


R0015307 Bench assembly spindle drive cylinders

Pre Assembly of drive cylinders with sensors

 Difficulty **Medium**

 Duration **3 hour(s)**

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Comments

Introduction

Tools Required

Standard spanner set
Small screwdriver set
Reed switch test box
Araldite 2 part adhesive

Parts Required

D0015540 sensor bracket x 8
P0000488 Sensor x 8
P0001098 elbow adapter x 12
P0000238 6mm elbow x 8
P0001198 6mm flow elbow x 8
P0000459 4mm elbow x 4
P0001202 4mm flow elbow x 4
P0001200 cylinder x 8
P0001201 cylinder x 4
P0001047 reed switch x 16
D0007630 cylinder anchor x 8
M0001170 magnet x 8

Step 1 - Unless otherwise stated

Loctite 243 must be used on all bolts
Bolts must be pen marked when finalised



Step 2 - All Air fittings must have sealant applied

All threaded pneumatic fittings **MUST** have adequate Loctite572 applied

The ring has an anti drop system for tooling on emergency stop, and presence of any air leaks will affect this feature

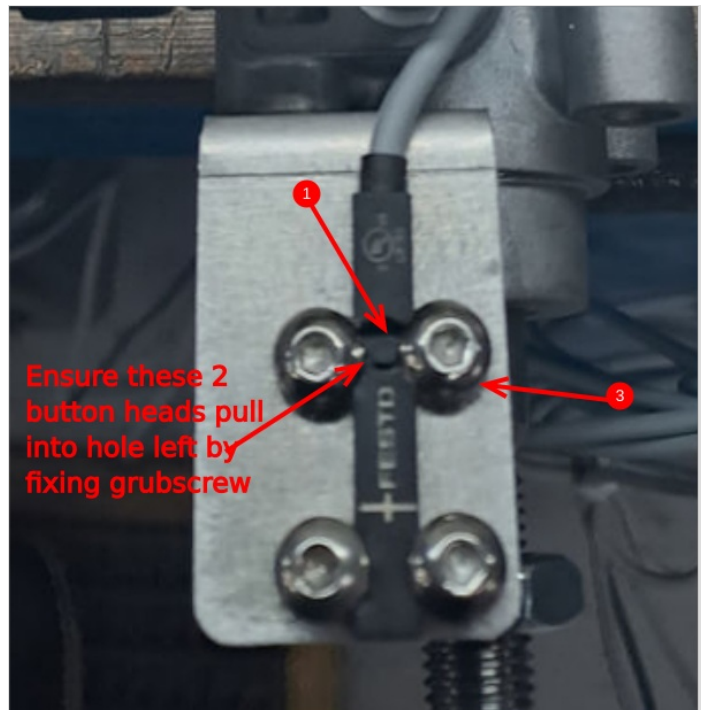


Step 3 - Mount single plunge home sensor

8 off

- 1 Remove OEM sensor locking nut from sensors P0000488
- 2 Label sensors at trailing end SH
- 3 Use m4 x 6 button heads and attach sensor to D0015540 as shown

i ...Ensure 2 off indicated m4 x 6 button fasteners are pulled into the rebate left when the locking grub screw is removed



Step 4 - Attach air fittings to single plunge cylinders

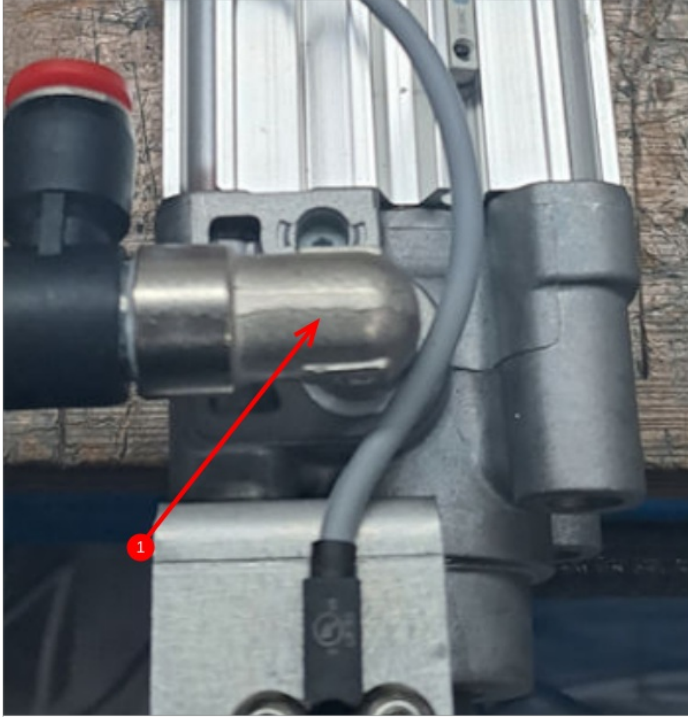
8 off P0001200 cylinder

Use Loctite 572 on all air fittings

1 Attach P0001098 elbow as shown

2 Attach P0001198 elbow

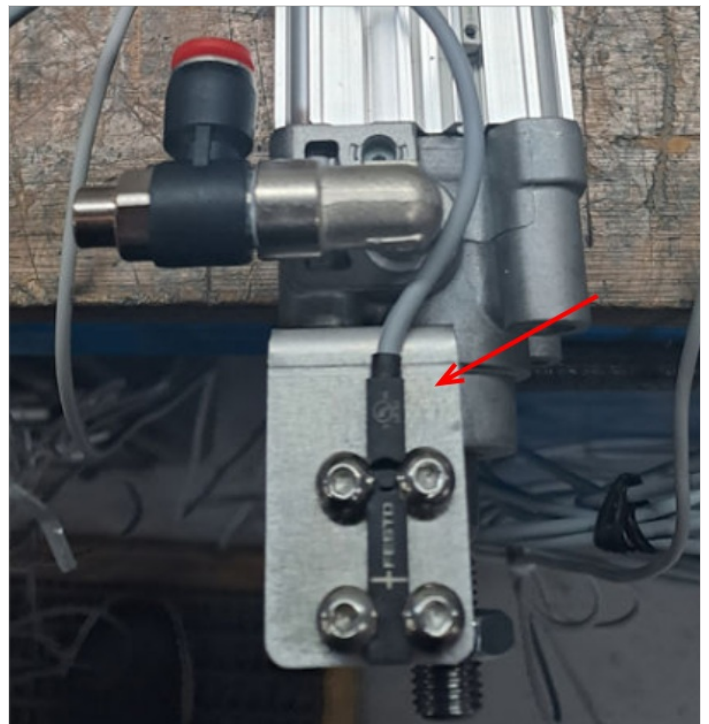
3 Attach P0000238 elbow



Step 5 - Attach sensor bracket to Single plunge cylinder

8 off

Use 2 off m6 x 16 socket caps to attach sensor bracket to cylinder

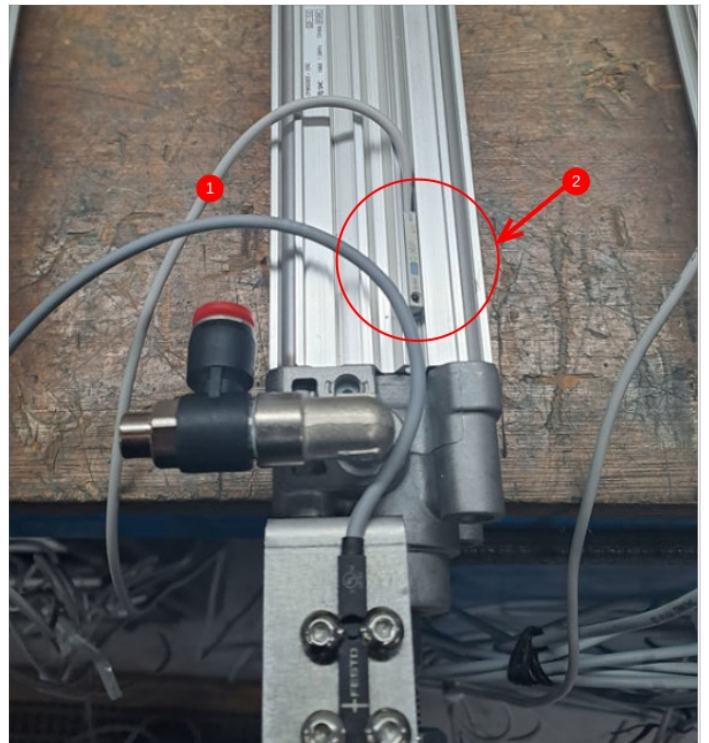


Step 6 - Fit single out sensor

8 off

- 1 label 8 off P0001047 sensor SO at connection end
- 2 Use test box and connect sensor and set position on cylinder with piston extended out of cylinder

⚠ ...It is vital the reed switch is set to mid read point on the cylinder. With the cylinder in the position to be set, the reed switch should be moved forward and back to determine the length of movement the switch will read at. Then the reed switch should be set at the middle point of reading



Step 7 - Attach air fittings to double plunge cylinders

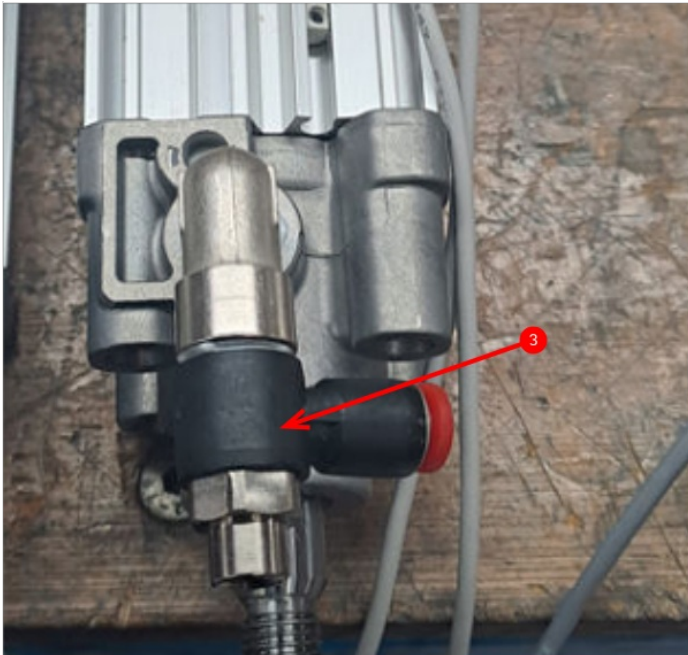
Use Loctite 572 on all air fittings

4 off Cylinder P0001201

1 Attach P0000459 4mm elbow

2 Attach P0001098 elbow

3 Attach P0001202 flow regulator elbow



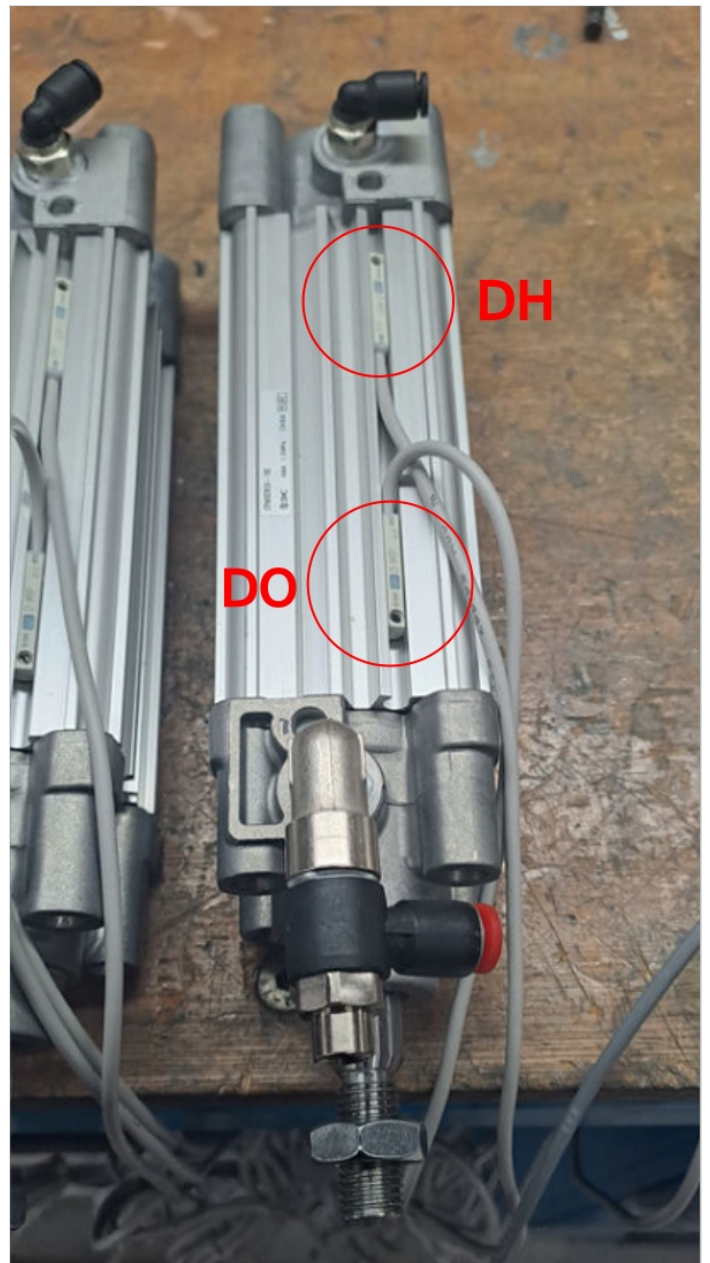
Step 8 - Mount double plunge cylinder sensors

Mark 4 off sensors P0001047 at connection end DO

Mark 4 off sensors P0001047 at connection end DH

Use test box and set reed switches in position on cylinders orientated as shown in picture

! ...It is vital the reed switch is set to mid read point on the cylinder . With the cylinder in the position to be set, the reed switch should be moved forward and back to determine the length of movement the switch will read at. Then the reed switch should be set at the middle point of reading



Step 9 - Mount magnet to cylinder anchor

M0001170 magnet must have additional adhesive applied to be adequately attached to D0007630 cylinder anchor

