

R0015321 Bench Assemble Guards and Doors

Bench assembly details for guards and doors

 Difficulty **Medium**

 Duration **5 hour(s)**

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Introduction

Tools Required

Standard hex key set

Standard spanner set

Dymo label printer

Parts Required

C0001152 Camera: HikVision DS-2CD2343G0-I-2.8mm x 3

C0001239 Micro SD Card 32Gb Class 10 x 3

D0007643B Perspex Glazing - Door x 4

D0007644B Machining Centre Door 1 x 2

D0007645B Machining Centre Door 2 x 2

D0007654B Perspex Glazing - Front Guard MkB x 1

H0015747 8mm diameter rod x 1 (in process of changing to D0015747 x 4)

M0000036 Sign - Ear Protection x 1

M0000201 T Handle Cabinet Lock x 2

Step 1 - Unless otherwise stated

Use locktite 243 on all fasteners

Use loctite 572 on all threaded pneumatic connection

Pen mark all fasteners to show finalised



Step 2 - Paintwork quality

Please ensure all paintwork is inspected before assembly and any quality issues are reported.

All paintwork must be of a good quality with no damage evident



Step 3 - Roof Panel fit light

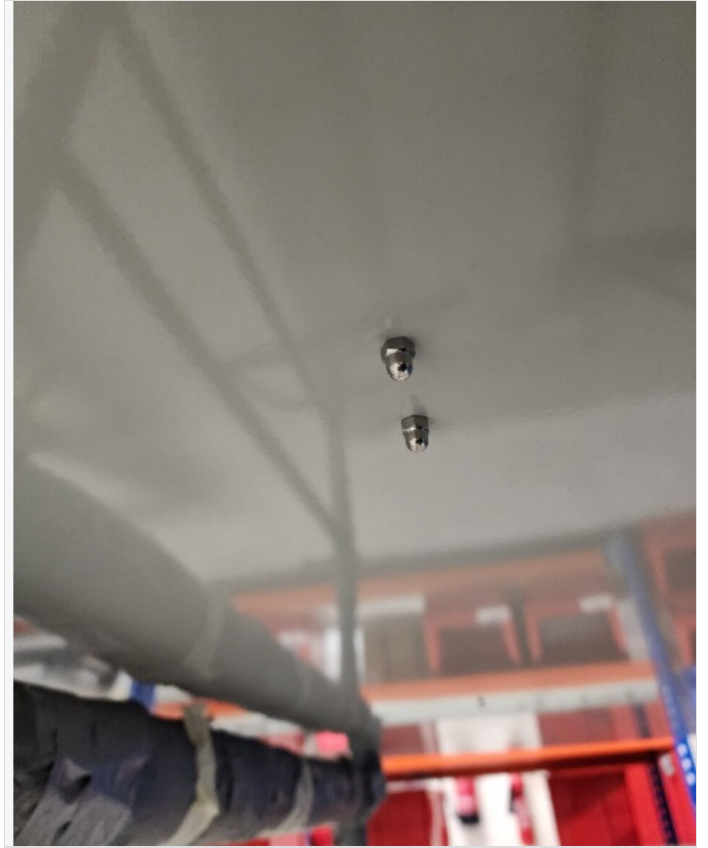
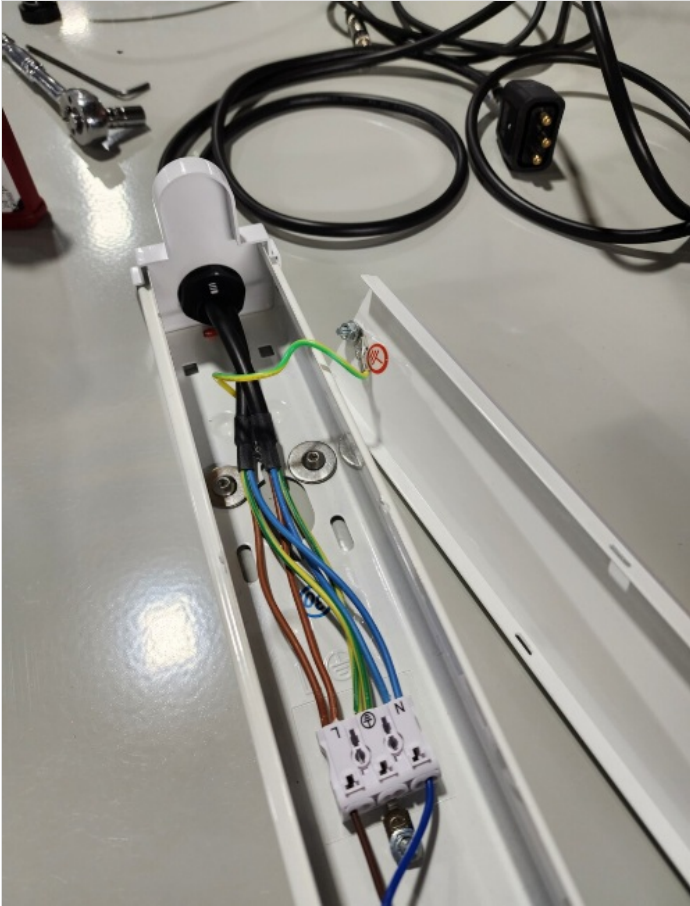
Images show L-R configuration. Please mirror assembly for R-L

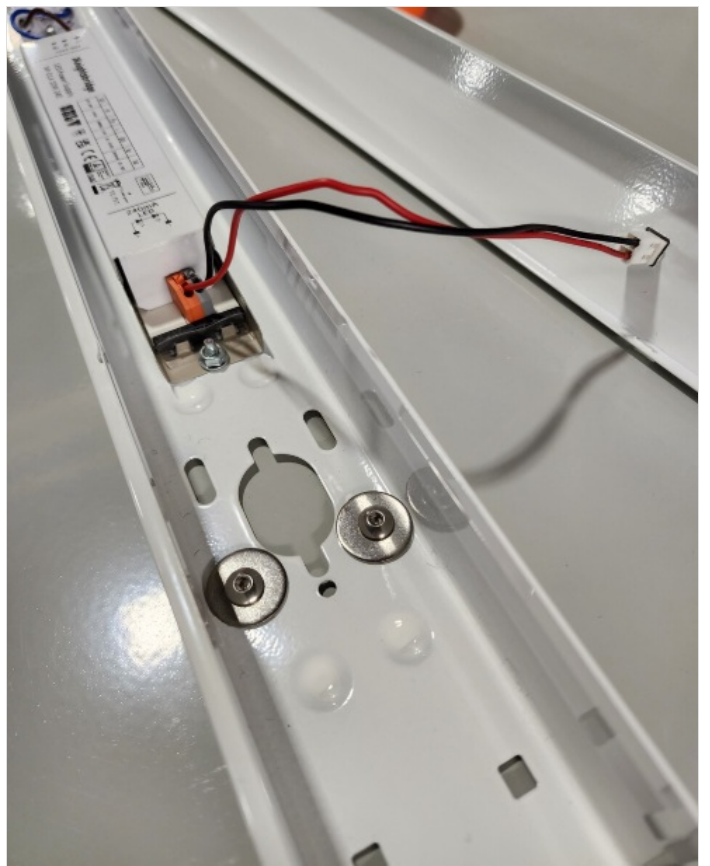
Use m5 x 10 buttons 4 off + penny washers backed with a forms and dome nuts to fit each light assembly to pre drilled holes as shown

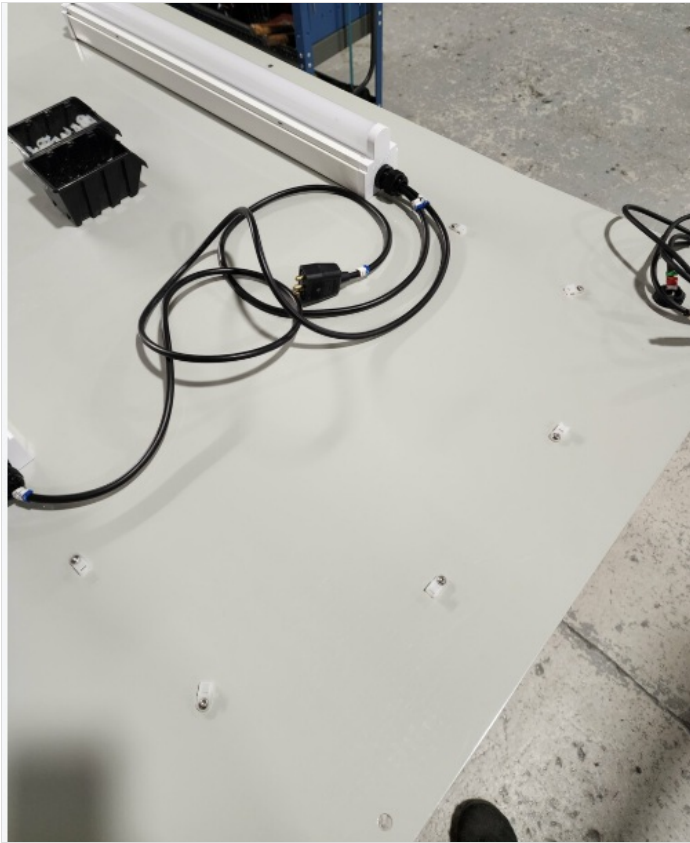
Ensure Light connection lead travels towards tie base fixing points

Attach M4 tie bases with M4 x 6 button heads to pre drilled holes

Secure cables from lights as shown





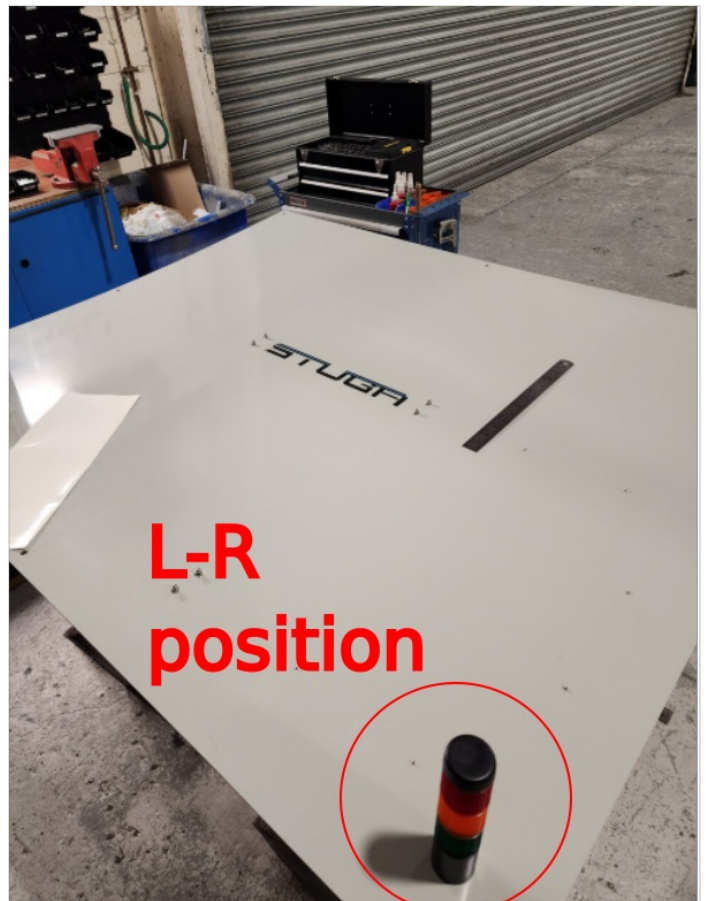


Step 4 - Roof panel fit beacon

Images show L-R configuration. Please mirror assembly for R-L

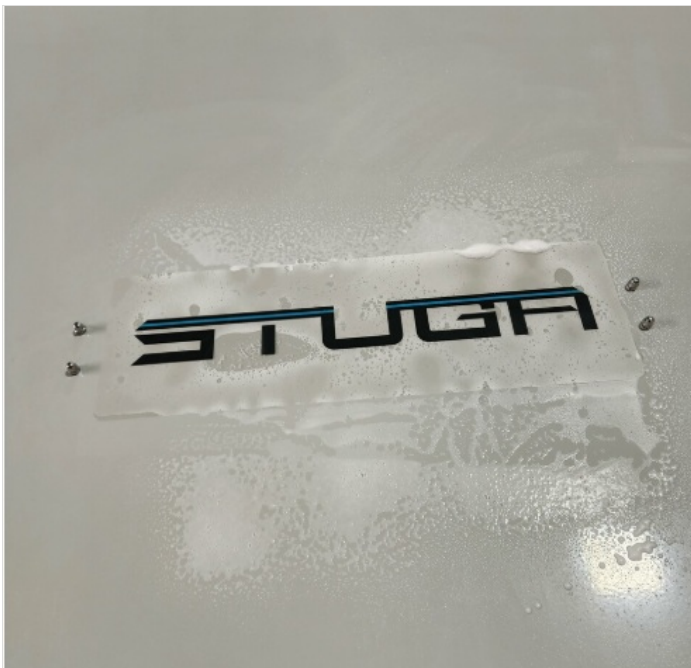
Attached pre wired beacon as shown





Step 5 - Roof panel fit Stuga sticker

Fit Large clear Stuga sticker to top face of roof. Position evenly between light fixing points shown
Please ensure sticker is applied using foam spray and squeegee , so no air bubbles are present once fitted



Step 6 - Front Panel Upper Fit screen

L-R Configuration shown . Mirror for R-L

Use M6 x 16 socket caps, M6 penny washers, M6 A Form washers and M6 nyloc nuts to fix



Step 7 - Front Panel Upper fit camera

L-R Configuration shown . Mirror for R-L

Fit C0001239 Micro SD Card 32Gb Class 10 x 1 to camera before mounting

Fit camera to top guard using 3 off M4 x 12 socket caps , and back off with M4 dome nuts and M4 A form washers

Ensure camera is fitted the correct orientation. Camera will have a 'UP' marked on body. This must be at the top

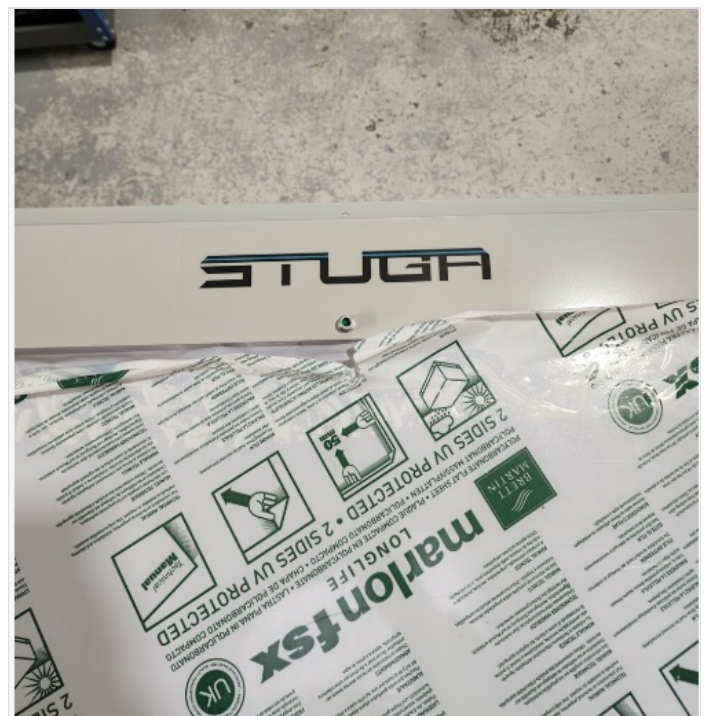
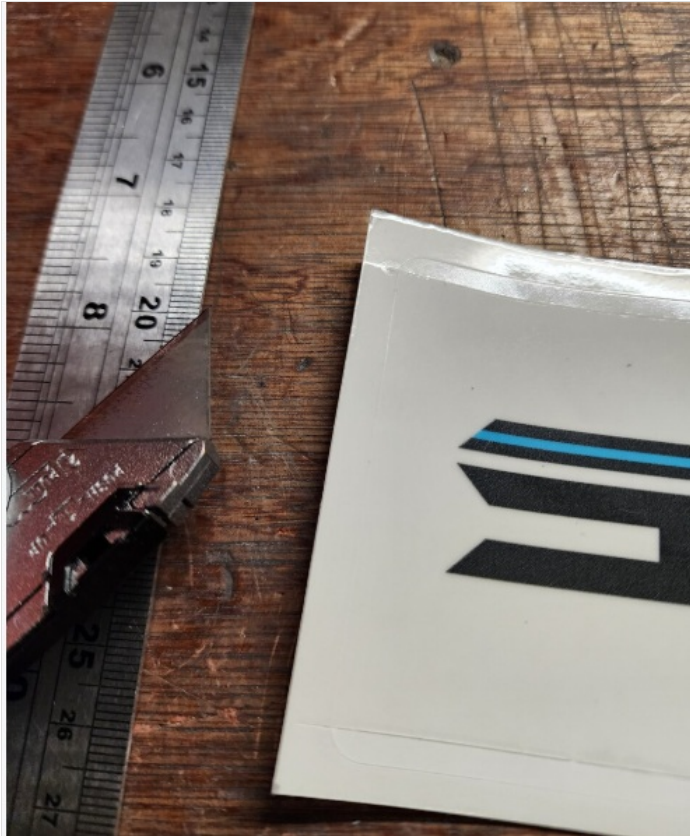
Camera must be fitted to top corner of front guard closest to Module F saw unit



Step 8 - Front Panel upper Fit Sticker

Remove 4mm off top and bottom of small stuga sticker, fit central with m6 bolt

Ensure sticker is fitted wet , so no air bubbles are present once fitted



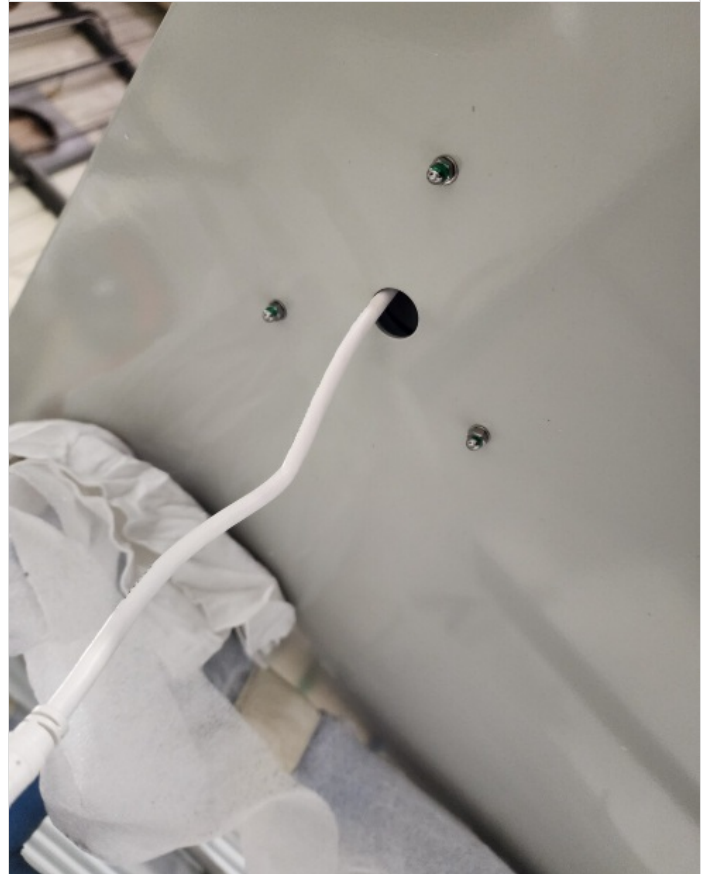
Step 9 - Rear Upper Panel Fit Camera

L-R Configuration shown . Mirror for R-L

Fit C0001239 Micro SD Card 32Gb Class 10 x 1 to camera before mounting

Fit camera to rear panel using 3 off M4 x 12 socket caps , and back off with M4 dome nuts and M4 A form washers

Ensure camera is fitted the correct orientation. Camera will have a 'UP' marked on body. This must be at the top



Step 10 - Rear upper Panel Fit sticker

L-R Configuration shown . Mirror for R-L

Fit large Clear Stuga sticker . Ensure sticker is fitted wet to avoid air bubbles once fitted



Step 11 - Door assembly Fit Handles

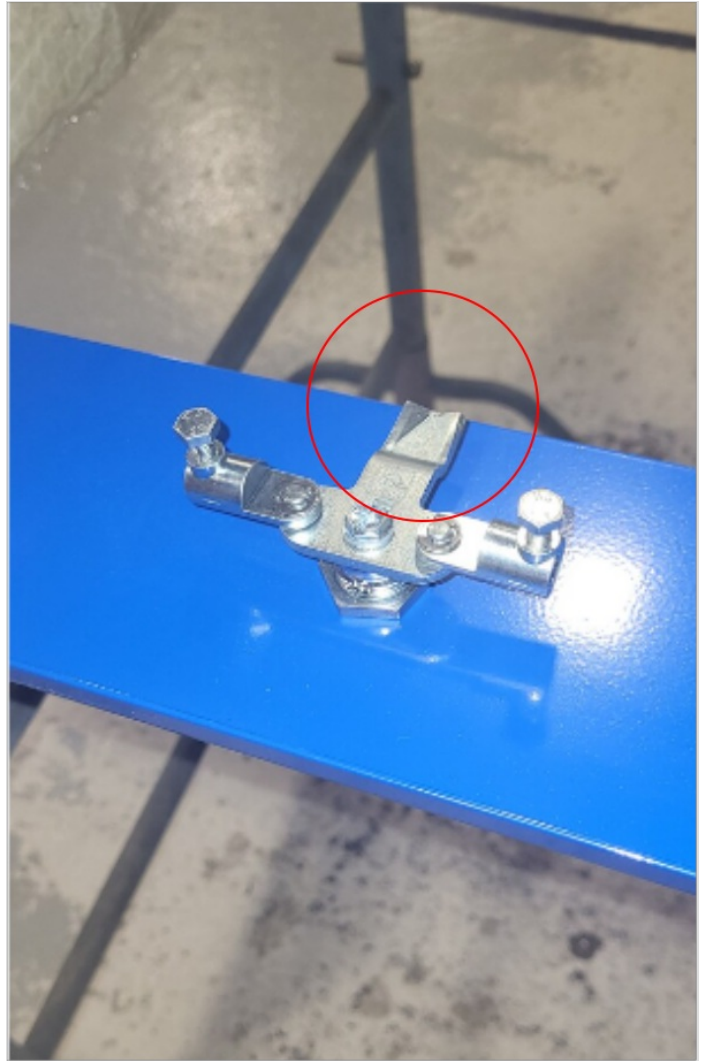
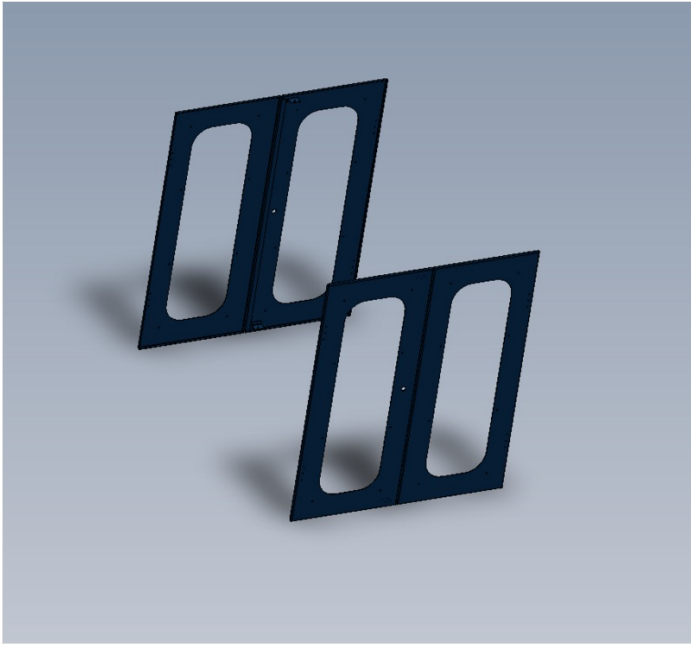
Fit door handles to doors, ensure orientated as shown, With striker facing centre of door

Ensure Loctite 243 is used on all securing nuts and Securing bolts. Remove all pre fitted bolts and add adhesive

Once tightened sufficiently check that rotation of handles are smooth

Fit 2 off door bars to each door , Adhesive is vital on locking fasteners for these rods

Ensure chauffeured end is present and orientated correctly





Step 12 - Attach key to handle

Ensure handle is left unlocked and key is fitted to handle as shown



Step 13 - Door Assembly Fit screens

Fit screens to doors

Use M6 x 20 socket caps, M6 penny washers , M6 A form washers and M6 Nyloc nuts to fix

Ensure protective wrap is only removed from edges to allow fitment of screen



Step 14 - Door Assembly Fit stickers

Fit stickers as shown

parts consumables and ambient temp stickers need cutting down by 4mm top and bottom to suit doors

Ensure all stickers are fitted wet, so no air bubbles are present once fitted

Front doors





