

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 loctite 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

Please Provide Fastener details and hole positions for drilled holes to fit lights if required

Please Provide photos of this step

Fit Pre assembled lights to roof panel

Ensure nyloc nuts are used to back of fixings on light assemblies

Fit cable tie bases

Attach Cables from lights to tie bases

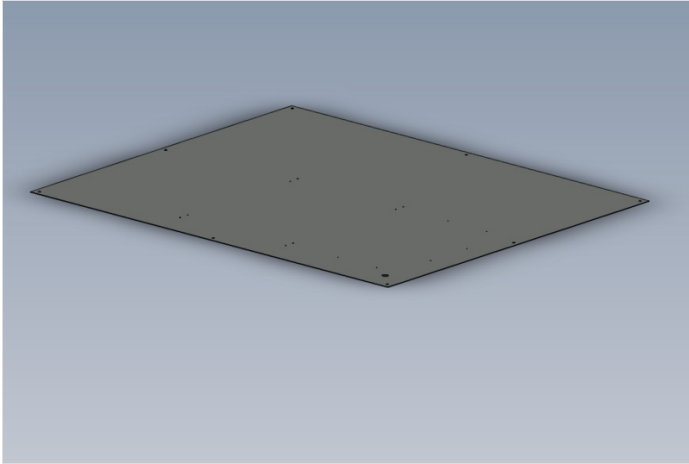


Photo
Required

Step 4 - Roof panel fit beacon

Please Provide photos of this step

Fit Beacon assembly to roof

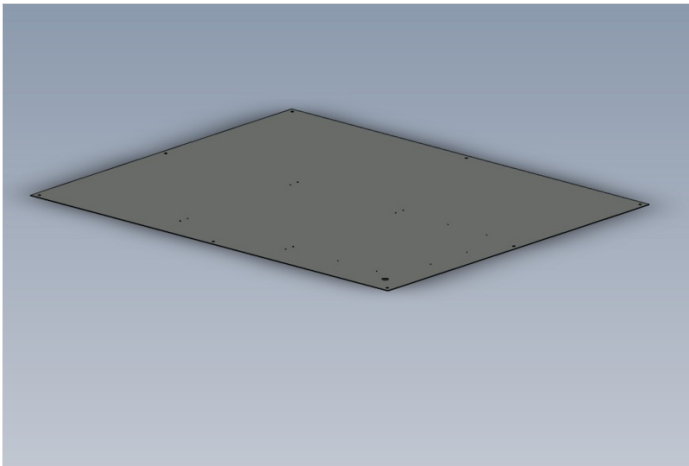


Photo
Required

Step 5 - Roof panel fit Stuga sticker

Please Provide photos of this step

Fit Large clear Stuga sticker to top face of roof. Please ensure sticker is applied wet, so no air bubbles are present once fitted

fit central and facing infeed

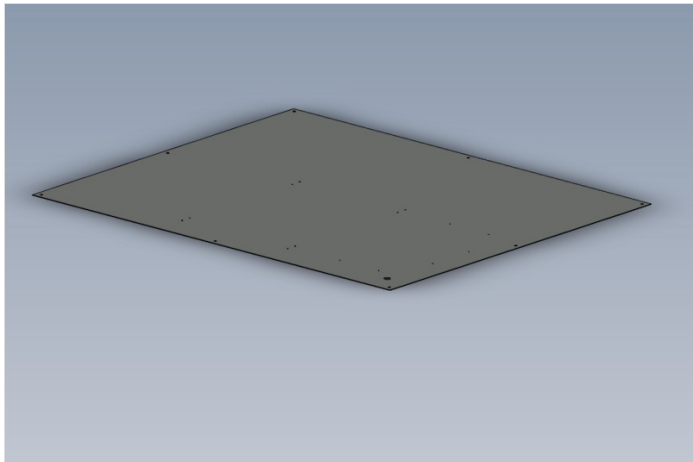


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Step 6 - Front Panel Upper Fit screen

Please Provide photos of this step

Fit screen to front panel

Use M6 x 20 socket caps, M6 penny washers, M6 A Form washers and M6 nyloc nuts to fix

Ecr raised 11/12/23 to amend hole position on screen D0007654B Perspex Glazing - Front Guard MkBto allow fitment

Holes require slotting for time being until ecr is actioned

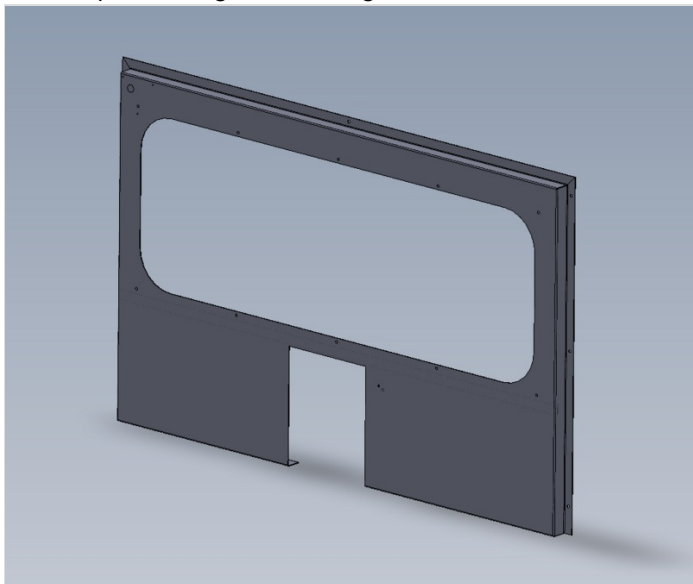


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Step 7 - Front Panel Upper fit camera

Please Provide photos of this step

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

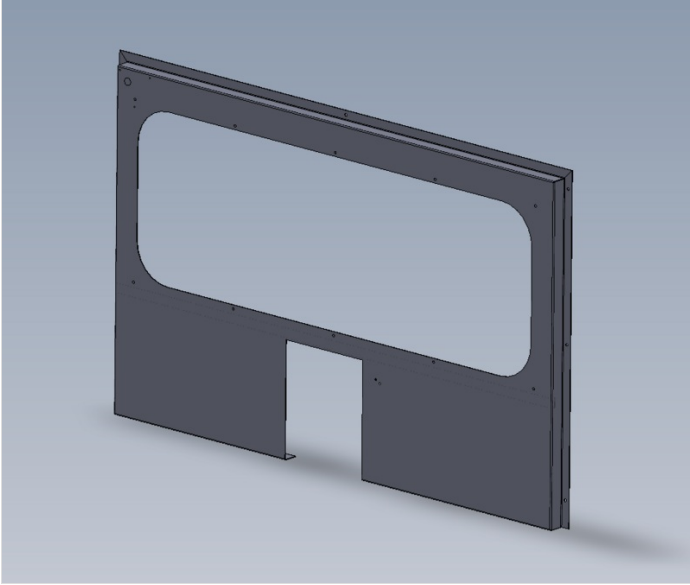


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Step 8 - Front Panel upper Fit Sticker

Please Provide photos of this step

Fit small clear Stuga sticker to front panel

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

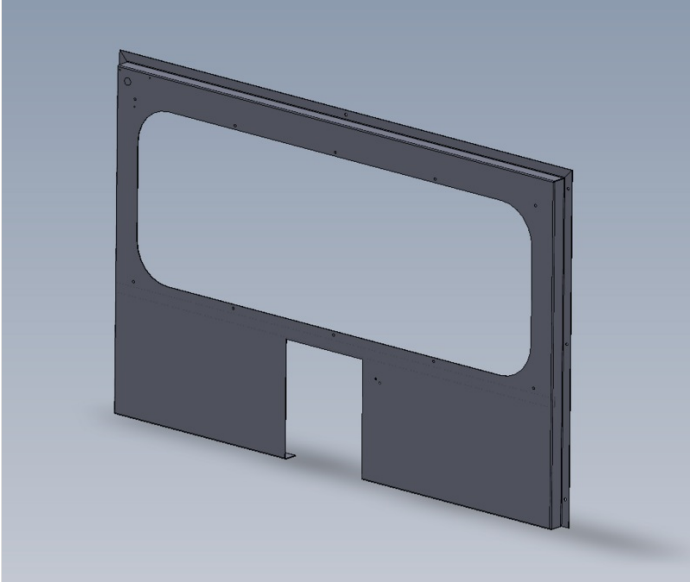


Photo
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Step 9 - Rear Upper Panel Fit Camera

Please Provide photos of this step

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

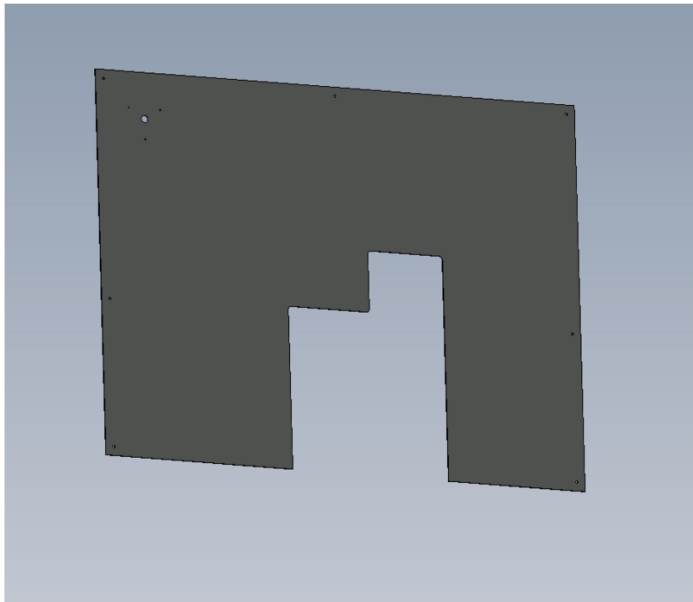


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Step 10 - Rear upper Panel Fit sticker

Please Provide photos of this step

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

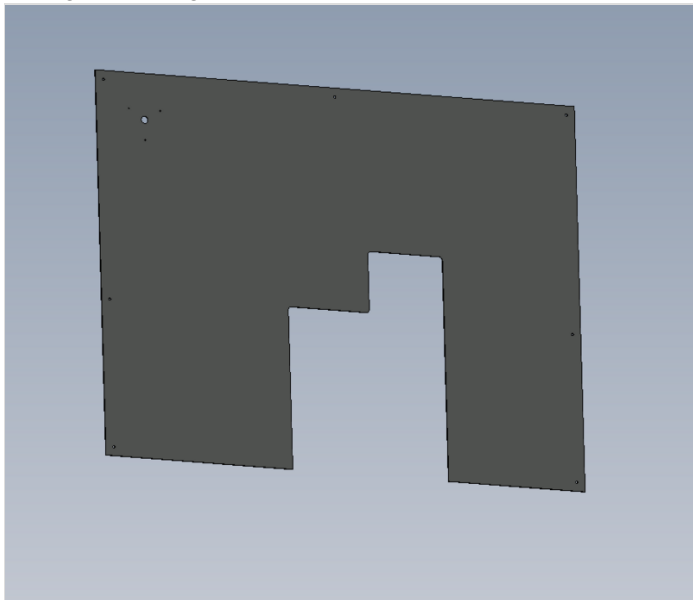


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Step 11 - Door assembly Fit Handles

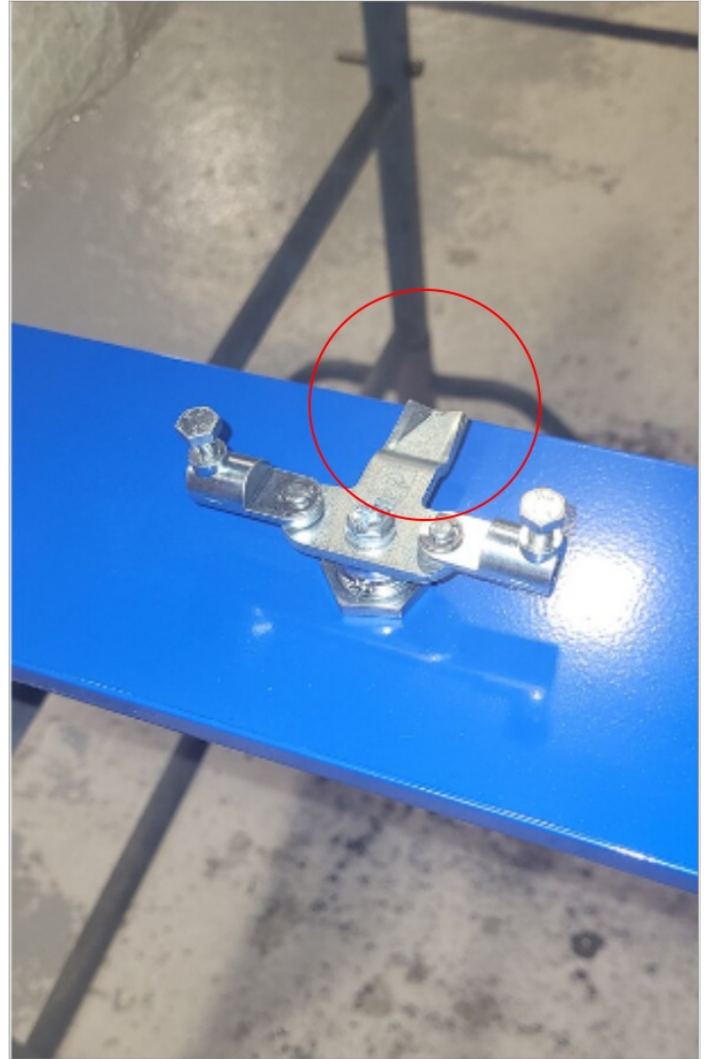
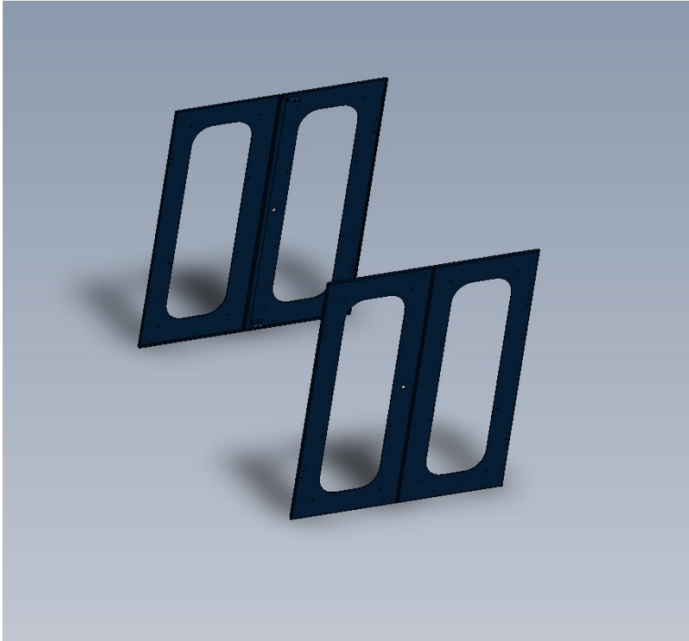
Fit door handles to doors, ensure orientated as shown, With striker facing centre of door

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

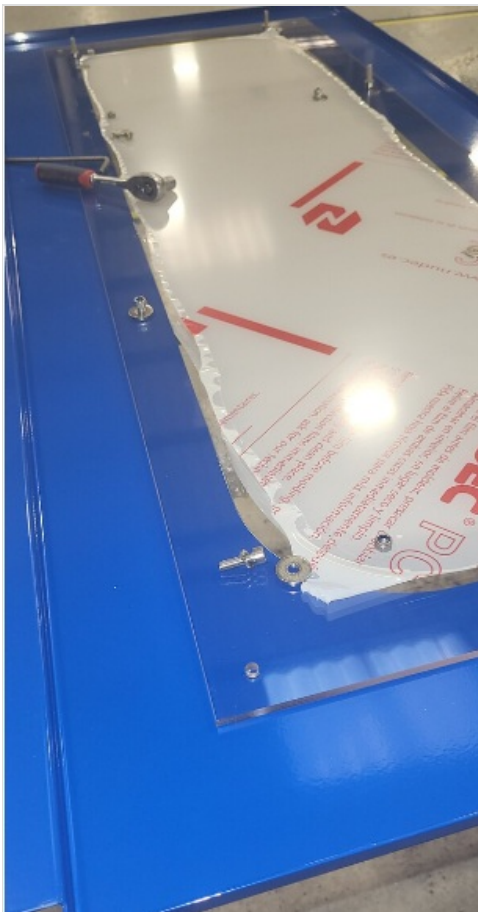


Step 13 - Door Assembly Fit screens

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

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

