

# R0015316 V notch Final Assembly Part 2

## Final assembly details

 Difficulty **Hard**

 Duration **0.1 hour(s)**

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Comments

## Introduction

### Tools Required

Standard Hex key set

Standard Spanner set

ZX5 Blade tightening tool

Compressed air connection with regulation (for axis support)

### Parts required

A0001069 Energy Chain Series B15.050 (48mm radius) Openable x 2

A0001070 Igus Mounting Br Set for A0001069 Non-Pivot x 2

B0000046 Slide Base Bearing Block (Straight Grease Nipple) x 4

B0000173 Blanking plug foc x 28

B0000426 Linear Rail MSB25 400mm Long (AMT) x 4

D0015156 Saw Bearing Plate x 2

D0015161 Saw Plate x 4

D0015162 Saw Mid Spacer Bar x 1

D0015163 Saw Bearing Spacer Bar x 1

D0015168B Balance Cylinder Bracket x 2

D0015169B Cylinder Rod Bracket x 2

D0015179 Energy Chain Bracket x 2

D0015180 Datum Switch Bracket (VZ) x 1

D0015183 VY Stop x 2

D0015235 VY Datum Switch Bracket x 1

D0015236 VY Energy Chain Bracket - Fixed x 1

D0015237 VY Energy Chain Bracket - Moving x 1

D0015250 Safe Sensor Block x 1

D0015251 Safe Sensor Finger x 1

D0015440 Spacer: Ø12.7 x 36, M6 tap thru x 2

D0015452 Scissor Cable Retainer x 1

D0015541 Energy Chain Deflector x 1

D0015704 Energy Chain Support Plate x 1  
E0000336 Sensor: M8; 2mm, PNP N/O, M8 conn x 2  
E0001185 Elte Saw motor x 4  
M0001087 Rubber Bump Stop M6 Ø20x24 x2  
P0000022 Fitting: Brass Reducing Bush 1/4 - 1/8 BSP x 1  
P0000023 Fitting: Hex Nipple 1/8 BSP x 1  
P0000026 Silencer 1/4 BSP x 1  
P0000050 Fitting: Silencer 1/8" BSP x 1  
P0000077 Straight Adaptor 8mm - 1/8BSP x 1  
P0000140 Fitting: Quick Exhaust Valve 1/8" x 1  
P0001040 Fitting: 1/8BSP Hex Head Silencer x 2  
P0001041 SMC Reed Switch Mounting Bracket BJ3-1 x 2  
P0001133 Cylinder: Ø50 x 500 x 2  
P0001134 Floating Joint M18x1.5 x 2  
P0001140 Pilot Check Valve: 8mm to 1/4" BSP x 2  
P0001141 Fitting: SMC Flow Controller Elbow Ø8-1/4BSP x 1  
P0001142 Adjustable Damper 150mm stroke (3000N) x 1  
P0001144 Reed Switch Mounting Band for Ø50 cyl x 2  
R0015084 Bench assemble and Drill Off Swarf chutes  
V0000028B-ZX5 Notching Blade: Ø300 x 96 teeth x 2.8mm pl x 3.3mm kf x24mm x 4

## Step 1 - Unless otherwise stated

Use loctite 243 on all fasteners

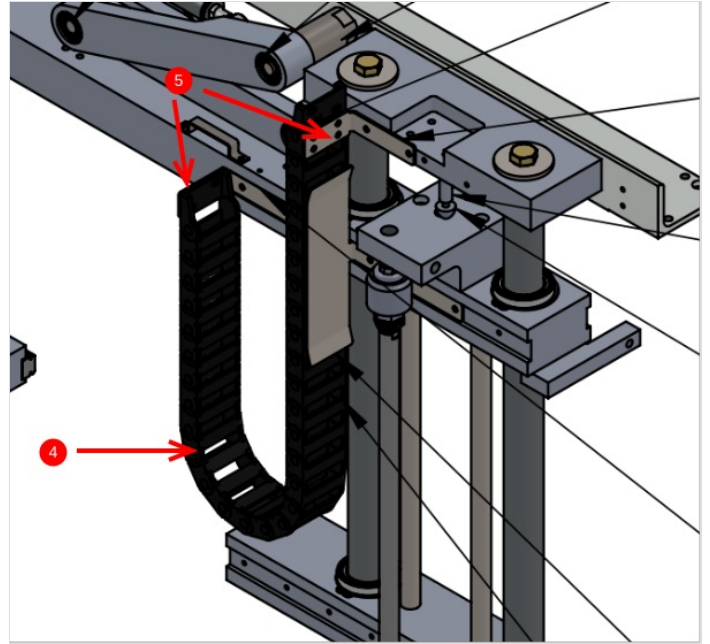
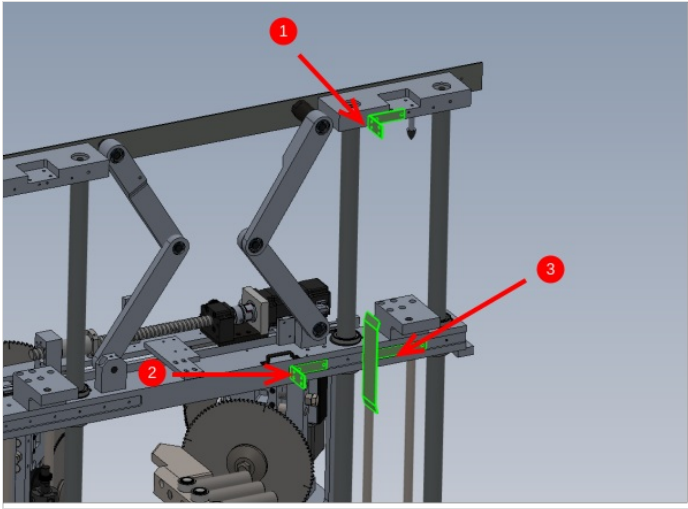
Use loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



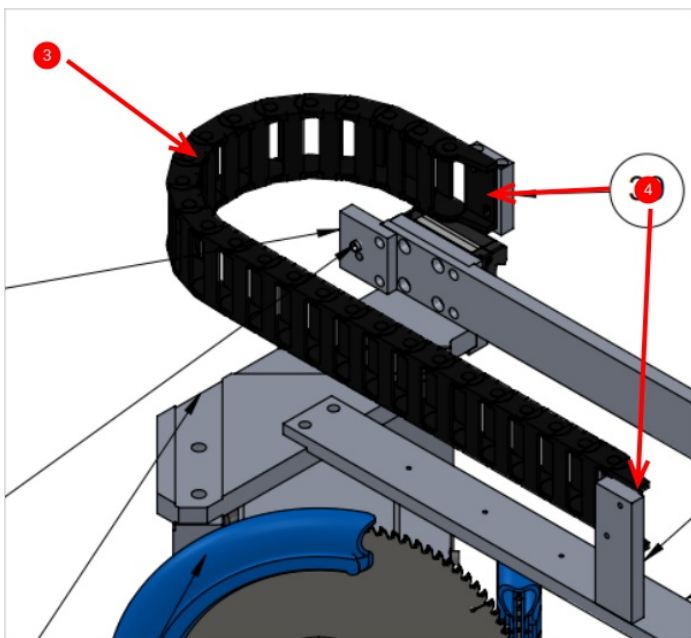
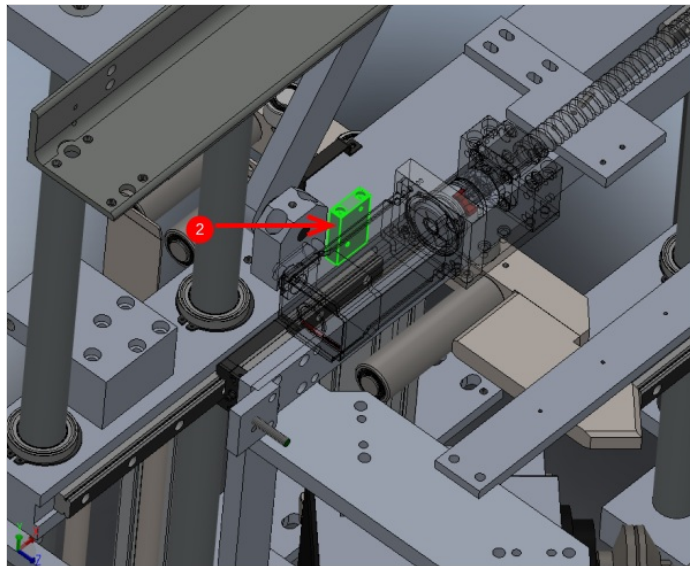
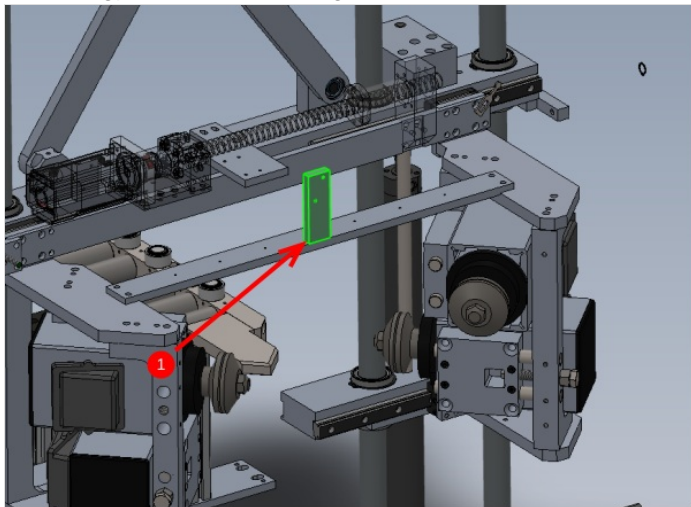
## Step 2 - Fit VZ energy chain

- 1 Fit D0015179 Energy Chain Bracket as shown using 2 off M6 x 16 socket caps and A form washers
- 2 Fit D0015179 Energy Chain Bracket as shown using 2 off M6 x 16 socket caps and A form washers
- 3 Fit D0015541 Energy Chain Deflector as shown using 2 off M6 x 16 socket caps and A form washers
- 4 Assemble A0001069 Energy Chain @ 31 Links with A0001070 Igus Mounting Br Set
- 5 Attach as shown using M6 x 16 button heads, M6 A form washers and M6 nyloc nuts



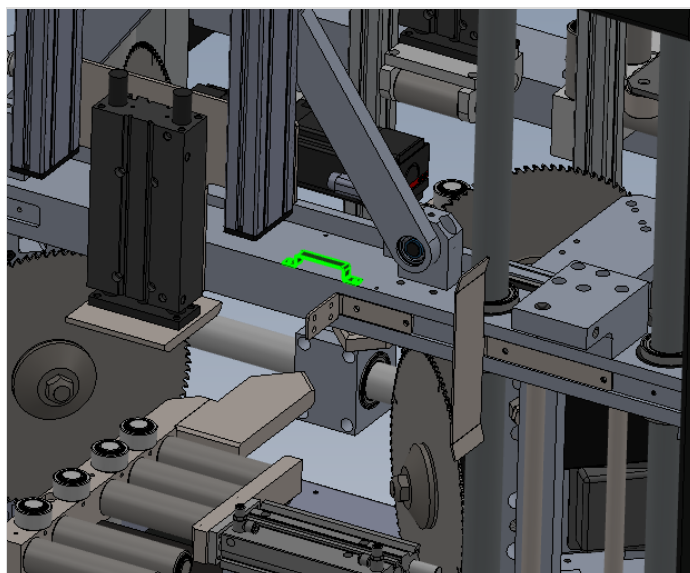
## Step 3 - Fit VY energy chain

- 1 Attach D0015237 VY Energy Chain Bracket as shown. Use 2 off M5 x 20 socket caps and A form washers to fix . Ensure correct orientation
- 2 Attach D0015236 VY Energy Chain Bracket as shown. Use 2 off M5 x 65 socket caps , ensure correct orientation
- 3 Assemble A0001069 Energy Chain Series @21 links with A0001070 Iigus Mounting Br Set as shown
- 4 Fit energy chain as shown using 4 off M5 x 16 button sockets and 4 off M5 12mm od washers



## Step 4 - Attach cable retainer

Attach D0015452 Scissor Cable Retainer as shown , Using 2 off M5 x 12 socket caps and A form washers

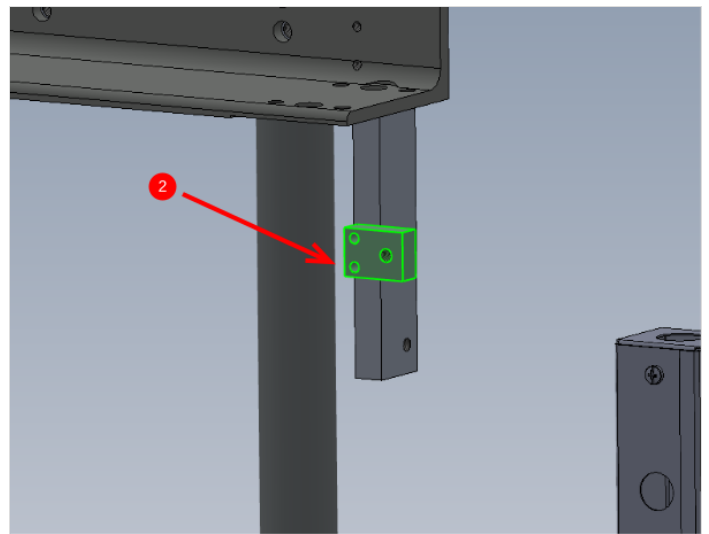
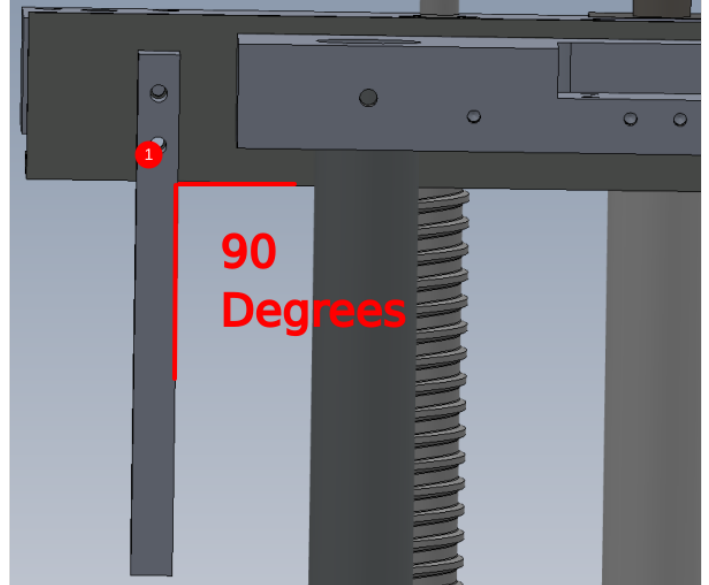
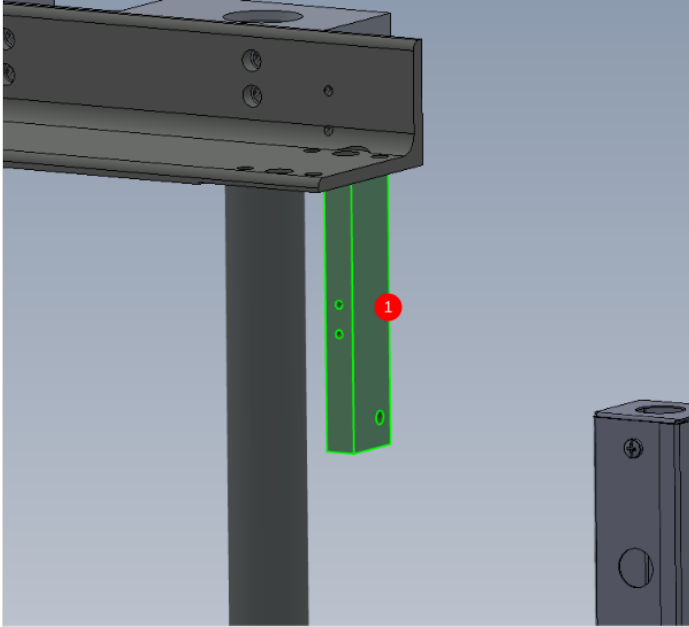


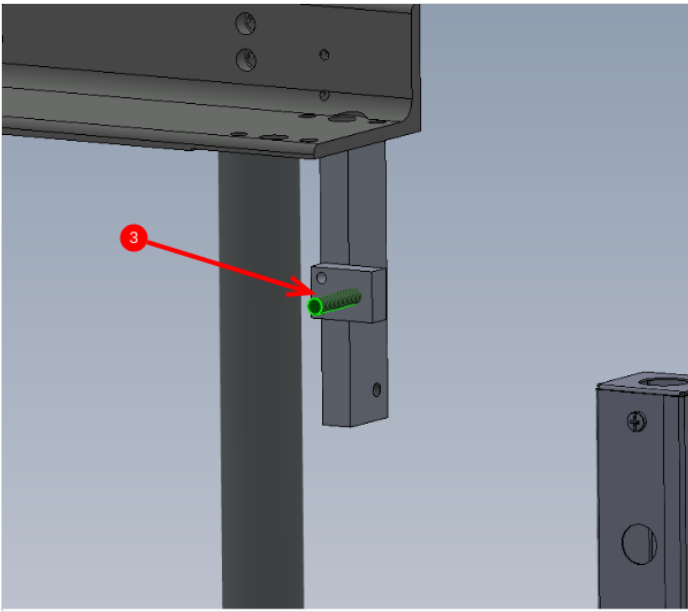
## Step 5 - Attach Datum sensor

1 Attach D0015180 Datum Switch Bracket as shown . This is always at the rear of the machine. Use 2 off M6 x 50 socket caps and A form washers to fix. Ensure bracket is mounted square

2 Attach D0015250 Safe Sensor Block as shown. Use 2 off M5 x 25 socket caps and A form washers

3 Fit E0000336 Sensor: M8; 2mm, as shown ensuring shakeproof washer is fitted along with locking nut. Do not over tension sensor lock nut!



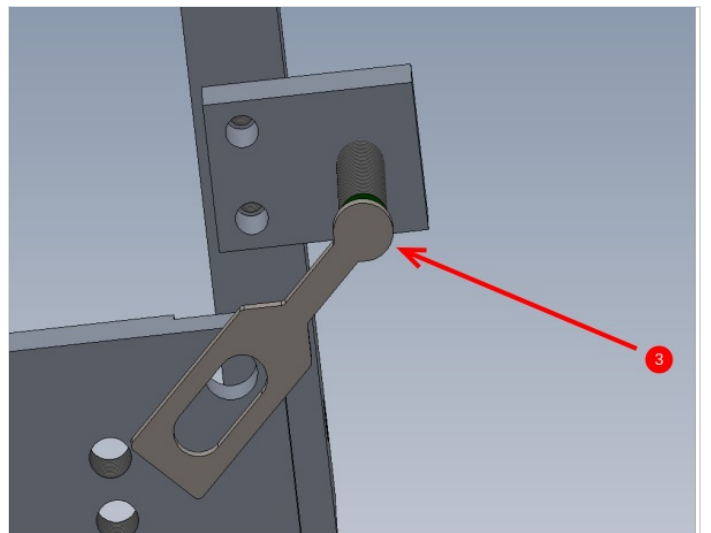
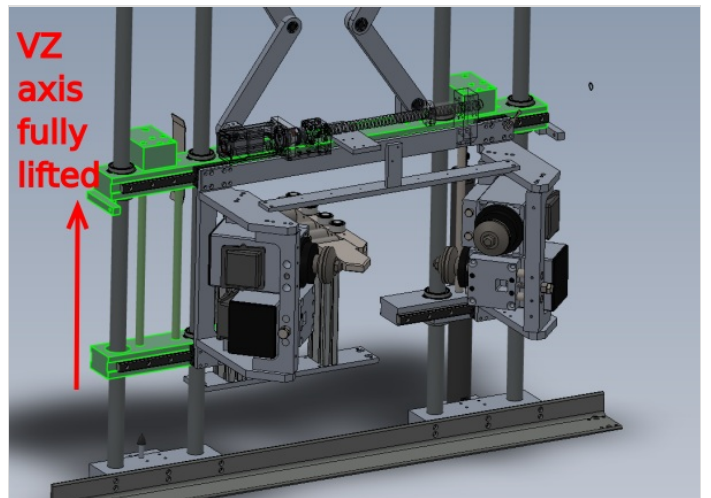
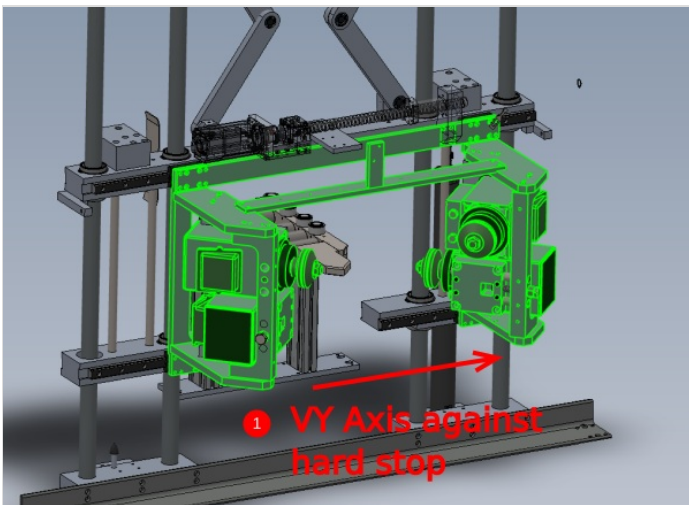


## Step 6 - Set V safe position

1 Ensure VY axis is at full travel in the direction shown

2 Ensure VZ axis is fully lifted with pneumatic support

3 Set sensor paddle to align with sensor and finalise. Ensure sensor is set to the correct position. Sensor must be set to -1mm , but MUST not contact sensor paddle



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## Step 7 - Fit Saw blades

1 Fit 4 off V0000028B-ZX5 Notching Blade: as shown

2 Ensure blades are orientated correctly for rotation

