


# R0015328 Install Base and Turntable

Details for fitting main turntable assemble to main frame

 Difficulty **Medium**

 Duration **1 hour(s)**

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Step 1 - Unless otherwise stated

Step 2 - Manual lifting Safety

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Comments

## Introduction

### Tools Required

Standard hex key set

PPE Gloves

### Parts Required

R0000558E Bench Assemble Base and Turntable Mk5 x 1

## Step 1 - Unless otherwise stated

All bolts to have Loctite 243 adhesive applied unless otherwise stated

All Threaded Pneumatic connections to have Loctite 570 applied

All bolts to be pen marked once adhesive applied and correct tension added



## Step 2 - Manual lifting Safety

Fitting of turntable base requires a 2 man lift to fit into position

Ensure the following are observed before commencing fitment

Pinch points are present when fitting base. Ensure all handlers are aware of dangers

Ensure handlers are aware of full procedure for fitting

ensure routes are clear of obstacles and work area is safe for lifting

Ensure all components on base are correctly tensioned before commencing lifting

Ensure correct handwear is used for protection

Ensure correct manual lifting method is used by individuals



**Caution  
Pinch point**



**Manual Handling /  
Lifting**

## Step 3 - Fit base into frame

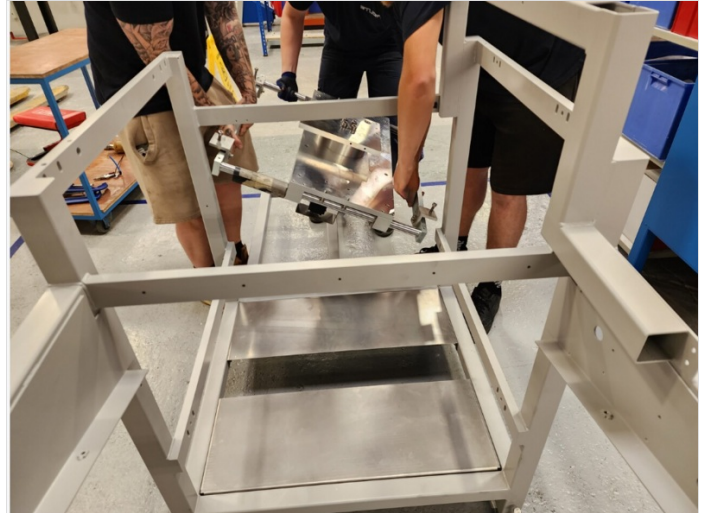
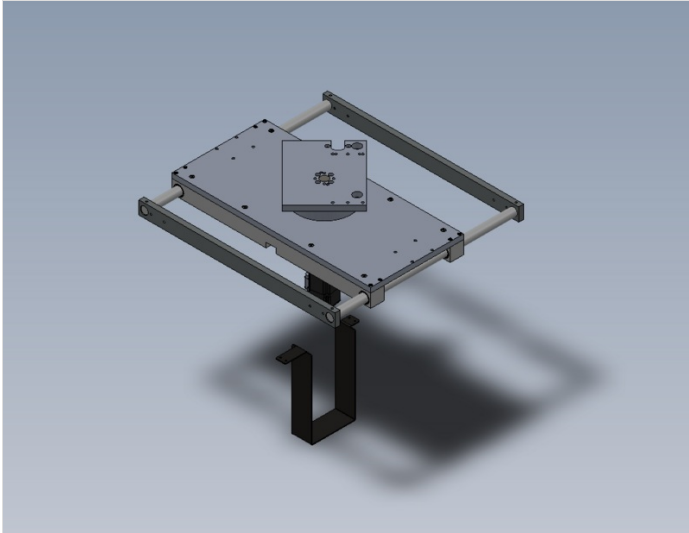
3 person lift

1 Manoeuvre assembly in from side of frame as shown, lifting assembly at an angle

2 when entered frame , lower rear section first onto mounting angles

3 Lower front section onto mounting angles

4 adjust position of frame to align M8 taped holes and slots in frame





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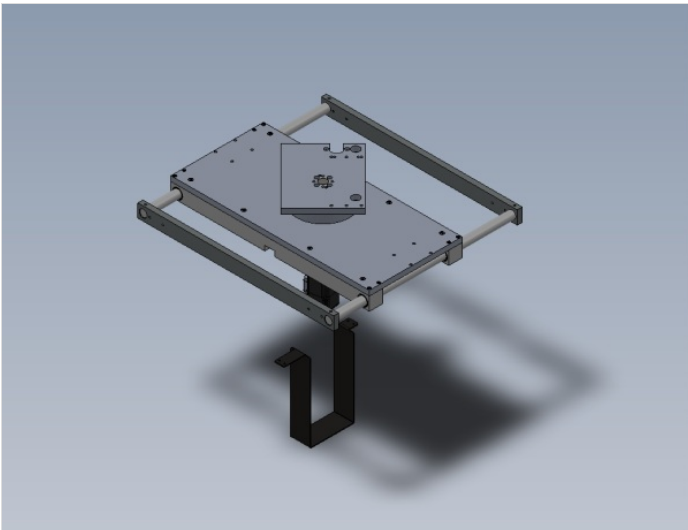
## Step 4 - Captivate

1 Captivate with 1 off for each corner with M8 x 50 socket caps and large and medium heavy m8 washers

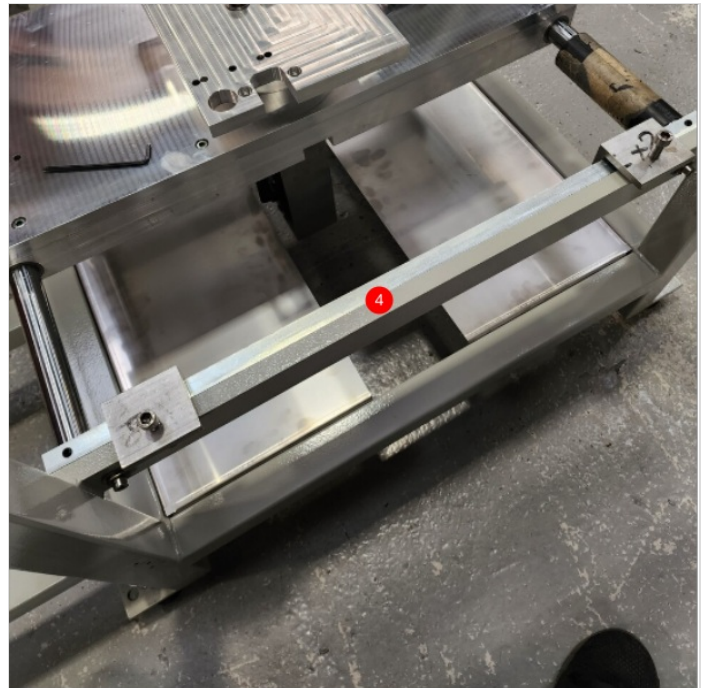
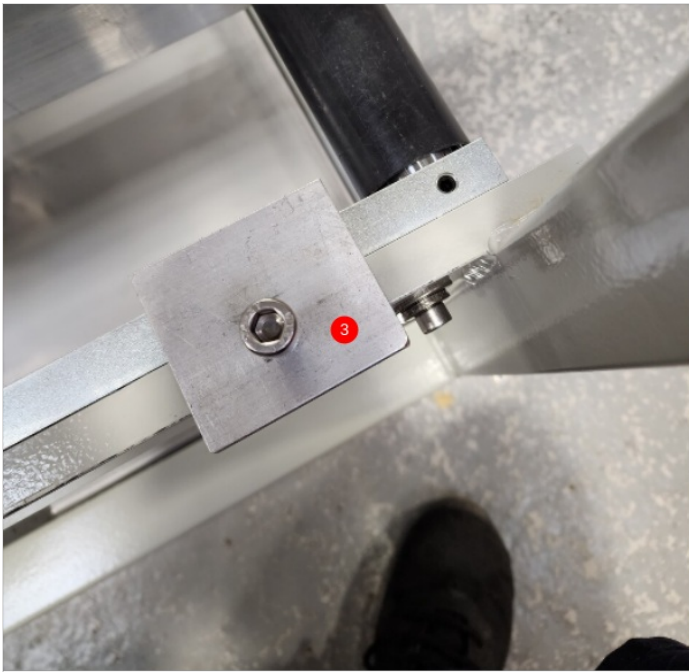
2 Remove tension on front two grub screws in shafts (non dimpled shaft position)

3 Use fitted M8 bolts on rear tie bar to pull to frame

4 Use front m8 socket caps to pull front tie bar to frame









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## Step 5 - Finalise shafts

Add adhesive to all 4 off securing grub screws that hold onto shafts and finalise tension

