

R0015319 Fit Guards and Doors

Details for guard fitting

 Difficulty **Medium**

 Duration **5 hour(s)**

Contents

Introduction

Step 1 - Unless otherwise stated

Step 2 - Fit lower rear panel

Step 3 - Fit roof panel

Step 4 - Fit rear panel

Step 5 - Alignment

Step 6 - Fit Guard Doors

Step 7 - Drill door stops

Step 8 - Drill and set interlock switches

Step 9 - Front panel

Comments

Introduction

Tools Required

standard hex key set
Standard spanner set
Standard HSS drill set
Standard tap set
Long reach 4.2mm drill
Extended M5 tap

Parts Required

R0015321 Bench assemble guards and doors

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

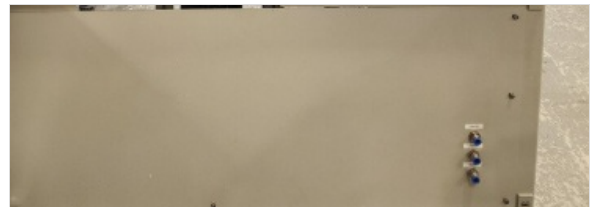


Step 2 - Fit lower rear panel

Connect 12.. red x 2 + 12mm blue pipes to pre fitted 12mm bulkheads on lower panel

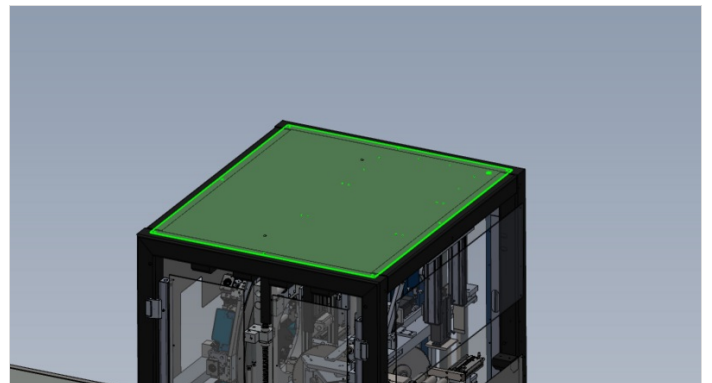
Use M6 x 12 socket caps + a forms to fix panel to frame

Use M6 x 10 buttons instead of M6 x 12 at bottom middle and lower corner cabinet side.



Step 3 - Fit roof panel

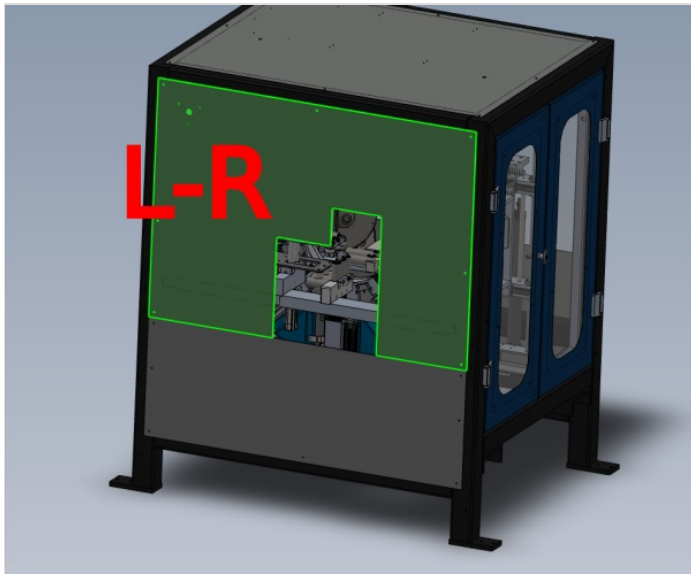
Fit pre assembled roof panel Using M8 x 20 socket caps and A form washers



Step 4 - Fit rear panel

Fit re assembled rear panel

Secure with 7 off M6 x 12 socket caps and M6 A form washers



Step 5 - Alignment

It is vital that door locks should align correctly.

Handle operation should be smooth and no force required to engage locking pins

Any discrepancies should be reported

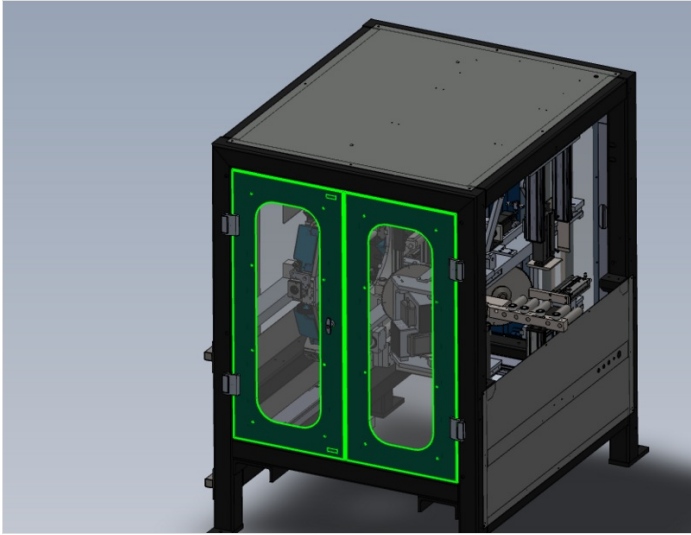


Step 6 - Fit Guard Doors

Fit 4 off Pre assembled guard doors to hinges using spreader plates D0015234 8 off

Use M5 x 16 socket caps and M5 penny washers to fix

Use adjustment in clearance holes of fixing points to align doors to frame as well as possible





Step 7 - Drill door stops

Drill off door lock pins and strike plates

Fit latch plates D0007960 as shown and position door to be flush to edge of frame

Mark through slot and drill M5

Lightly fix door stop using M5 x 25 socket cap and M5 Form washer

Close door and engage door lock to position door stop accurately as shown

Open door and mark and drill second slot on door stop to M5 and finalise fixing

Ensure operation of door locking is checked once drilled and movement is smooth with no excessive force required



Step 8 - Drill and set interlock switches

Set and drill door interlock switches

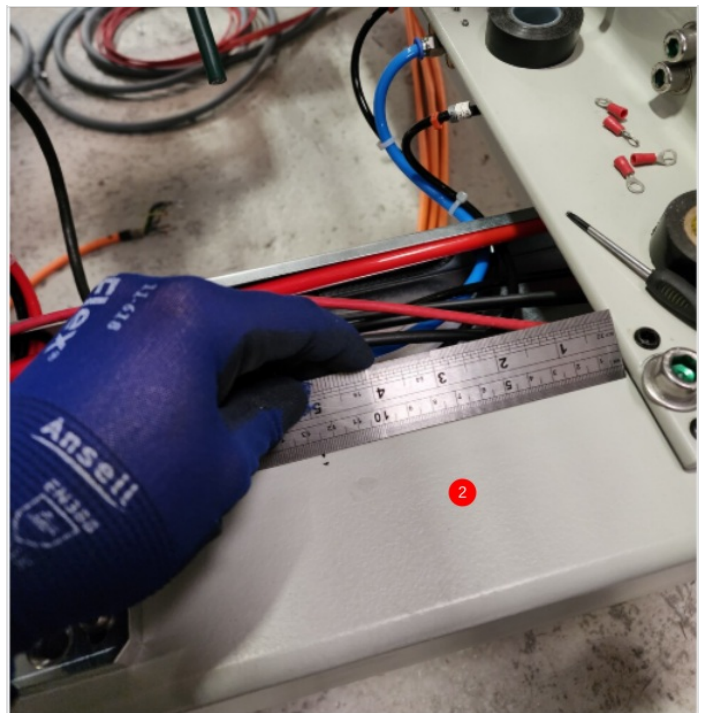
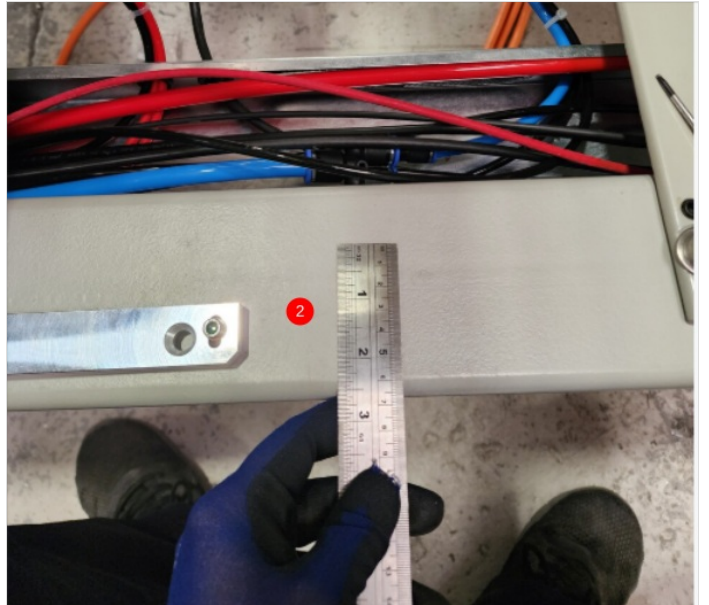
1 Flip front block on guard switches. Key will sit at top

2 Drill switches 67mm from box section edge and 95 and 125mm from v notch bar both sides. (Approximate measurements. Offer up block first)

Mark through key holes to drill key to door.

3 Use M5 x 50 caps to attach interlock to the frame

4 Fit interlock blade to interlock, close door and mark through blade. Drill and tap and fix with M5 x 16 socket caps and M5 A form washers, backed with a M5 A form washer and dome nut.





Step 9 - Front panel

Front upper panel should not be fitted until commissioning have installed tooling into rotary head

