 2

Step 1 - Quality

All bolts to have Loctite 243 adhesive applied unless otherwise stated

All bolts to be pen marked once adhesive applied and correct tension added



Step 2 - Quality Check

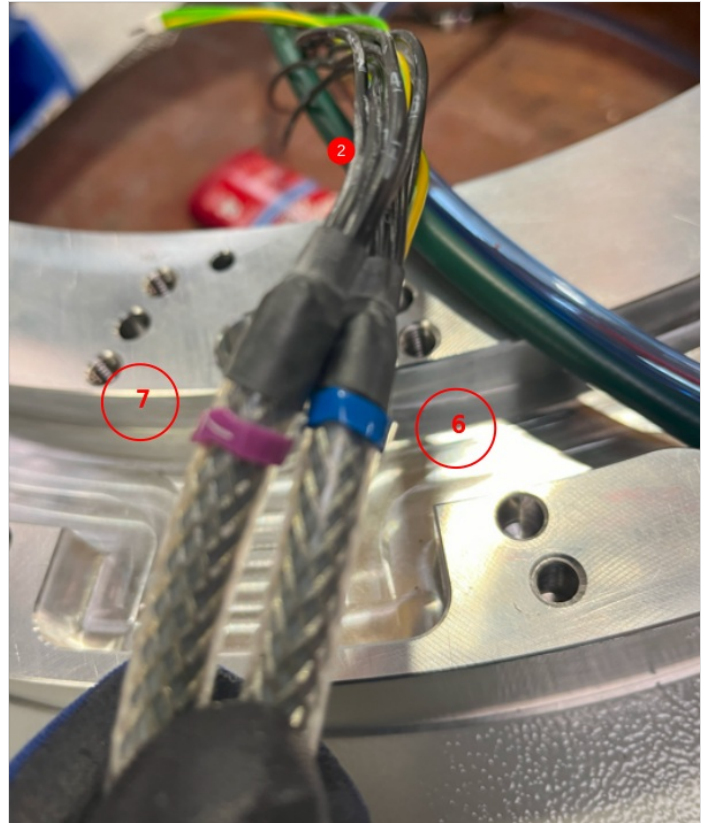
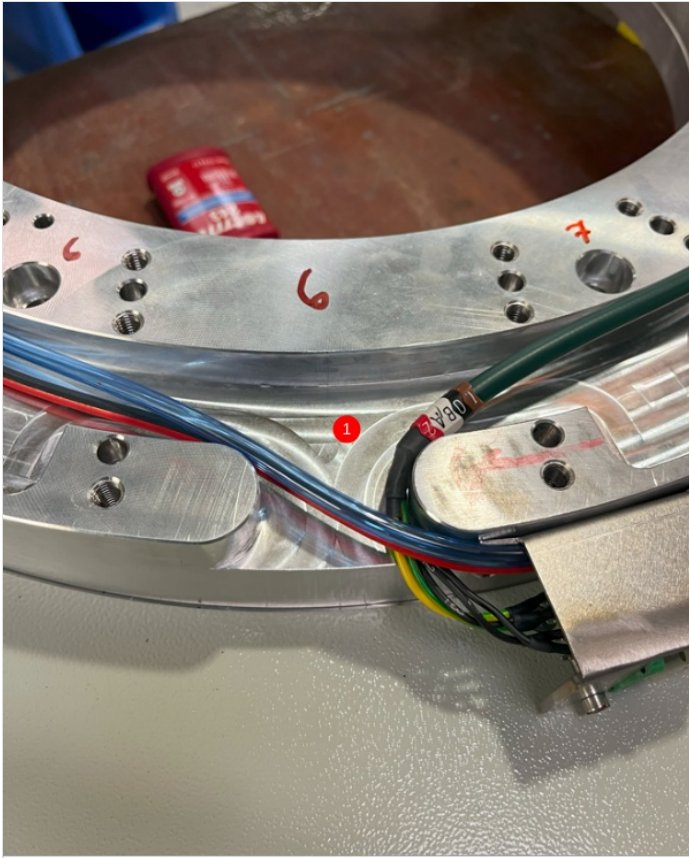
Check D0000291 spindle base has M4 hole tapped all the way through the plate. Rework if not

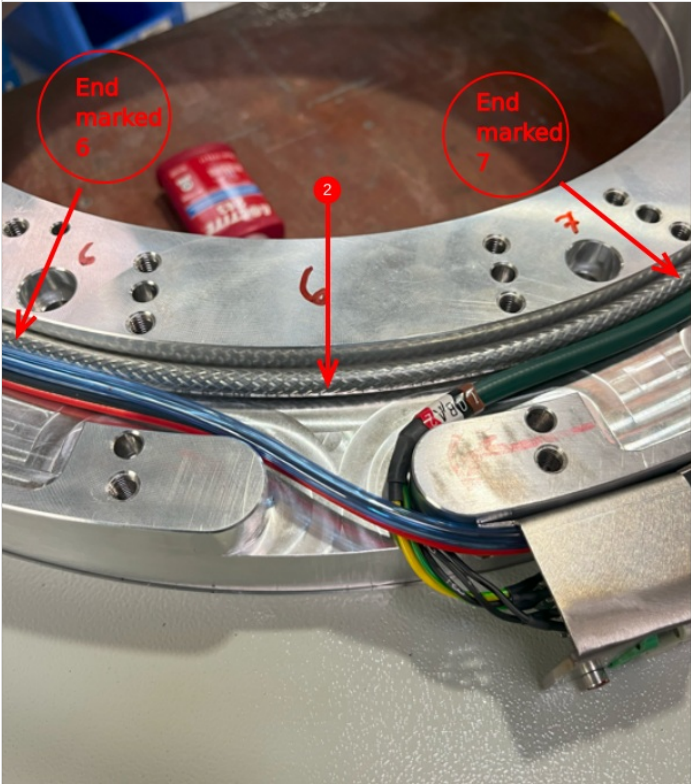


Step 3 - Start Wiring loom installation

1 Segregate cables and 6mm blue pipe as shown

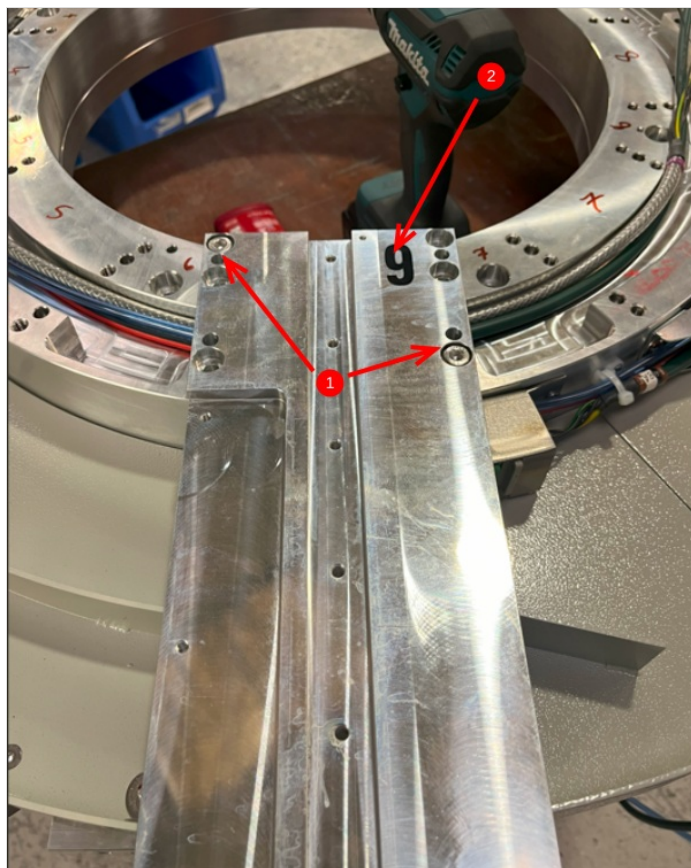
2 Use pre made cable identified as 6 and 7 and lay between 2 points shown





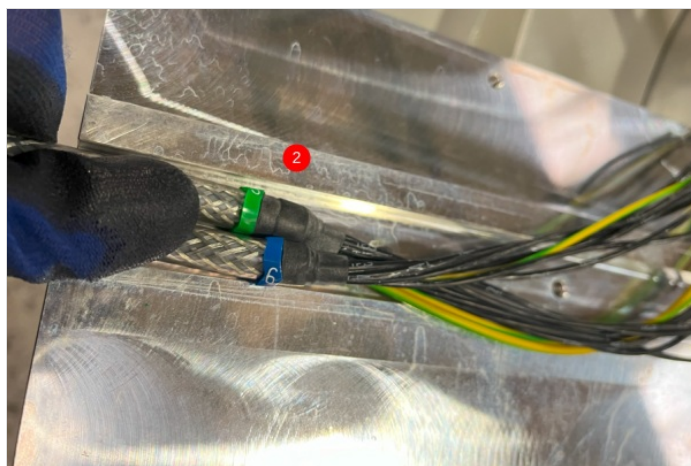
Step 4 - Fit spindle plate 6

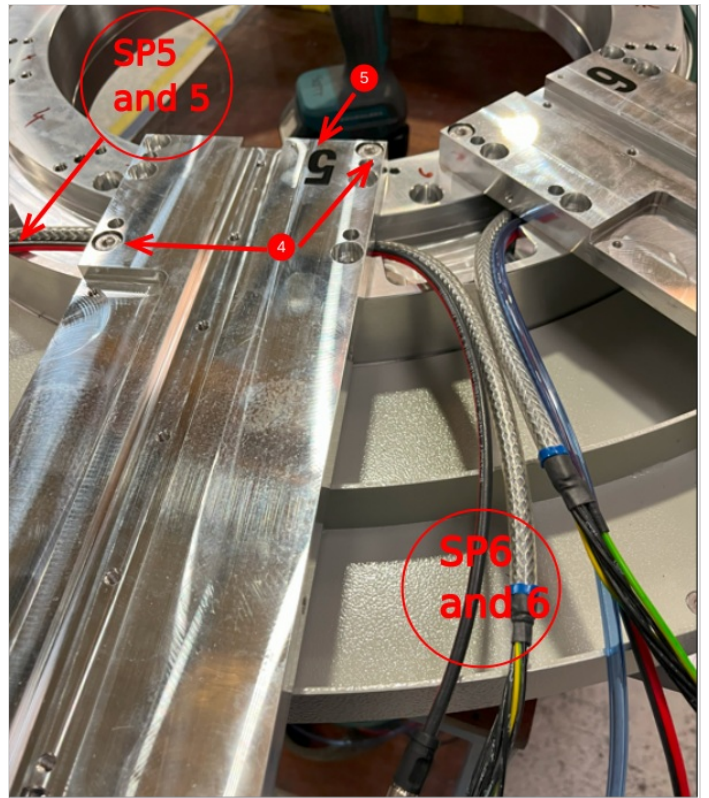
- 1 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps in opposing corners
- 2 Fit M0000025 number ident (number 6)



Step 5 - Fit Spindle plate 5

- 1 Retrieve pre marked ethercat cable marked SP5-SP6
- 2 Retrieve pre marked power cable marked 5-6
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP5 and 5 exit to left
Ensure SP6 and 6 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 5)

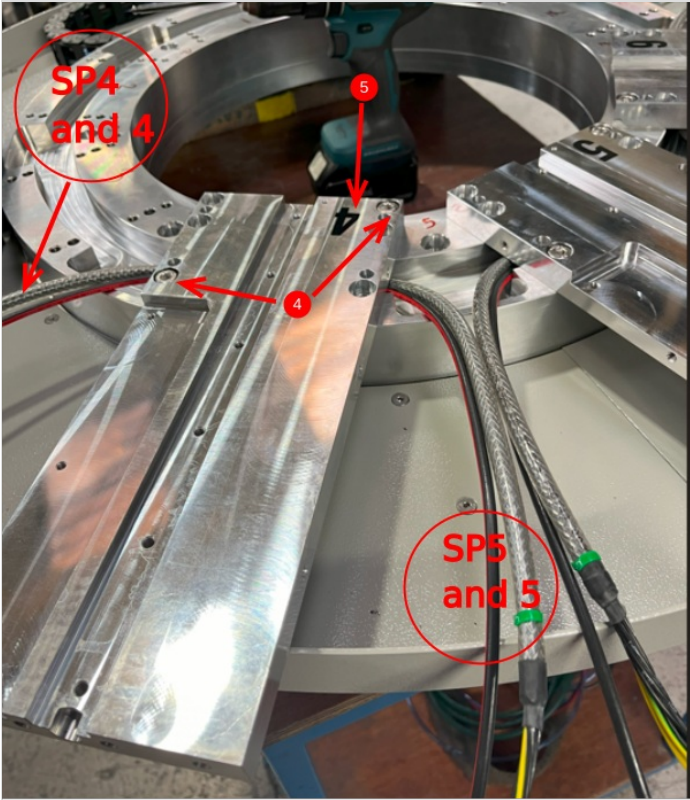




Step 6 - Fit Spindle plate 4

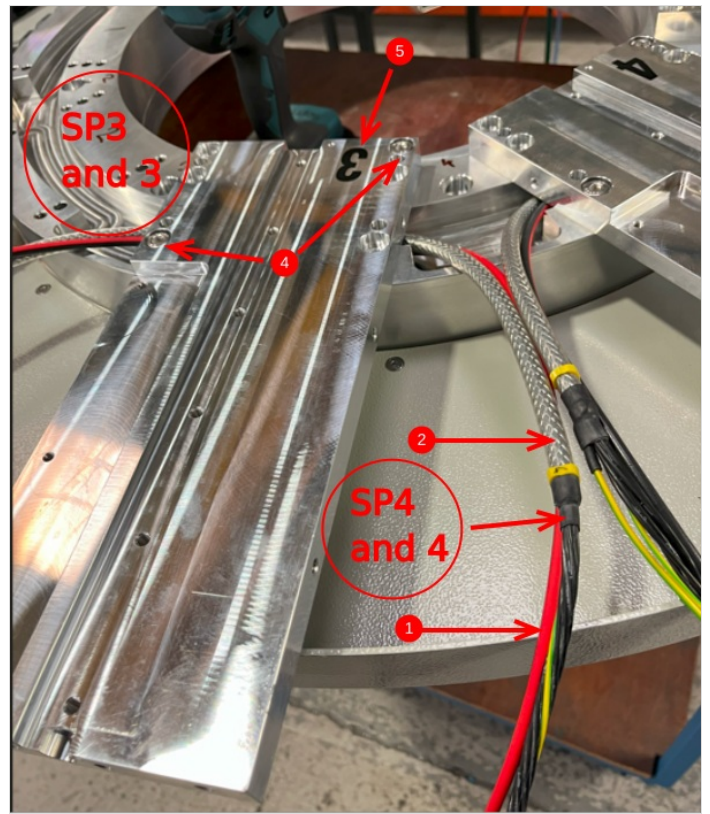
- 1 Retrieve pre marked ethercat cable marked SP4-SP5
- 2 Retrieve pre marked power cable marked 4-5
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP4 and 4 exit to left
Ensure SP5 and 5 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 4)





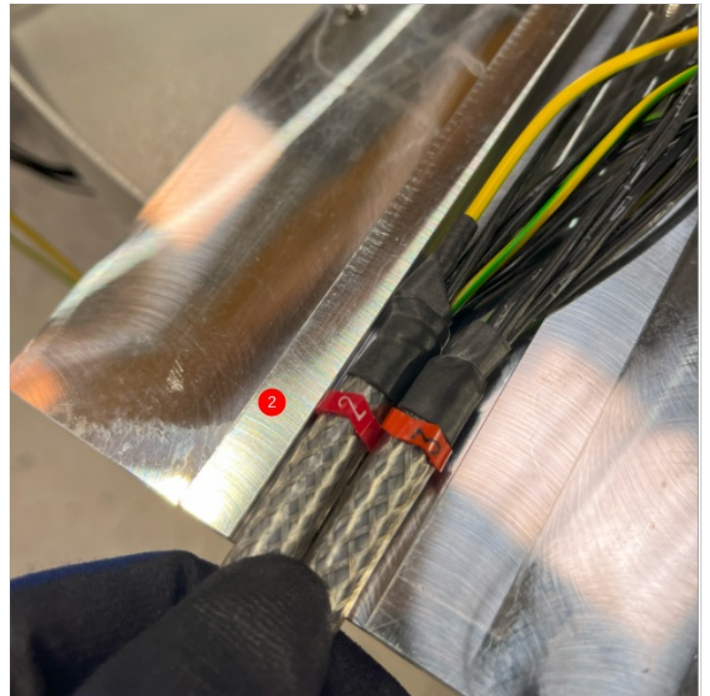
Step 7 - Fit Spindle plate 3

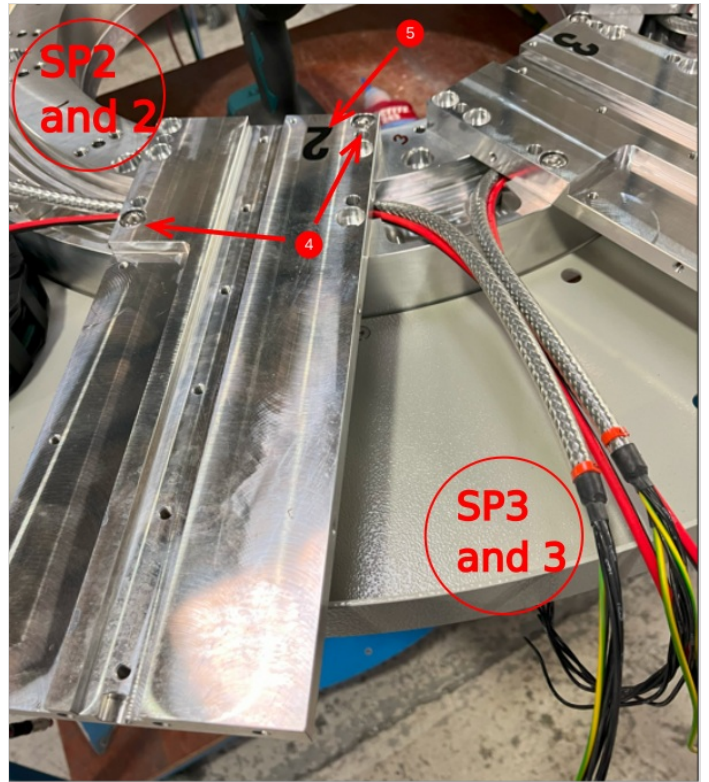
- 1 Retrieve pre marked ethercat cable marked SP3-SP4
- 2 Retrieve pre marked power cable marked 3-4
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP3 and 3 exit to left
Ensure SP4 and 4 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 3)



Step 8 - Fit Spindle plate 2

- 1 Retrieve pre marked ethercat cable marked SP2-SP3
- 2 Retrieve pre marked power cable marked 2-3
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP2 and 2 exit to left
Ensure SP3 and 3 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 2)

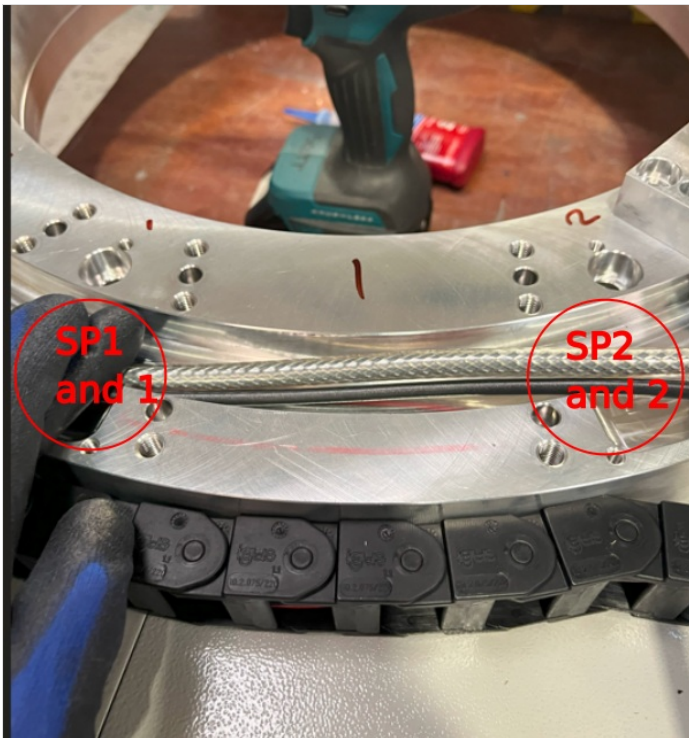




Step 9 - Fit Spindle plate 1

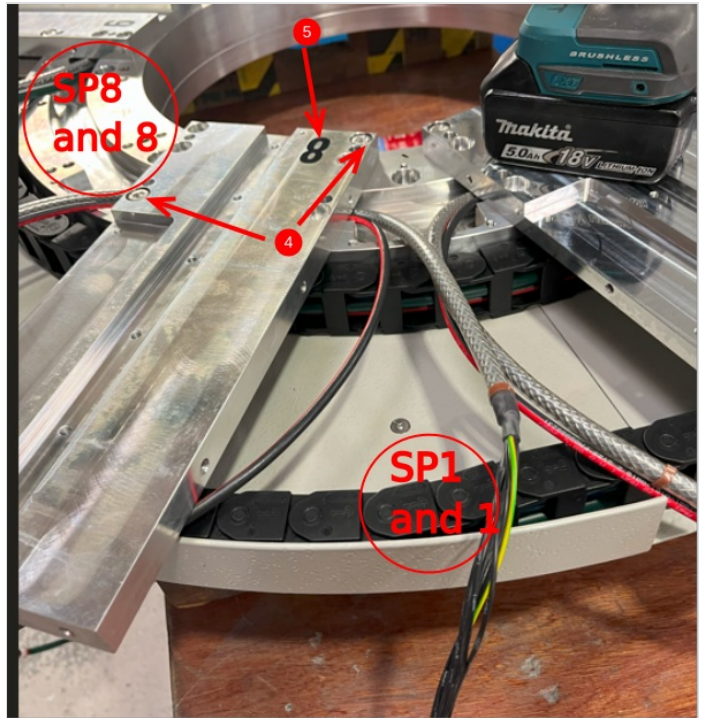
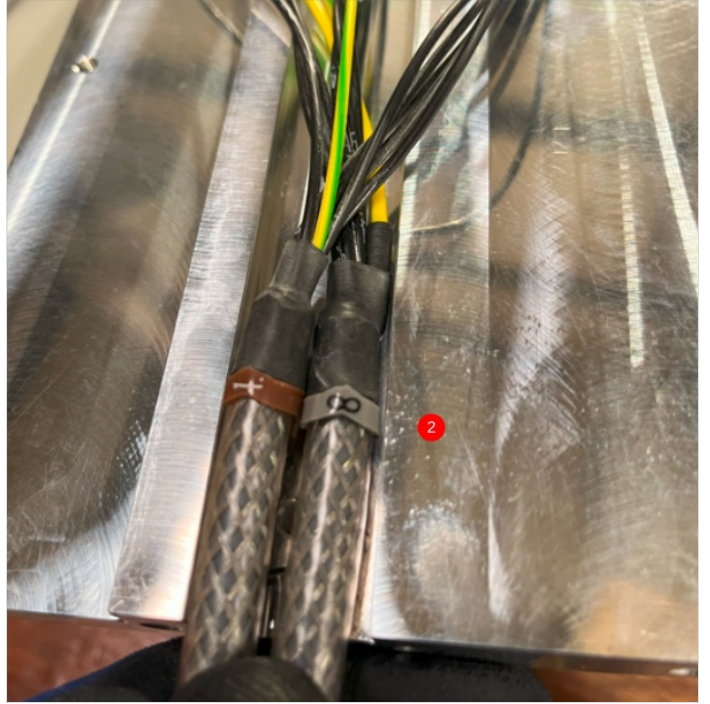
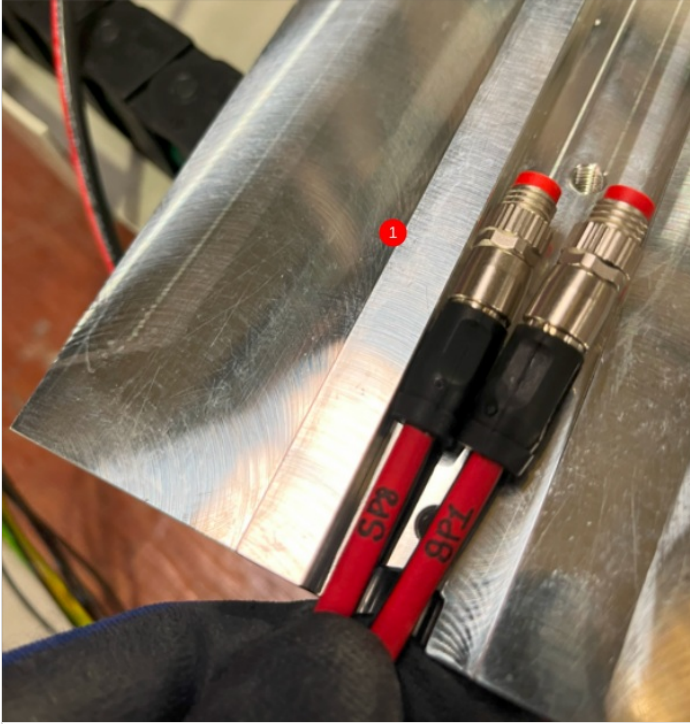
- 1 Retrieve pre marked ethercat cable marked SP1-SP2
- 2 Retrieve pre marked power cable marked 1-2
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP1 and 1 exit to left
Ensure SP2 and 2 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 1)





Step 10 - Fit Spindle plate 8

- 1 Retrieve pre marked ethercat cable marked SP8-SP1
- 2 Retrieve pre marked power cable marked 8-1
- 3 Lay both cables into chamber to the left of previous fitted plate
Ensure SP8 and 8 exit to left
Ensure SP1 and 1 exit to the right
- 4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps
- 5 Fit M0000025 ident number to spindle plate (number 8)



Step 11 - Fit Spindle plate 7

1 Retrieve pre marked ethercat cable marked SP7-SP8

2 Retrieve pre marked power cable marked 7-8

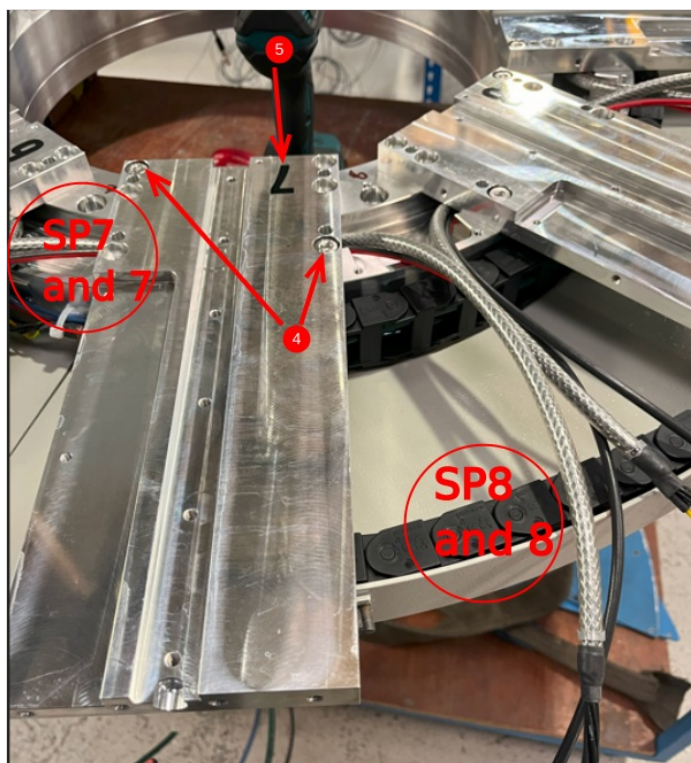
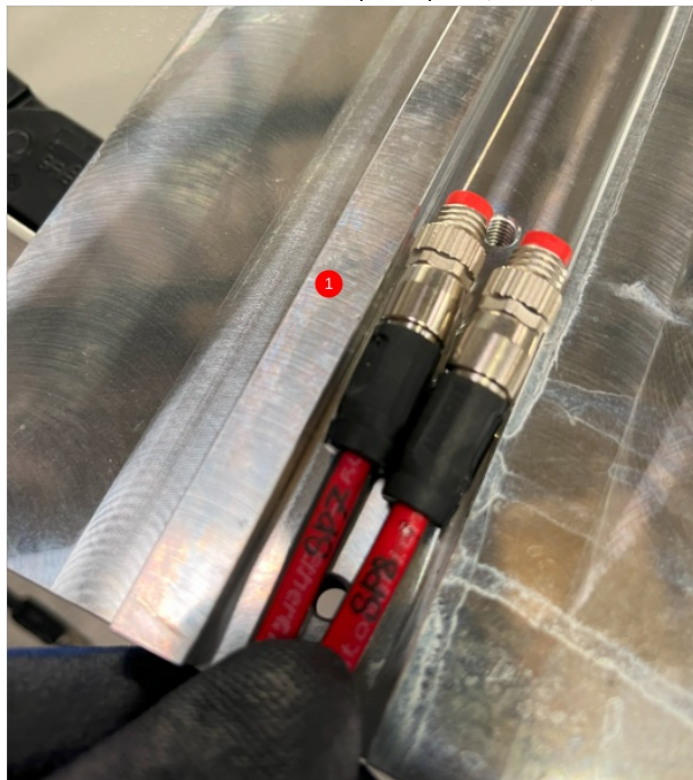
3 Lay both cables into chamber to the left of previous fitted plate

Ensure SP7 and 7 exit to left

Ensure SP8 and 8 exit to the right

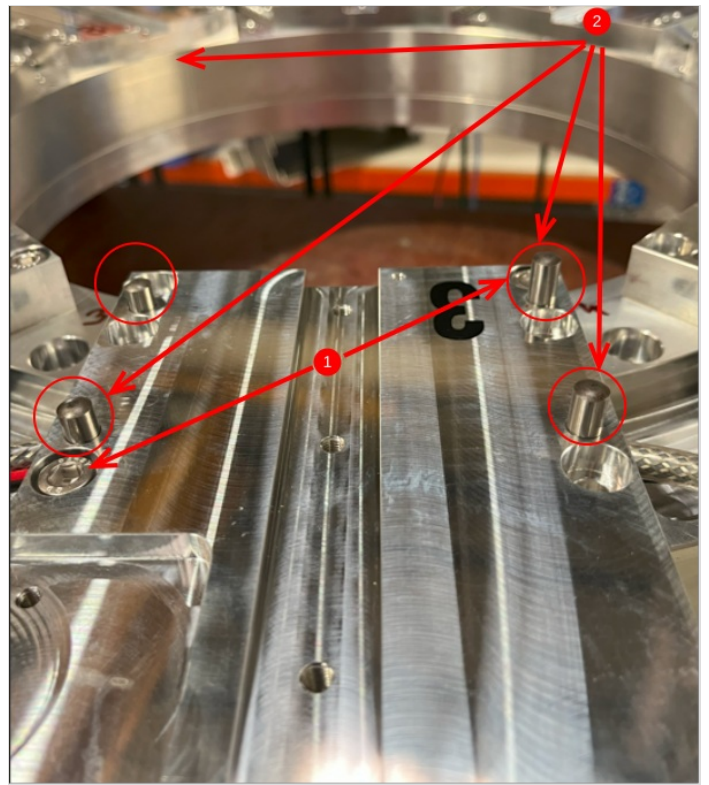
4 Fit D0000291 spindle plate and lightly secure with 2 off M8 x 25 socket caps

5 Fit M0000025 ident number to spindle plate (number 7)



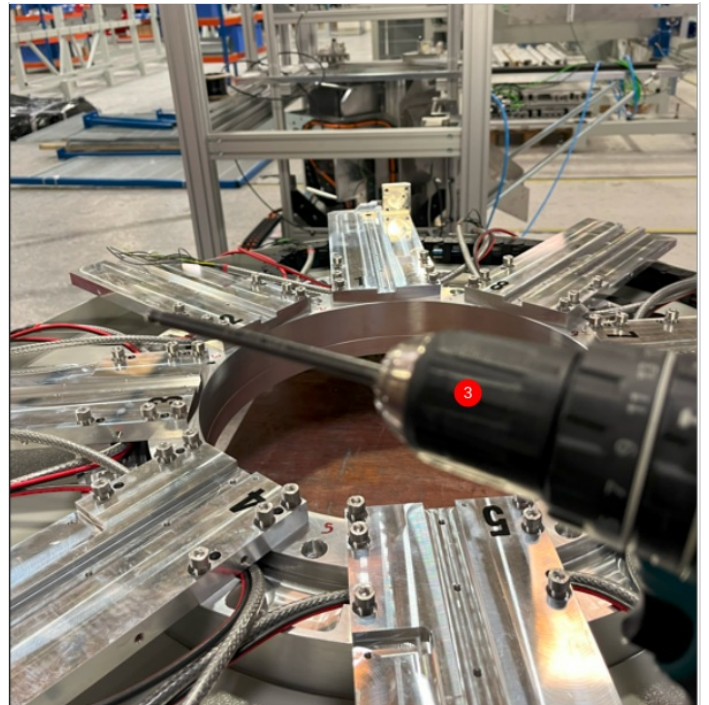
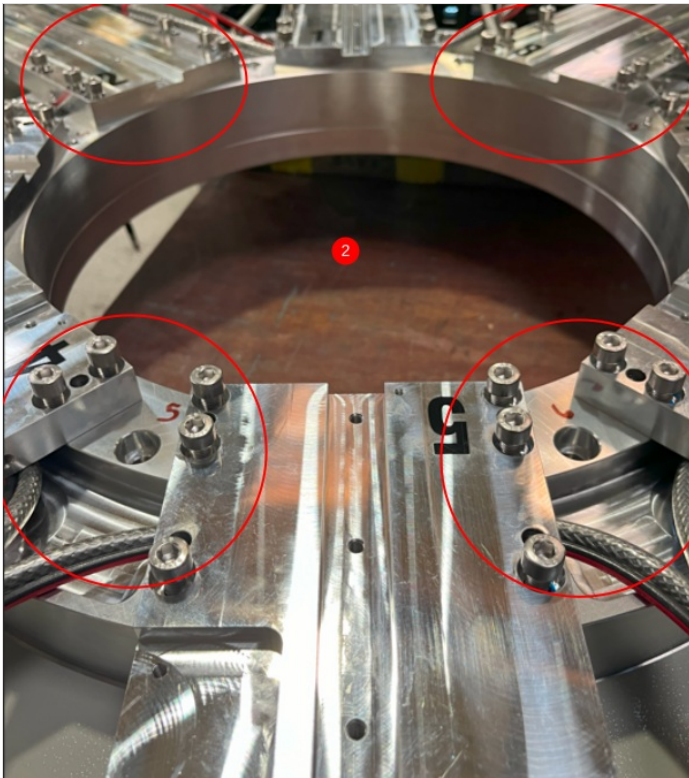
Step 12 - Fit dowels to spindle plates

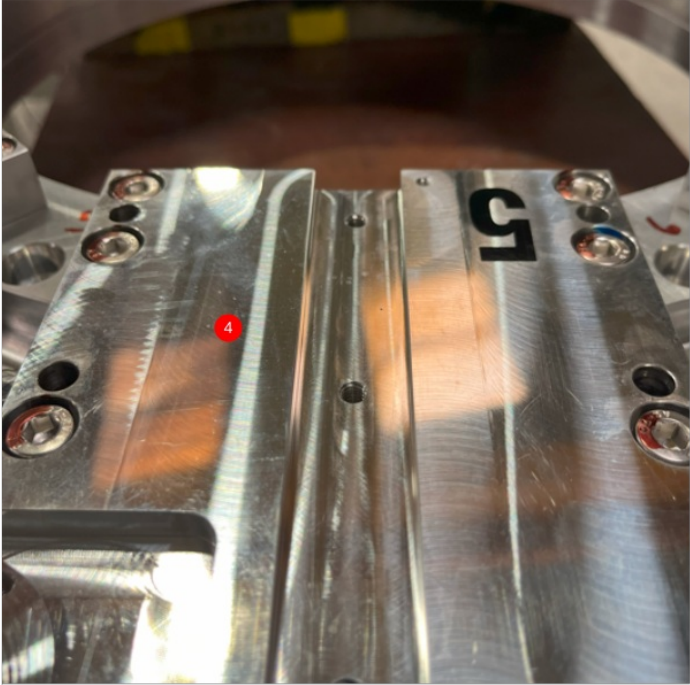
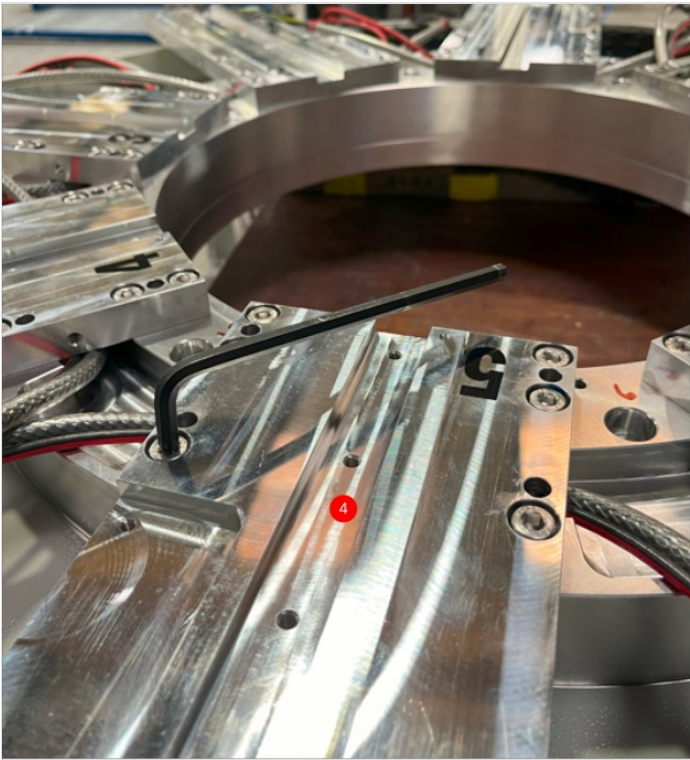
- 1 Ensure 2 off M8 x 25 sockets are only lightly tensioned. When fitting dowels spindle plates will need to move slightly to allow alignment to occur
- 2 Fit 4 off F0000042 8mm x 24mm dowel to each spindle plate. Start all 4 dowels into bores indicated , but do not drive flush
- 3 Use punch pin to drive dowels to approximately 10mm below spindle plate face



Step 13 - Add final fasteners

- 1 Remove 2 off M8 x 25 socket cap fitted to each spindle plate
- 2 Fit 6 off M8 x 25 socket cap with adhesive to each spindle plate , do not wind bolt into thread
- 3 Use drill driver (torque setting 15) with 6mm hex attachment to drive all fasteners home
- 4 Finalise M8x25 socket caps by hand , and mark as completed





Step 14 - Add anti drift marks

Each dowel hole (4 off per spindle plate, 32 in total) require anti drift dots adding to stop dowel slip in operation.

Use a centre punch and hammer, and add centre dot as indicated to slightly swage over top of dowel hole.

Repeat this for all dowel holes on spindle plates



Step 15 - Prepare back plates

Prepare 2 off D0007777 trunking back plates for fitting

Check that a M5 countersunk bolt fits flush in all fixing holes.

If M5 countersunk sits above face, rework with Countersink to allow correct fitment



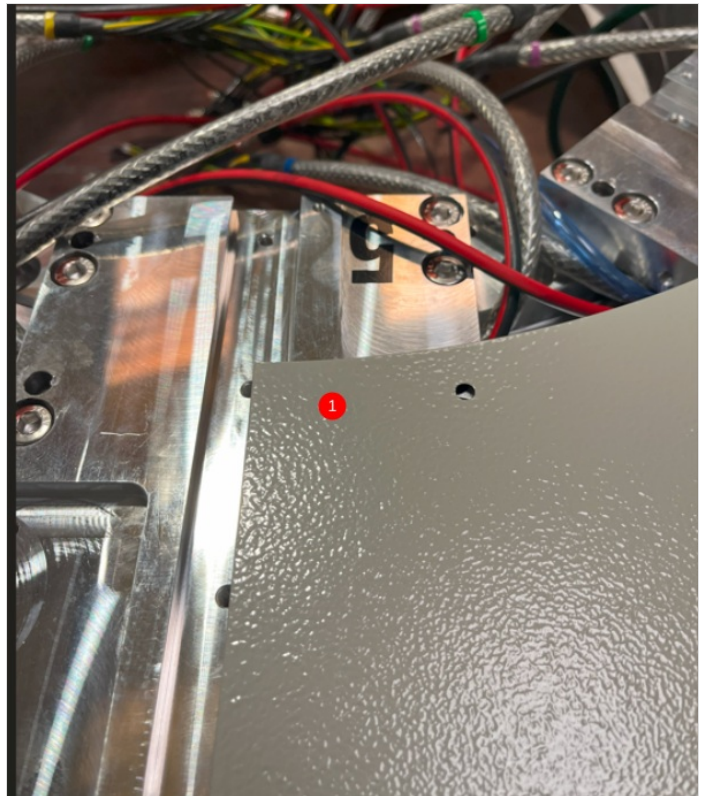
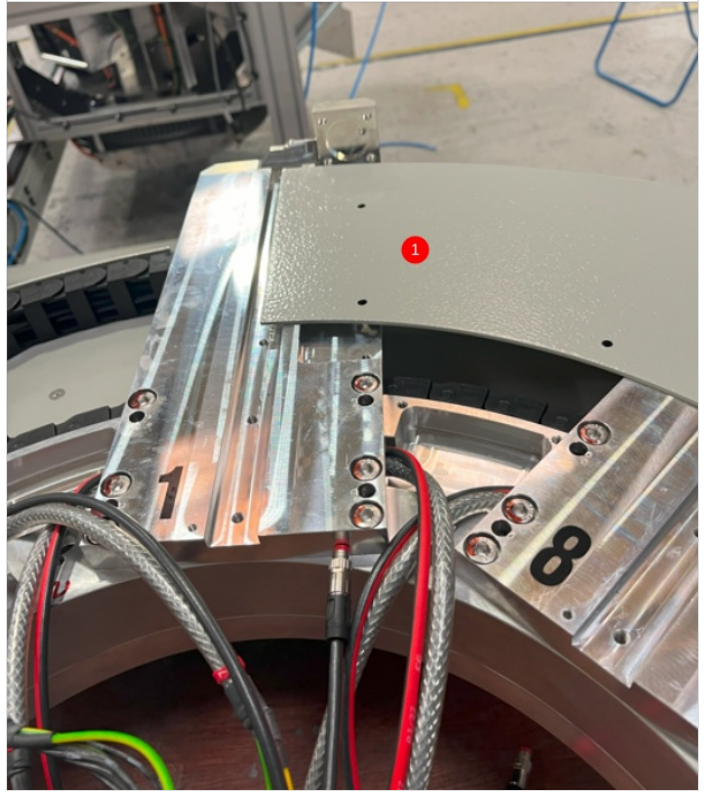
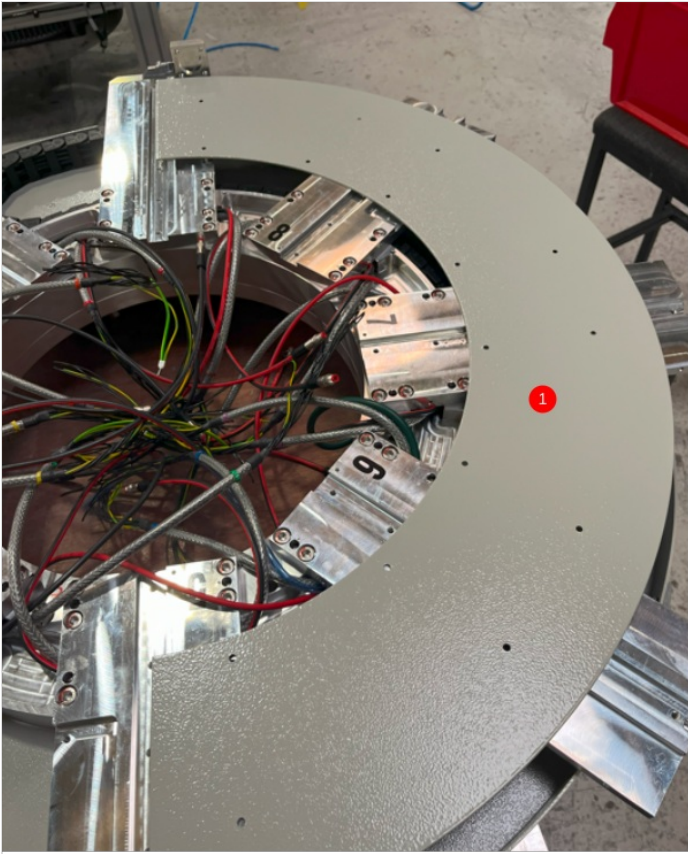
Step 16 - Fit back plate 1

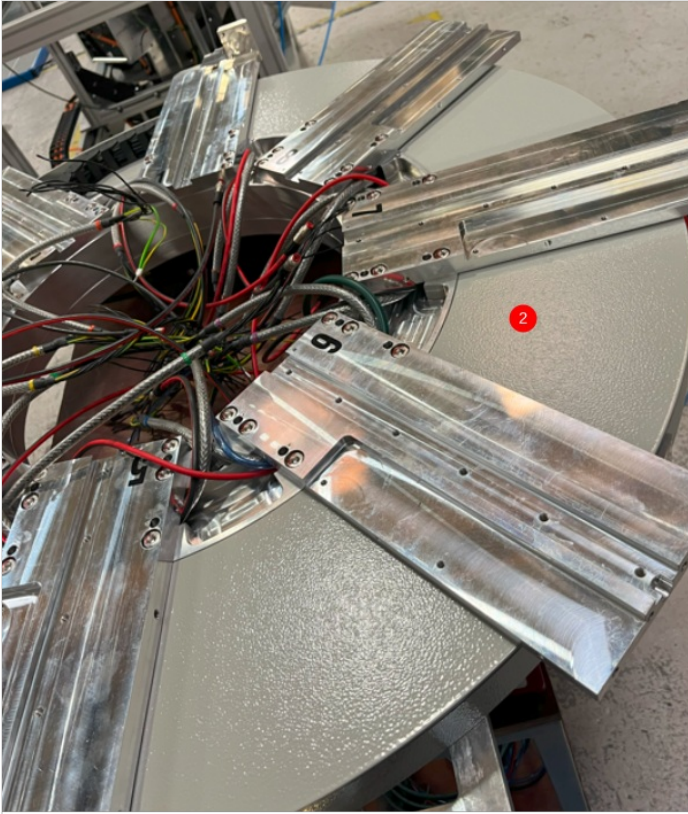
Trunking back plate 1 is positioned as shown

1 It should be fitted to the centre line of spindle plate 1 and 5, on the rear . (Picture shows fitted above for clarity of orientation only)

2 Slide back plate between spindle plates and lower trunking, and orientate as above.

3 Remove access cover to gain access to fit M5 x 10 countersunk bolts to fix backplate in position. Rotate ring to access all fastening points . 2 off fastening points will not be accessible at any point and are restricted by the energy chain mounting bracket and chain . These should be left unfixed at these points





Step 17 - Fit back plate 2

Repeat step 16 steps to fit backplate 2.

Use pictures for orientation

