


R0015329 Fit Head Spindle Posts

Assembly details for fitment of main saw head and spindle posts

 Difficulty **Hard**

 Duration **3 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set
Standard flat hand file
Emery tape 120
standard hand tap set
Stubby hex key set
Ratchet/hex bit set
Blade flange spanner

Parts Required

D0004002 Webb x 1
D0004003 Top Shaft Block x 2
D0004004 Brace Support Bar (D7451) x 1
D0004157 Motor plate spacer x 3
D0004342 Damper Bracket (5312) x 1
D0007451 Brace Support Bar OH (D4004) x 1
D0015490 Saw Turntable Sensor Flag x 1
D0015491 Saw Turntable Flag Bracket x 1
H0004024 Infeed Clamp Post x 1
H0004025 Outfeed Clamp Post (5302) x 1
H0004510 Shaft 30mm: 540 Saw Stroke x 2
P0000055 Adjustable Damper 200mm (Saw Stroke) x 1
R0000560 Bench Assemble Spindle 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 - Attach brace supports

attach brace supports to turntable plate

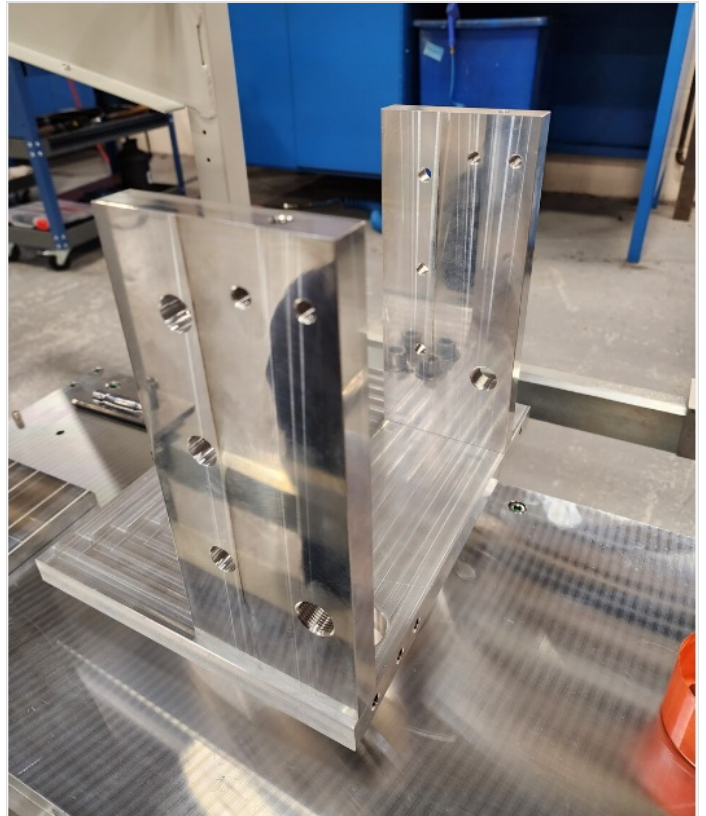
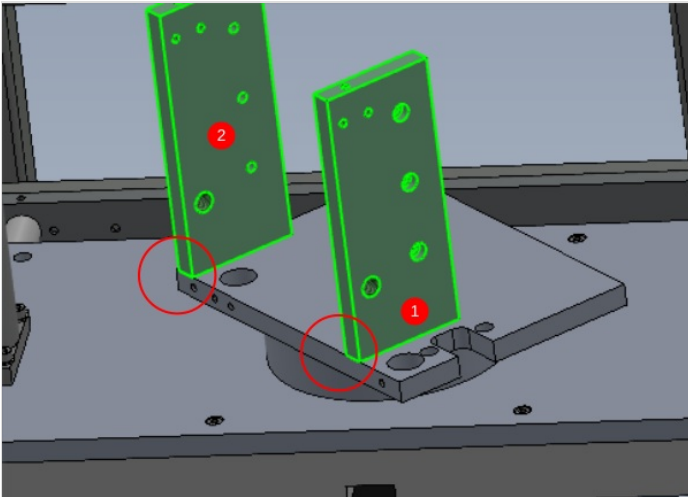
Do not tension brace 2, add adhesive ready for next step

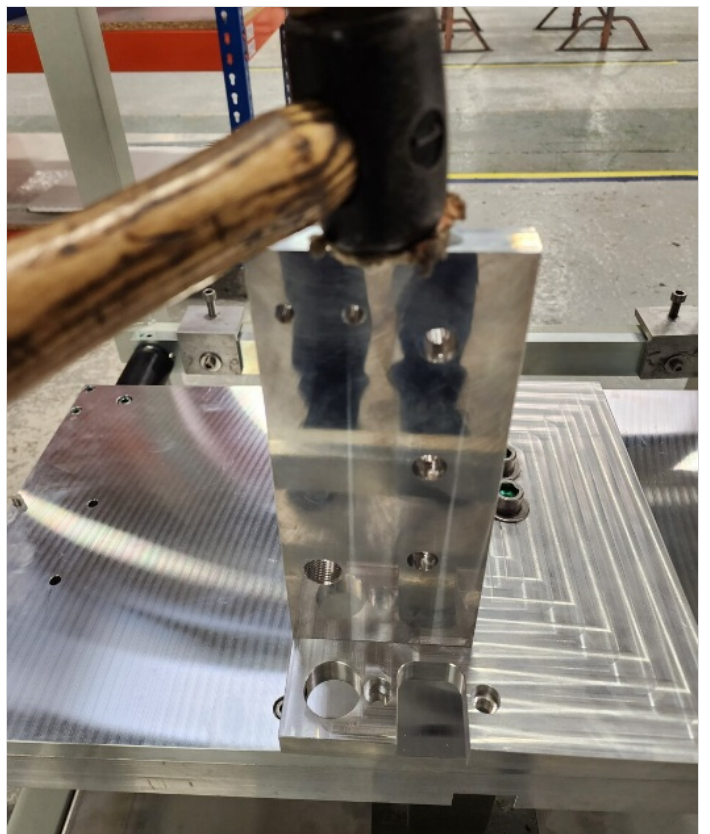
Orientate as shown

 ...Ensure indicated faces are set flush

Use M8 x 35 Socket caps and A form washers.

Use 2 off 8mm x 24mm dowels in brace support 1 that aligns with dowel holes in turntable base





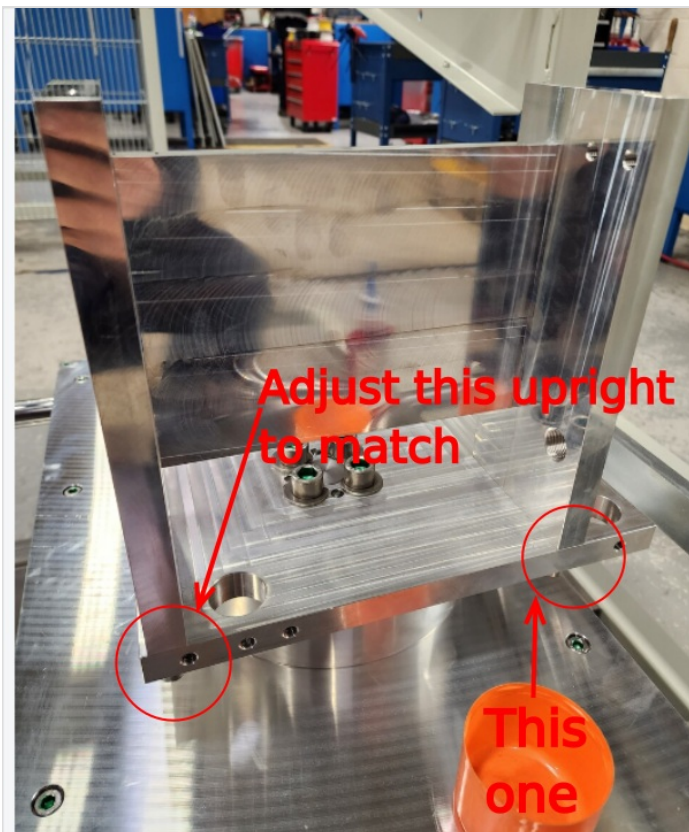
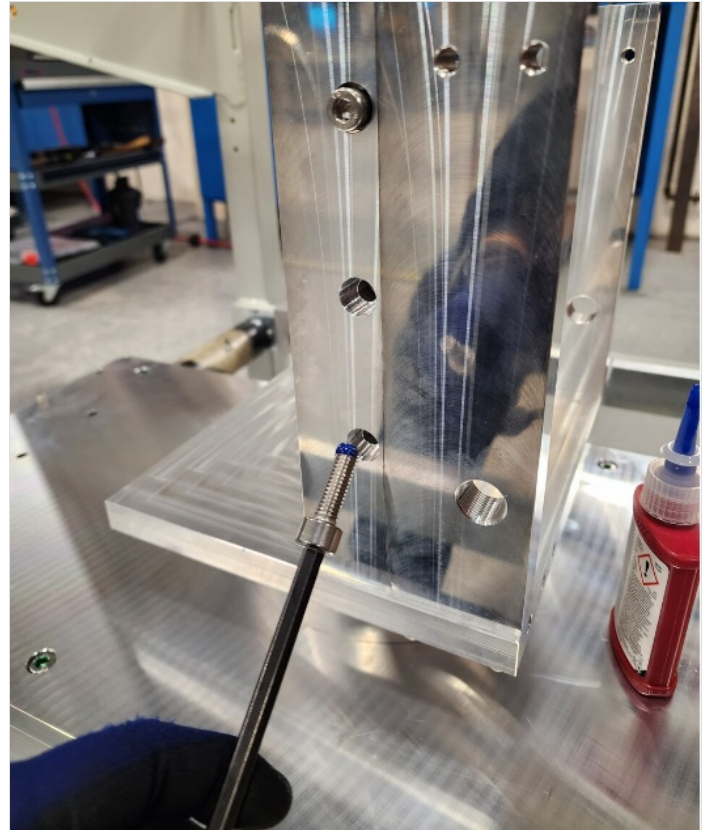
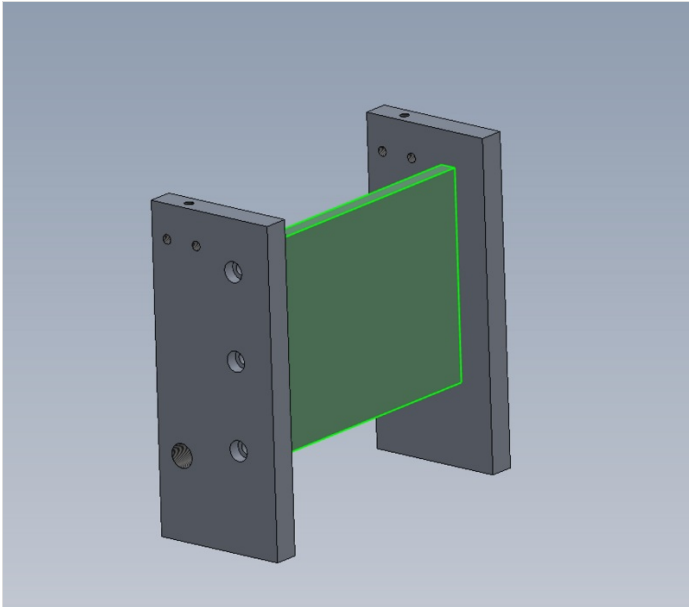
Step 3 - Fit web

Fit web using 6 of M8 x 25 socket caps

Use to set pitch of brace supports, Tension dowed upright side first

Adjust to set indicated faces flush

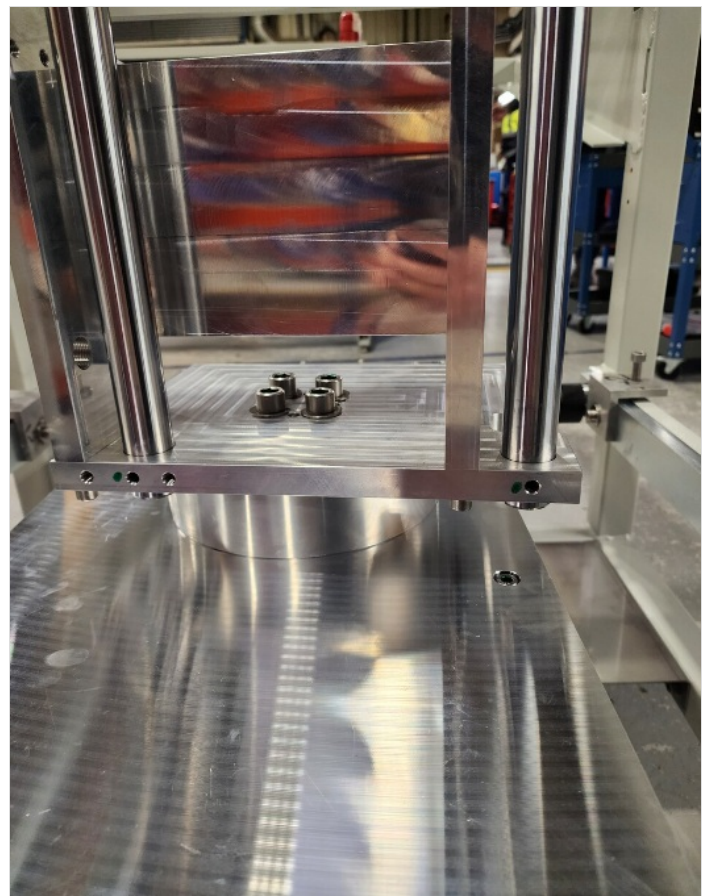
Finalise fasteners on brace supports and web



Step 4 - Fit shafts

Clean shafts with FE10 solvent

Fit shafts to turntable plate using M8 x 12 KCP grub screws, do not add final tension or adhesive at this point



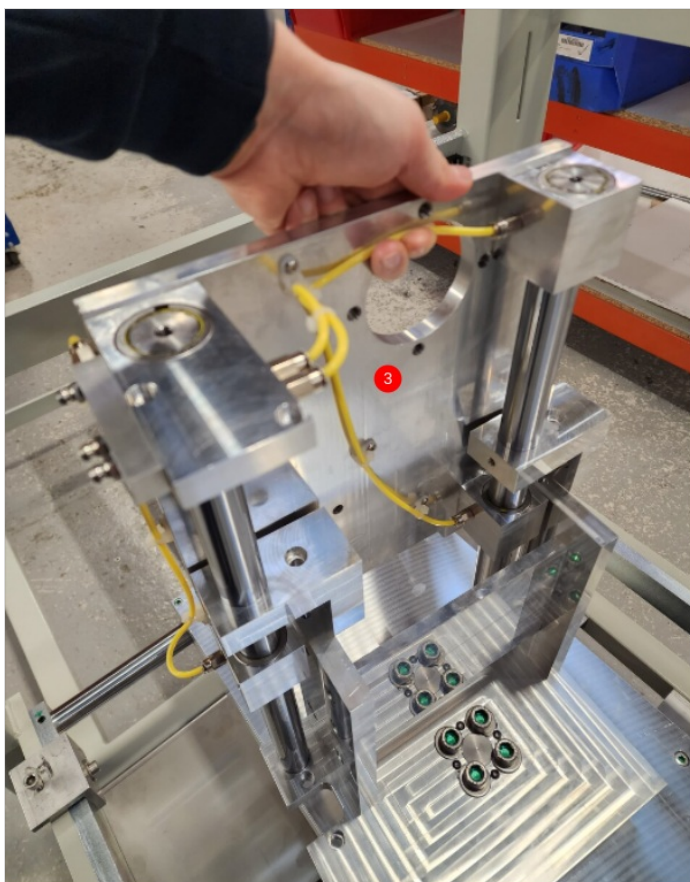
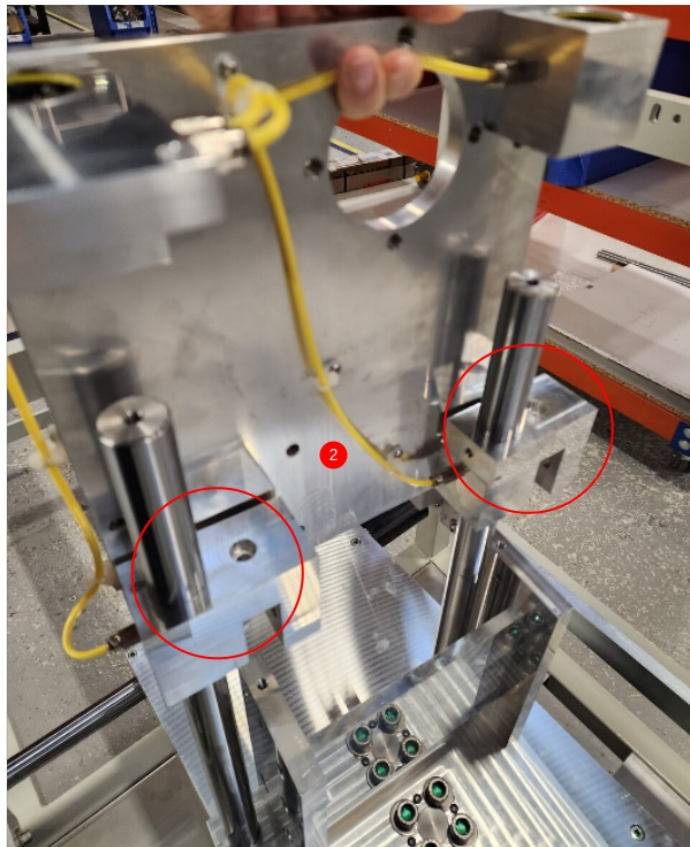
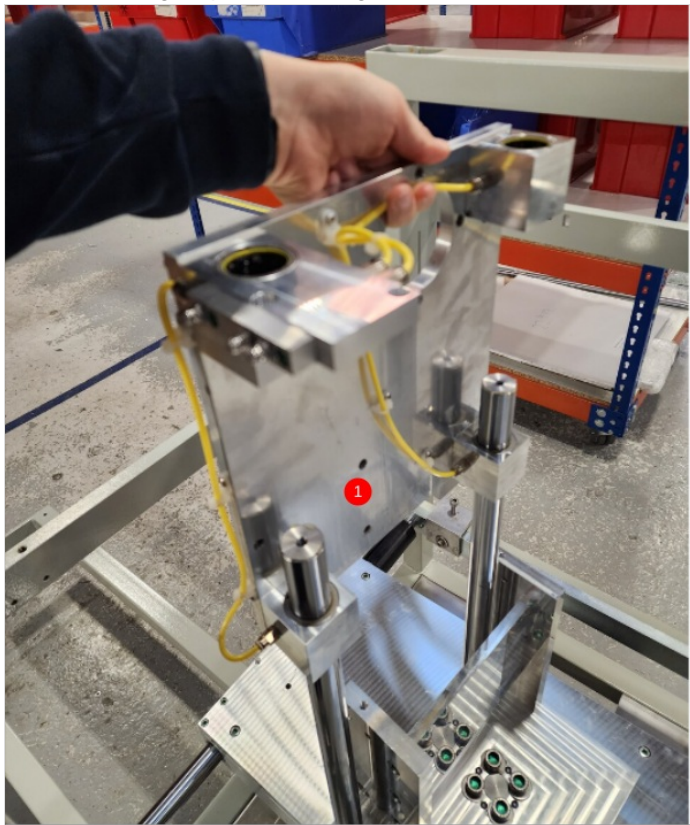
Step 5 - Fit pre assembled head

⚠ ...Ensure bearing seals are not damaged during the fitting of the upstroke plate assembly. Ensure bearings are aligned correctly

1 Position 1st set of bearings over shafts

2 Position shaft tie blocks over shafts as shown

3 Lower and align top set of bearings



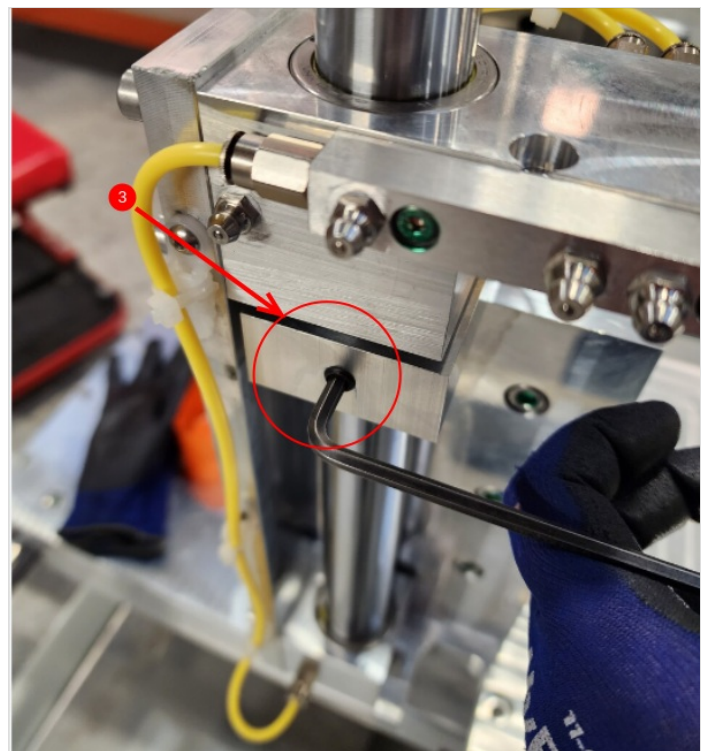
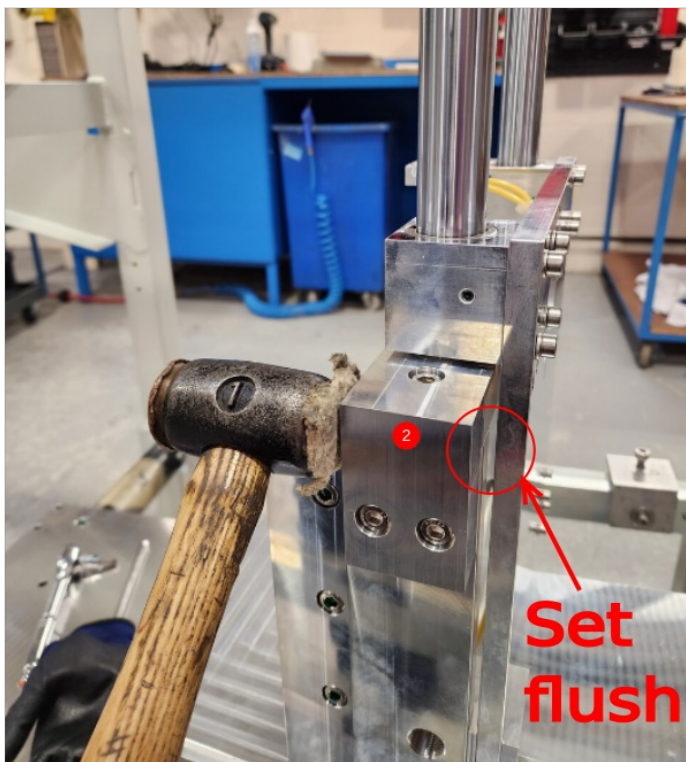
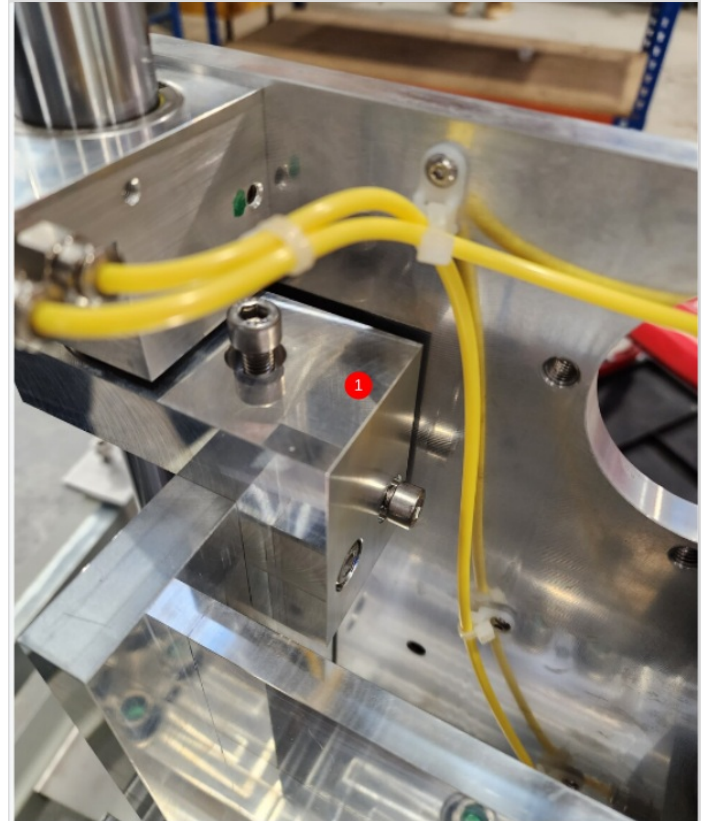
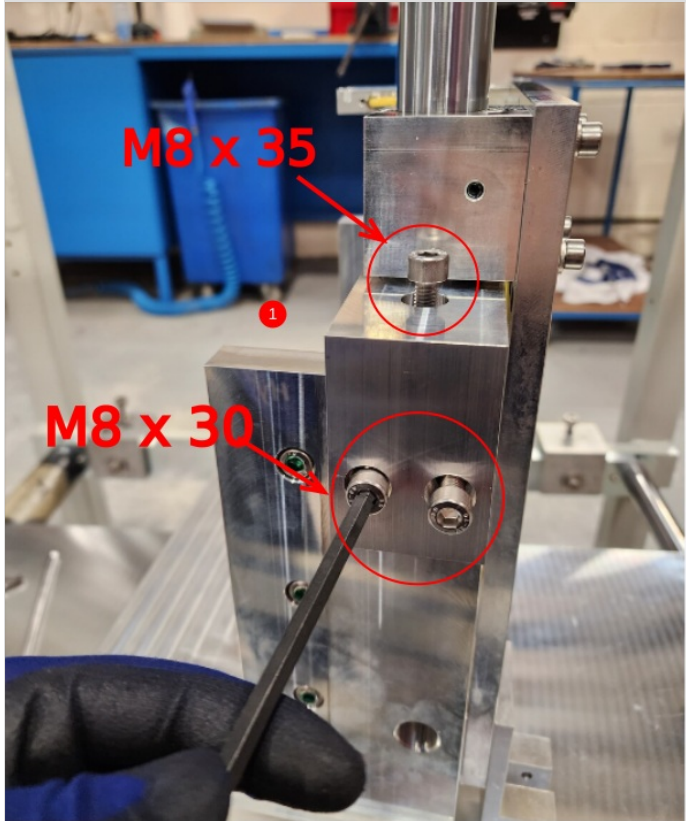
Step 6 - Fix top shaft blocks

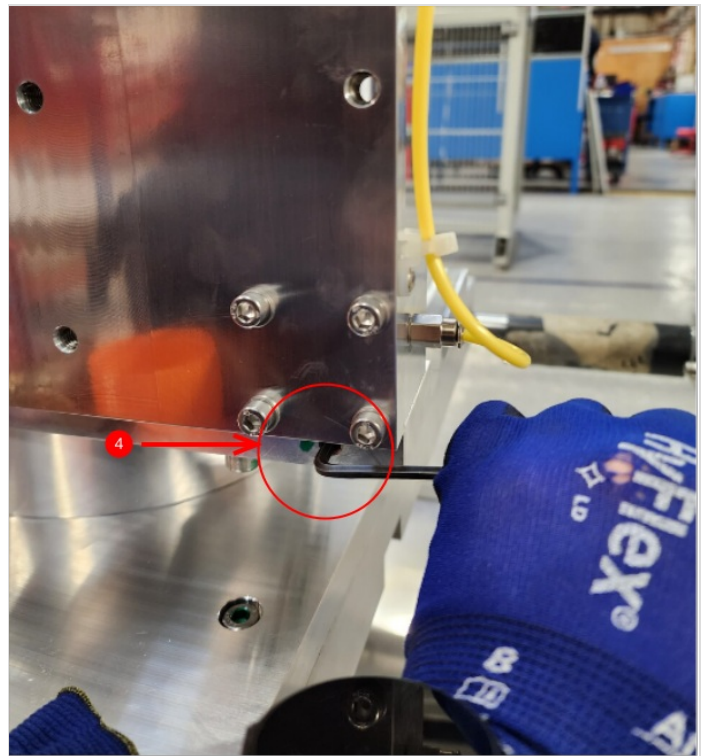
1 Use 4 off M8 x 30 and 2 off M8 x 35 to fix blocks

2 Adjust both blocks to be level on indicated face

3 Fit M8 x 12 Kcp grubscrew 2 off

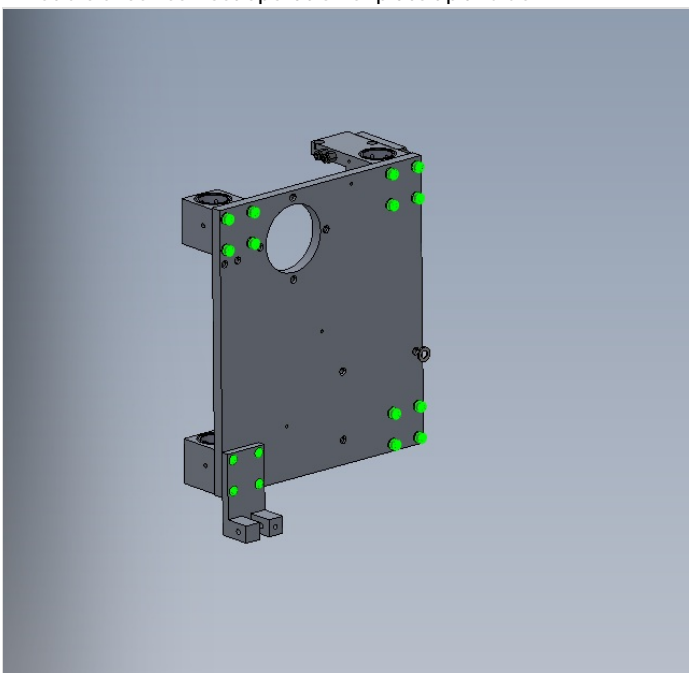
4 Finalise shaft grubscrews 2 off

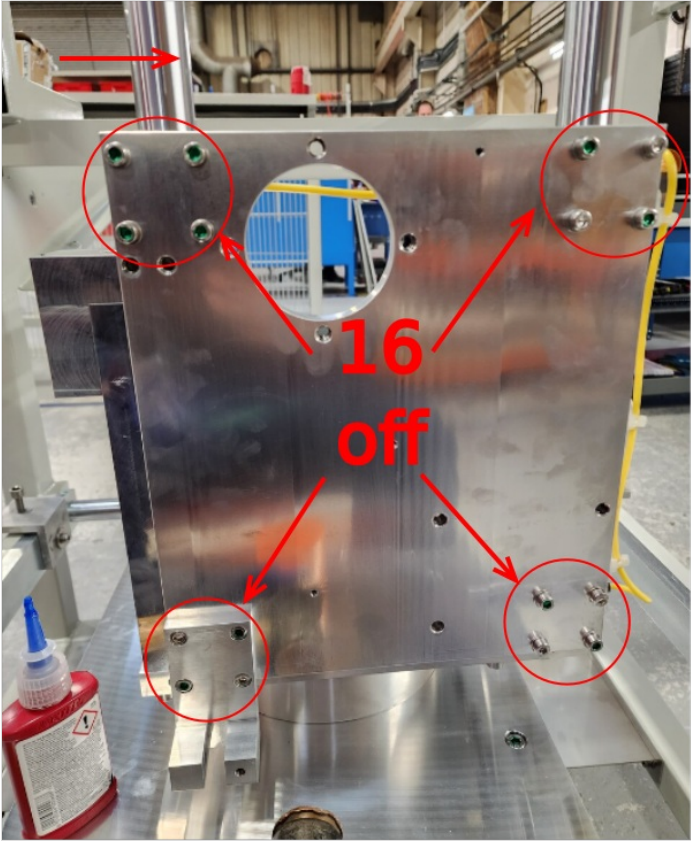


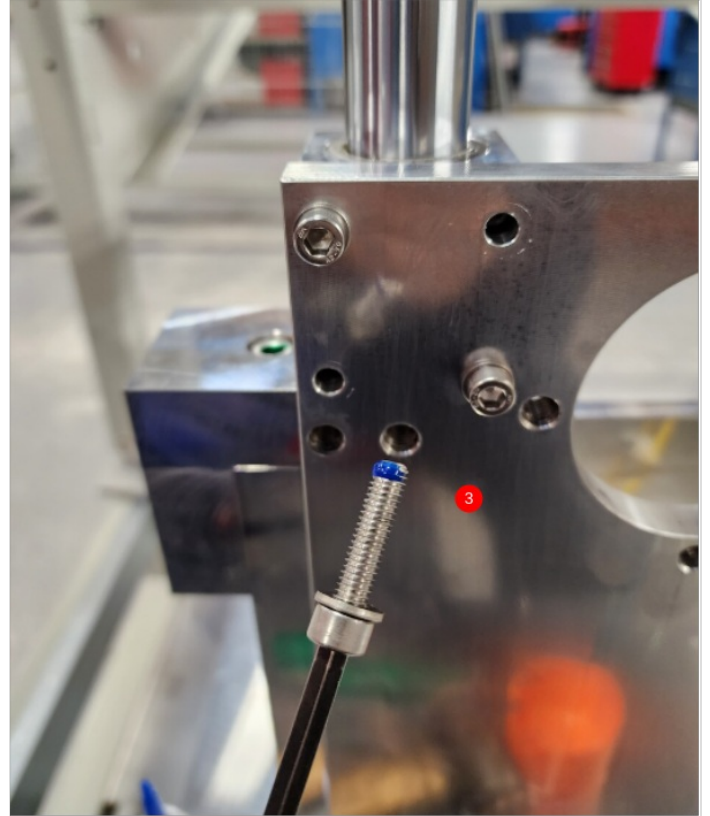
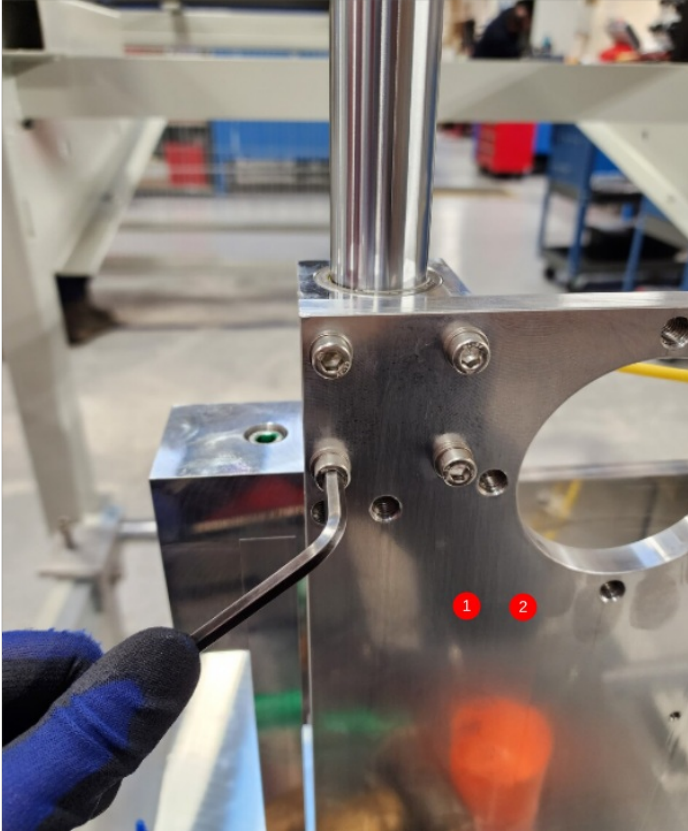


Step 7 - Finalise bearing blocks

- 1 Ensure all 16 off fasteners are slightly loose to allow plate to align correctly
- 2 Add light pressure to all 16 off fasteners , move plate up and down to check free running with consistent pressure required
- 3 Remove each individual fastener and add loctite 243, and apply final tension
- 4 Double check correct operation of plate up and down







Step 8 - Fit spindle

1 Slide off taper lock pulley from spindle assembly and remove flanges and bolt for saw blade

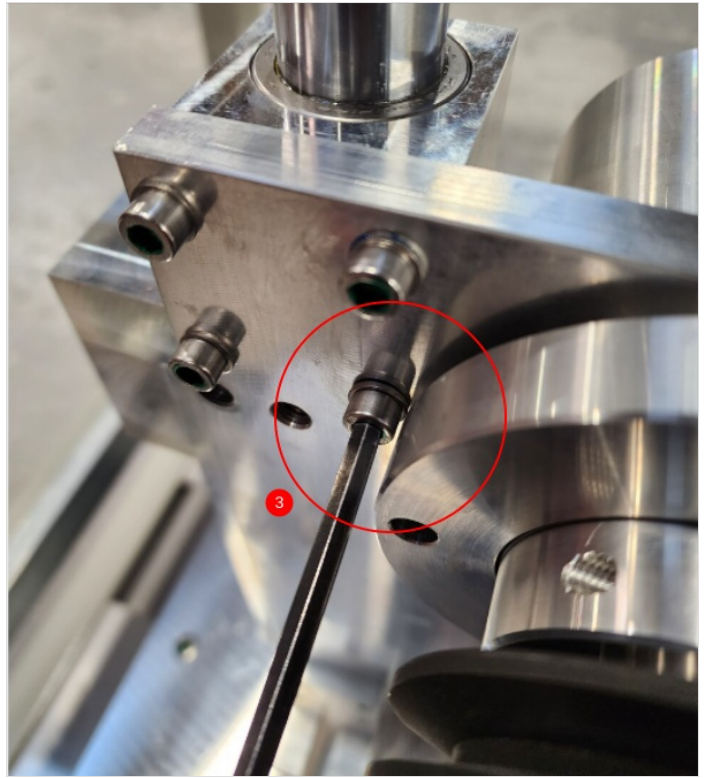
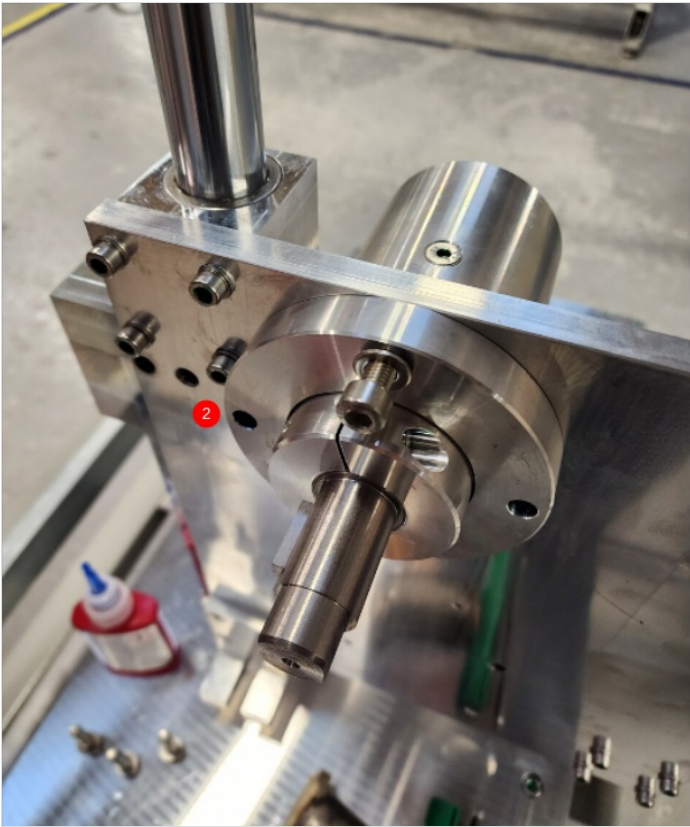
2 Position spindle into plate as shown . Use countersunk bolt as reference for alignment . Use M8 x 30 socket cap to help align mounting holes when fitted .

⚠ ...Countersunk bolts on spindle assembly may impede fitting into plate. If required, countersunk bolts can be dressed with a file to achieve clearance

3 Check clearance on washer shown. If washer interferes with spindle, remove washer

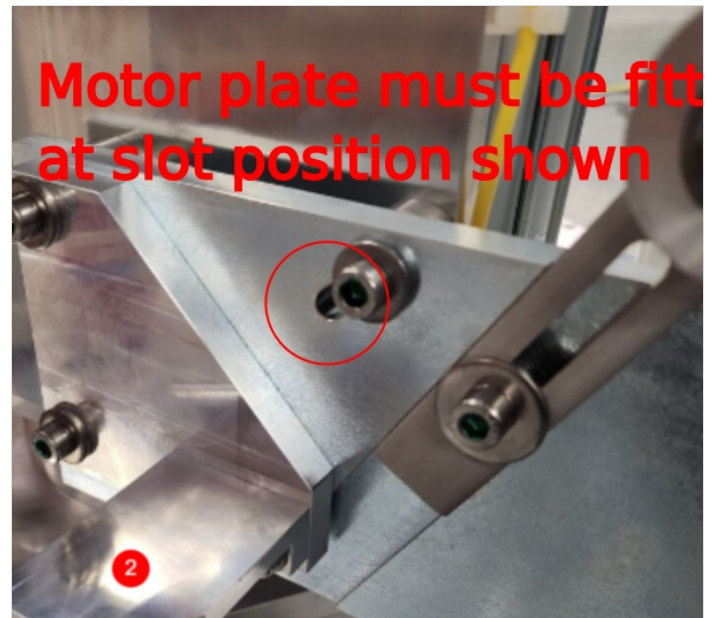
4 Remove 1 off locating M8 socket cap. Add 4 off M8 x 30 socket caps and A form washers and finalise

5 Refit taper lock pulley to spindle assembly




Step 9 - Quality instance

Motor plate must be fitted into the slot position shown in the next step to allow correct rotation of the saw head

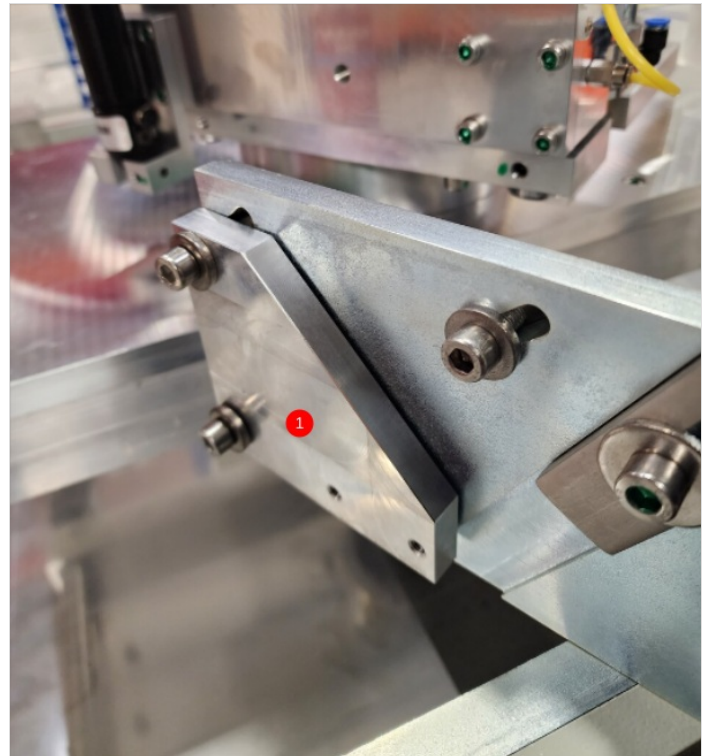


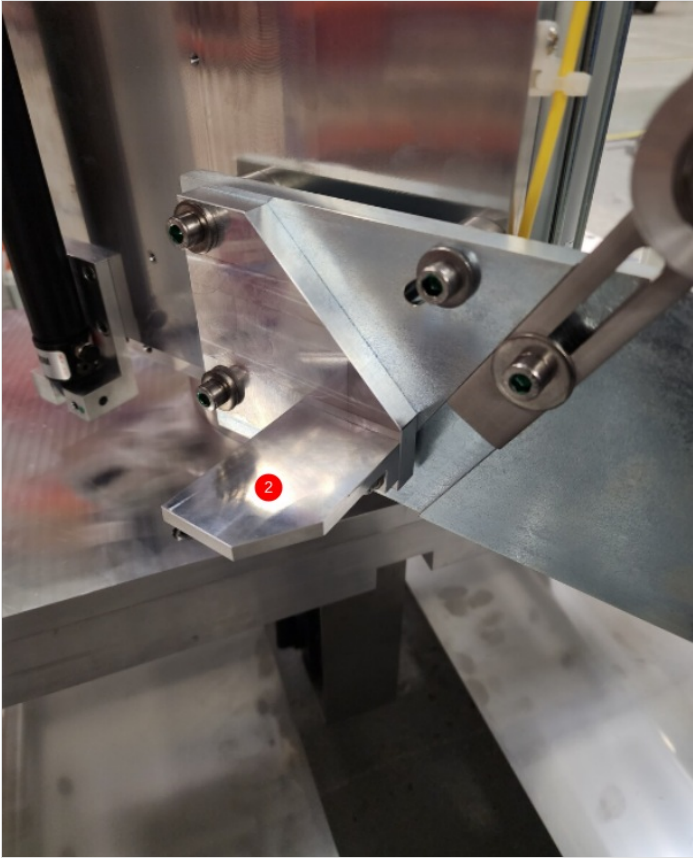
Step 10 - Fit motor plate and SR flag bracket

1 Fit motor plate to upstroke plate, combining part D0015491 saw turntable flag bracket and using D0004157 motor plate spacers between upstroke plate and motor plate. Use 2 off M8 x 50 socket caps, 1 off M8 x 40 socket cap and 3 off M8 motor plate washers

 ...Ensure motor is fixed at the top of slot adjustment as shown and fitted parallel and level

2 Attach Sr datum flag as shown using 2 off M6 x 20 socket caps and M6 A form washers





Step 11 - Fit saw blade

1 Fit first flange to spindle and fit saw blade . Ensure blade is orientated correctly

2 Fit front flange, and locking bolt and washer. Apply medium Tension with 24mm spanner and blade flange spanner

