

# R0015318 Fit Swarf Chutes

Fitting instructions for waste chutes

 Difficulty **Medium**

 Duration **1 hour(s)**

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Comments

## Introduction

### Tools Required

Standard Hex key set

Pipe cutters

### Parts Required

R0015084 Bench assemble and Drill Off Swarf chutes

## Step 1 - Unless otherwise stated

Use loctite 243 on all fasteners

Use loctite 572 on all threaded pneumatic connection

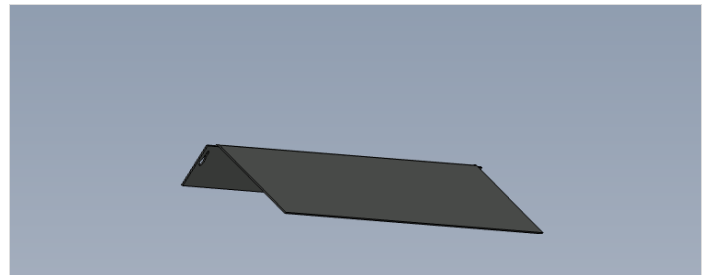
Pen mark all fasteners to show finalised



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## Step 2 - Fit lower chute lip

Fit lower swarf lip

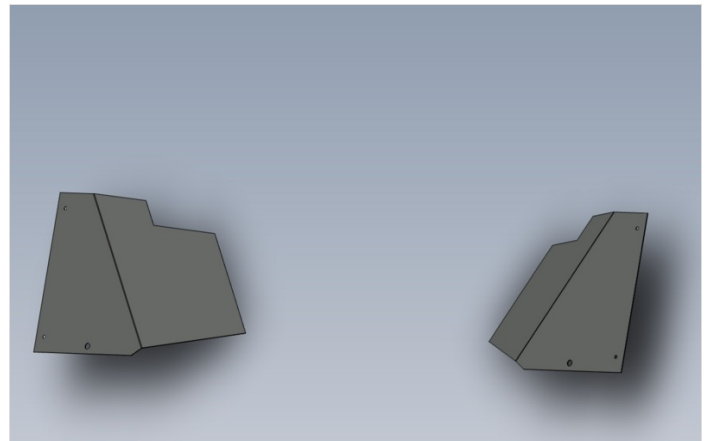


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## Step 3 - Fit side chutes

Fit 2 off side chutes

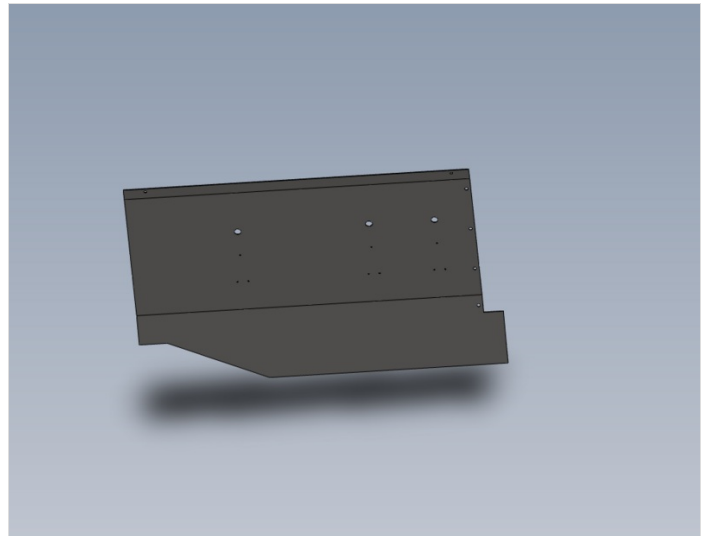
Do not finalise fasteners



## Step 4 - Fit swarf chute section one

Fit larger swarf chute section

Do not finalise fasteners

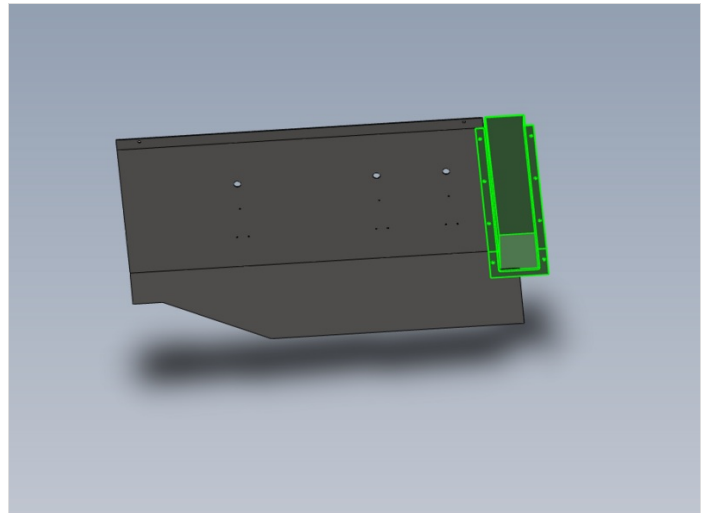


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## Step 5 - Fit cylinder poscket

Fit cylinder pocket

Do not finalise fasteners

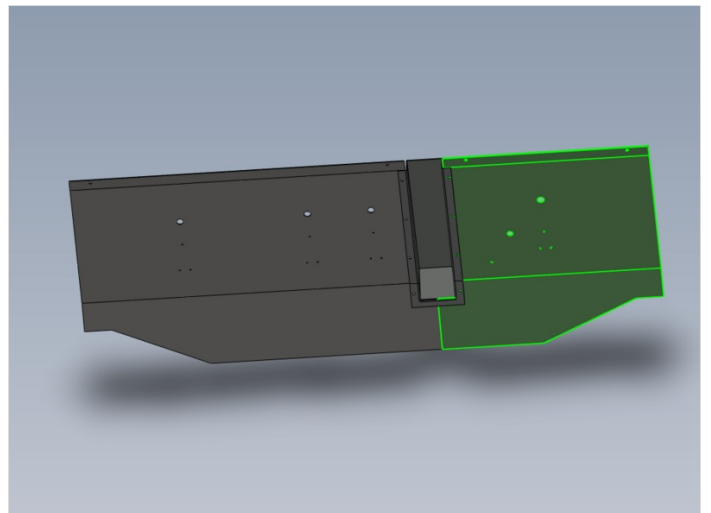


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## Step 6 - Fit chute section 2

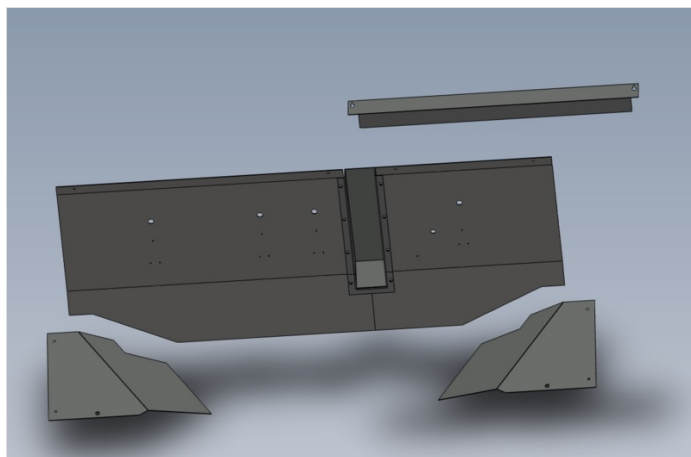
Fit chute section 2

Do not finalise fasteners



## Step 7 - Position for best fit

Position all sections in conjunction with each other for best fit



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## Step 8 - Finalise all fasteners

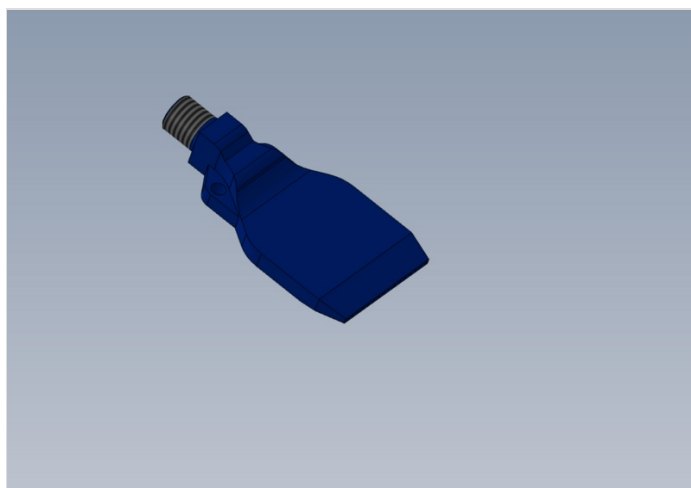
Finalise all fasteners ensuring adhesive is applied



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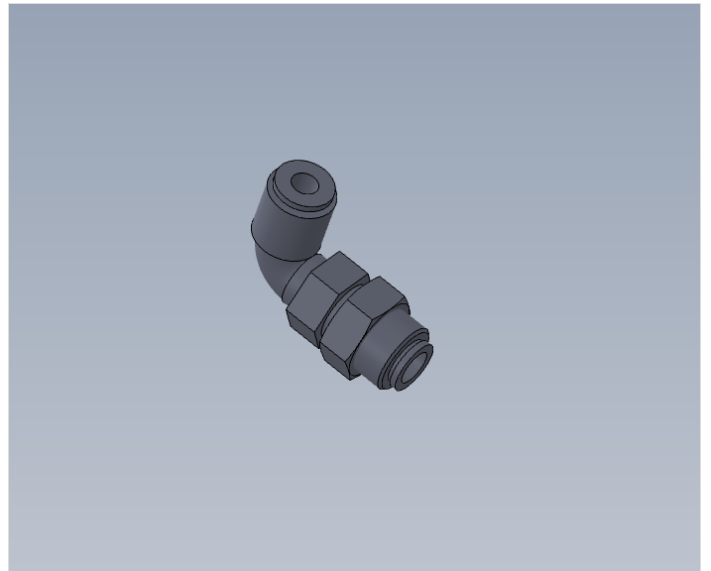
## Step 9 - Connect Chute blower feed pipes

Connect 2 off 6mm black air pipes to bulkheads for chute blowers on rear of swarf chutes



## Step 10 - Connect Y3501 and Y3502

Connect 3502 and 3501 6mm pipes to rear of chute and insert x63 reed switch through grommit



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## Step 11 - Loom feed pipes to top clamp

Set position of reed switch on top clamp cylinder using test box

Loom and spiral wrap pipes and reed switch and restrain

