

R0015330 Fit 1st stage Ejector and Level Base

Alignment details for base and 1st stage ejector

 Difficulty **Hard**

 Duration **4 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set

300mm engineers level

Copper /hide hammer

Parts Required

D0004014 Ejector Tie Bar x 2

D0004328 Rod Base (5303) x 1

H0004629 Shaft 20mm: 754 Ejector x 2

R0000570B Bench Assemble 1st stage Ejector and Level Base 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 - M6 rivnuts

Check frame has M6 rivnuts installed

If not present install with riv nut applicator

Riv nuts must be flush with box section face



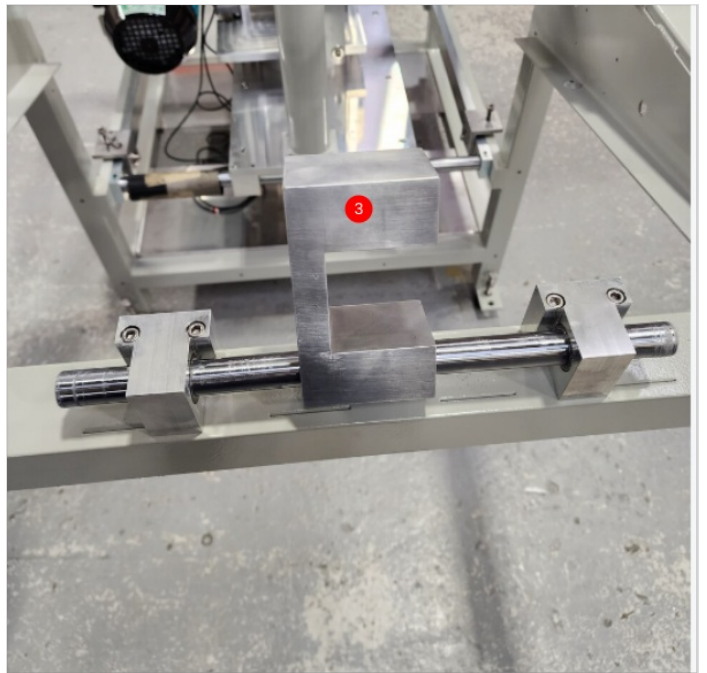
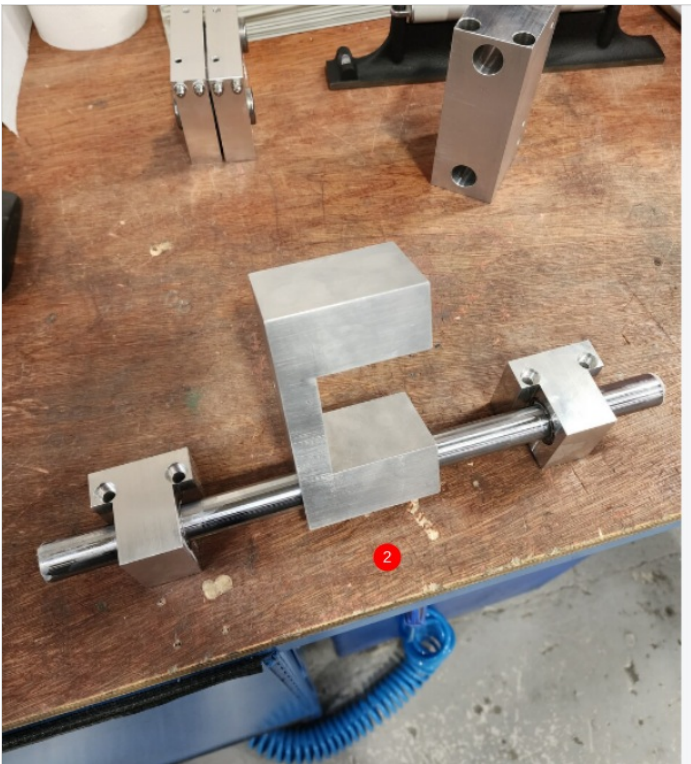
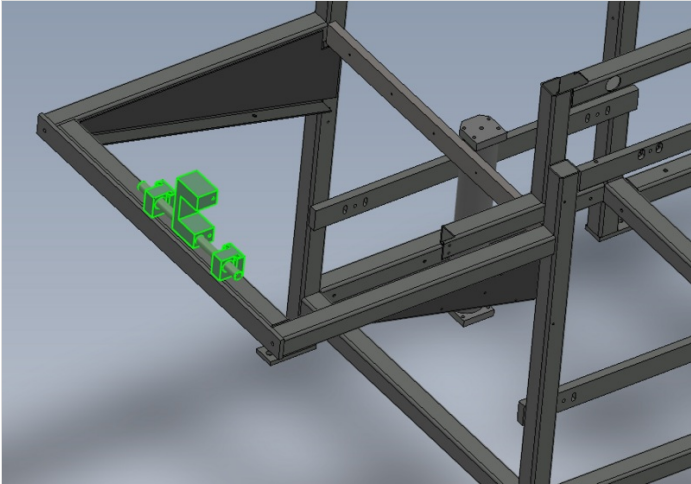
Step 3 - Attach eject support

1 Grease eject support blocks

2 Assemble with pre built support block

3 Fix to frame with M6 x 60 socket caps . Do not use adhesive at this point

4 Check for smooth operation

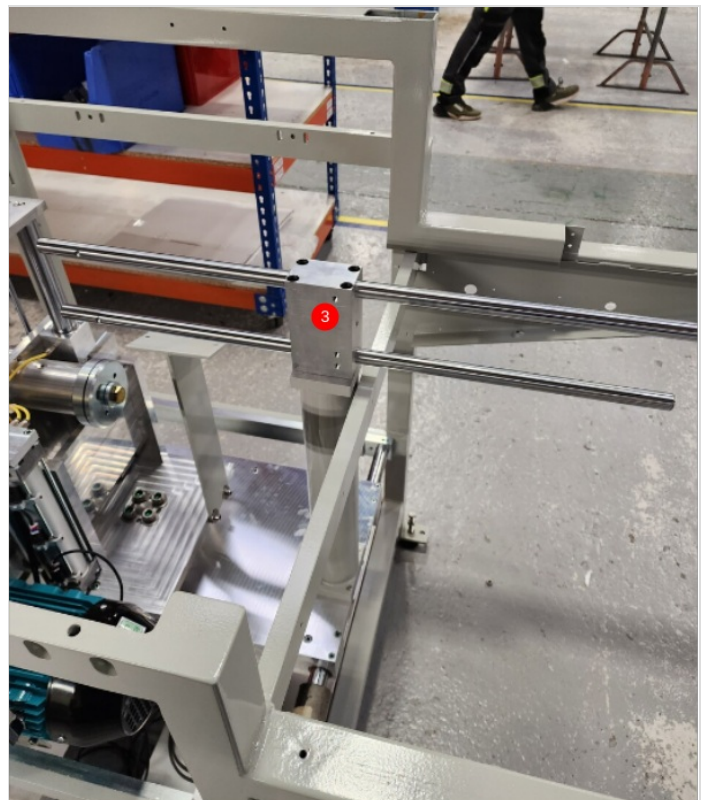
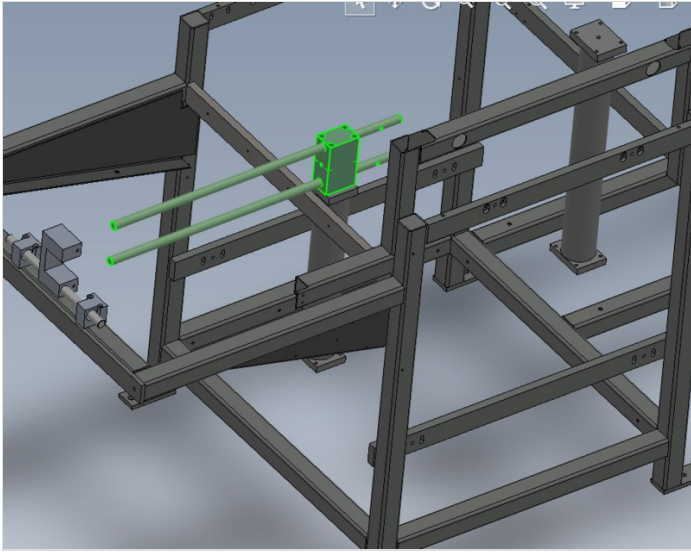


Step 4 - Attach Rod base

1 Clean shafts with Fe solvent

2 Insert shafts into rod base as shown , orientate dimples on shafts as shown in relation to rod base holes

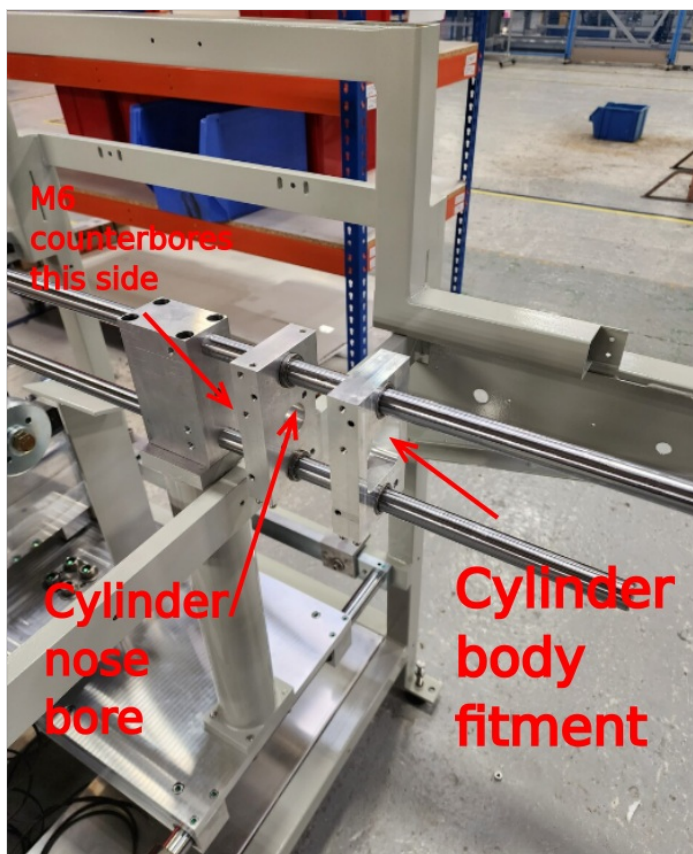
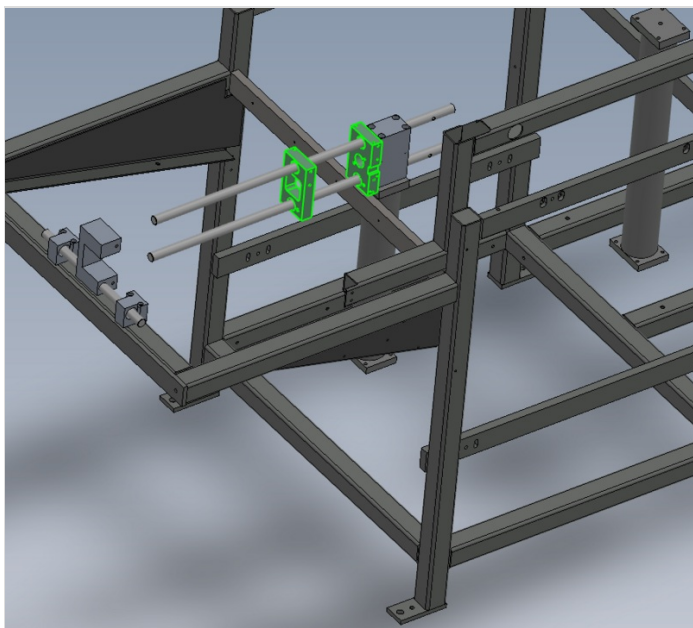
3 Fix to eject support post as shown using M8 x 80 socket caps 4 off. Do not use adhesive



Step 5 - Fit eject bearing blocks

Fit pre built bearing blocks to eject shafts

Ensure correct orientation as shown



Step 6 - position eject shafts

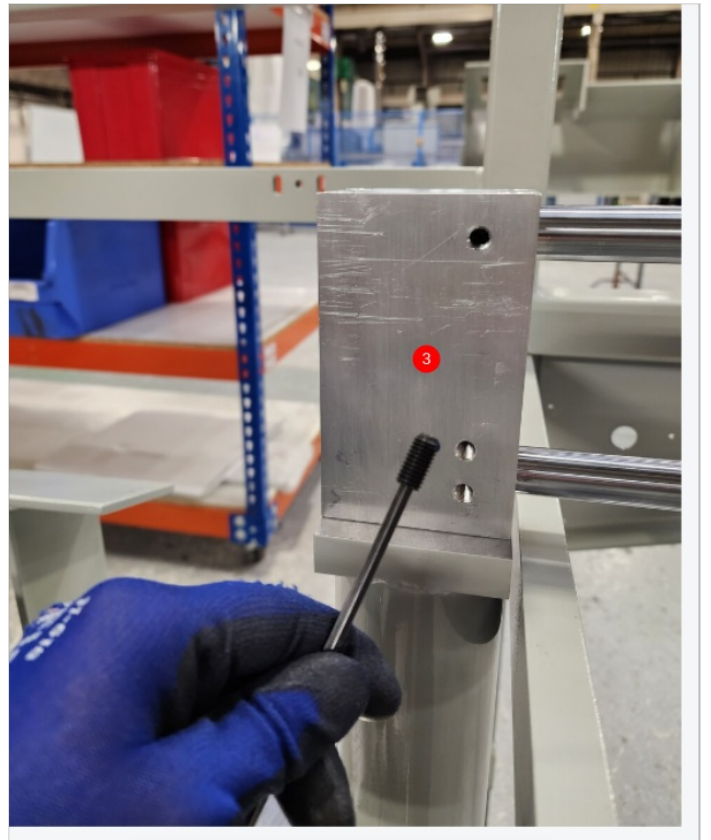
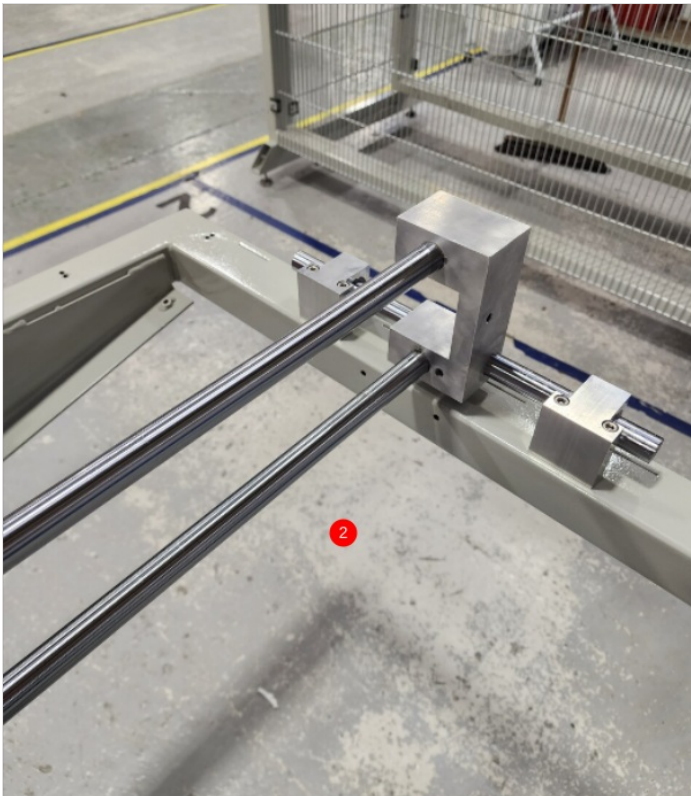
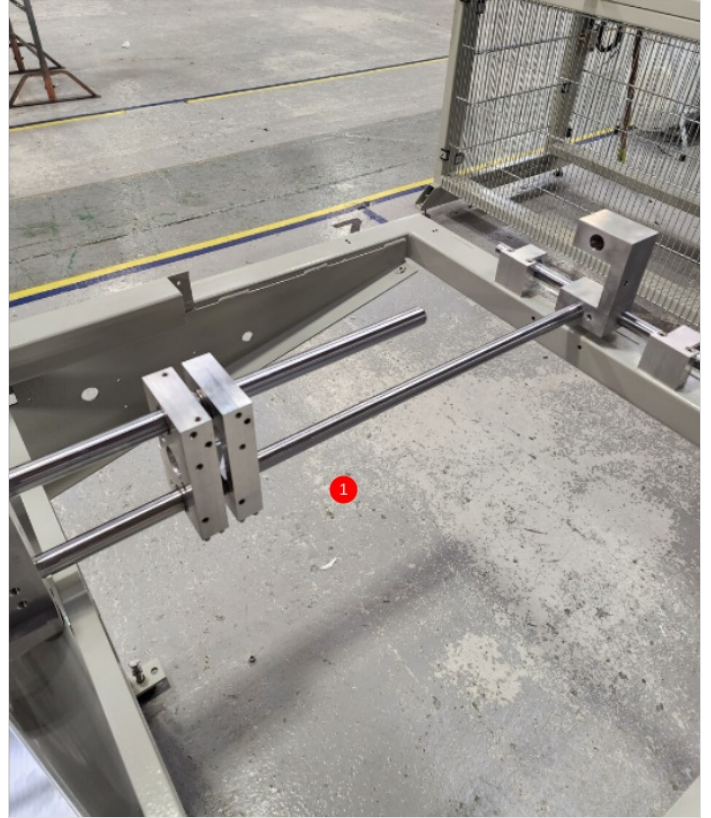
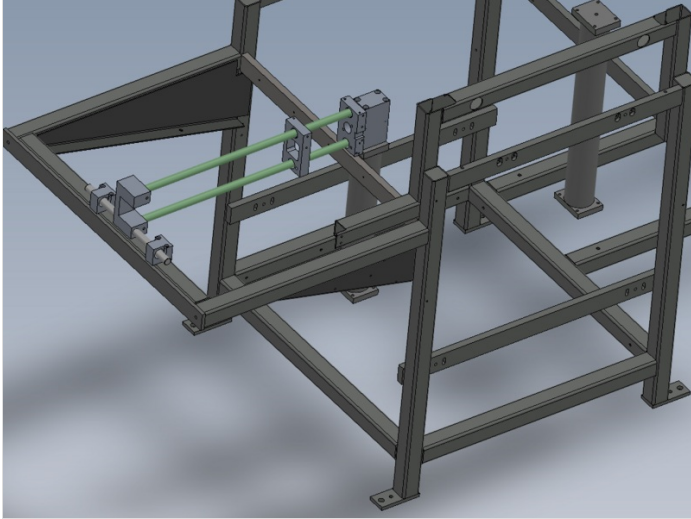
1 slide lower shaft into eject support block as shown , ensuring dimple aligned with M8 hole in rod base

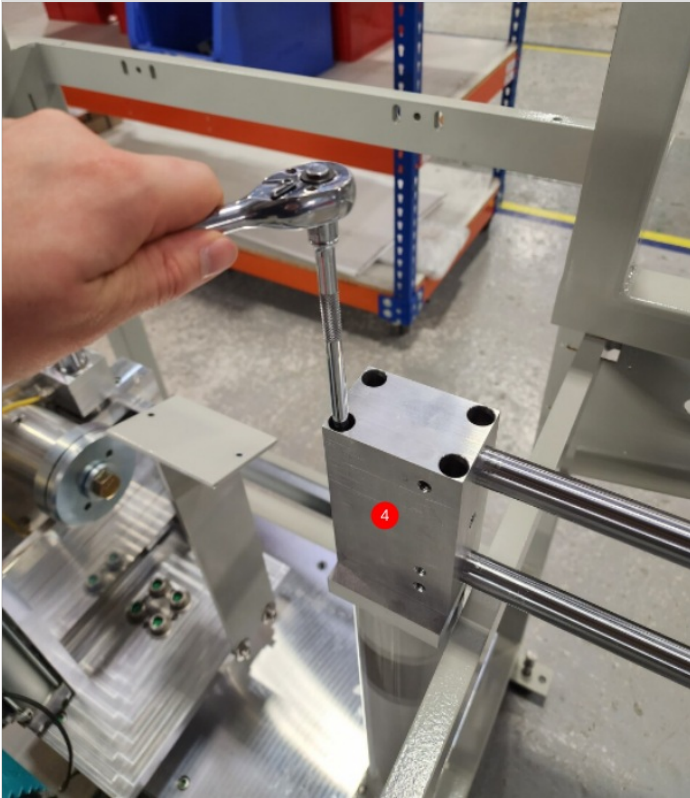
2 Slide into position upper shaft ensuring dimple in shaft is aligned with rod base M8 hole

3 Add 2 off M8 x 16 kcp grub screws to captivate shafts into rod base. Use loctite 243 on grub screws

4 Apply medium pressure to fixings in rod base

5 Add 2 off M8 20 kcp grub screws to eject support under light tension. Do not add adhesive



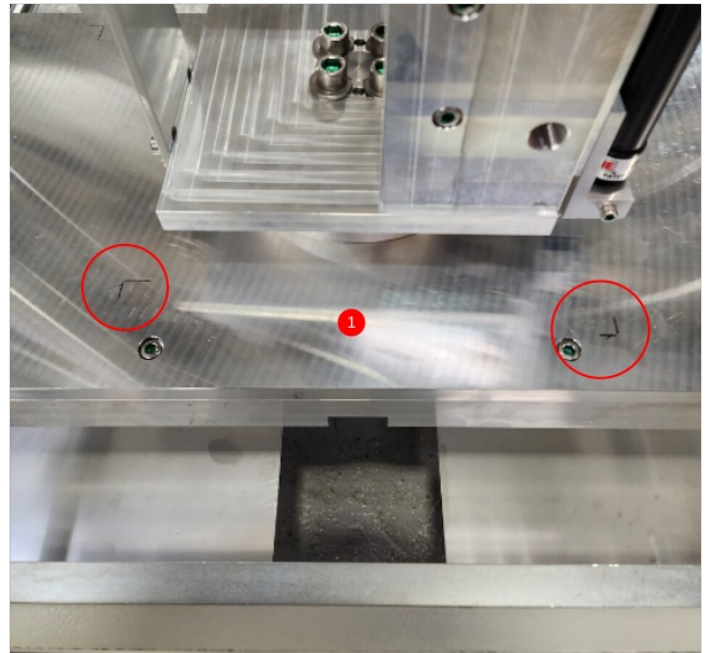
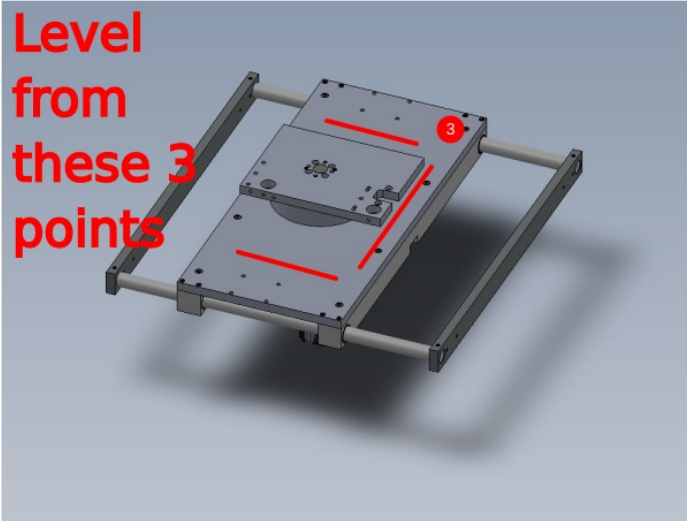


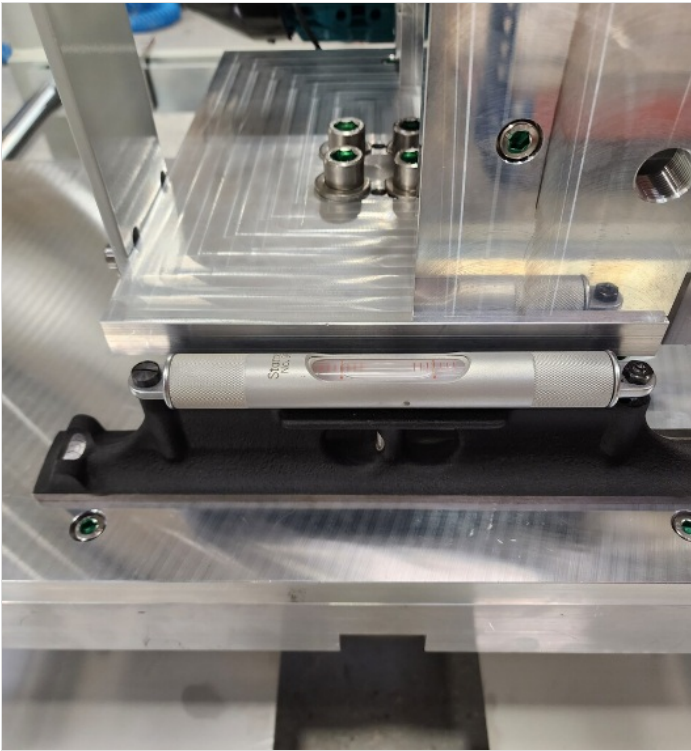
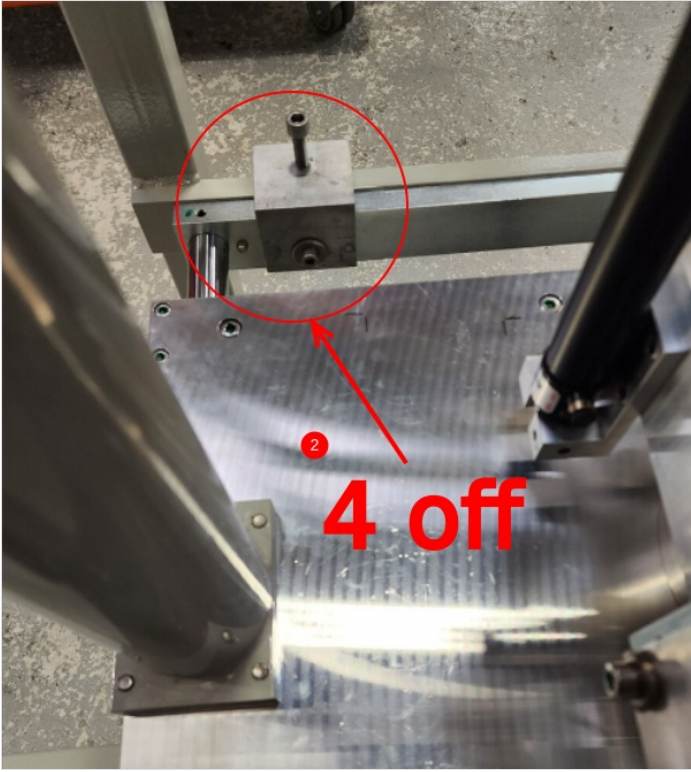
Step 7 - Level base

1 Use engineers level at indicated points to set base level. Use marker pen to outline level positions, so consistent point is used each time the level is moved to a new position

2 Adjust using jacking screws on support brackets

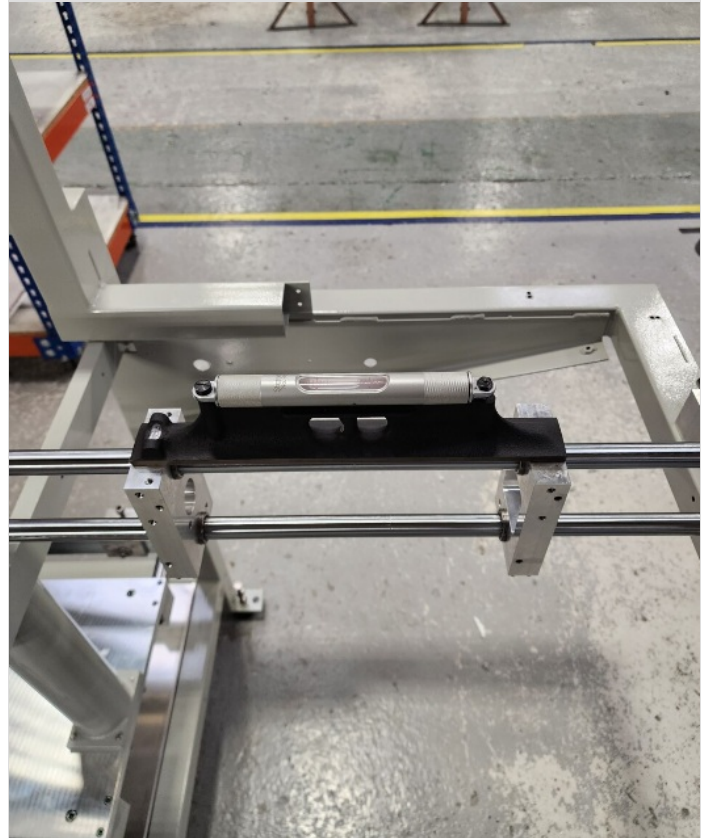
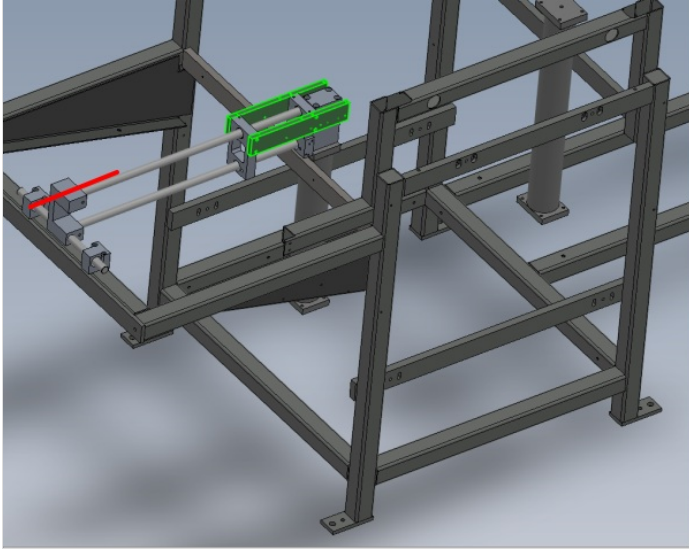
3 Ensure all 3 indicated points are set level





Step 8 - Check end plate level

End block level should be checked for level and adjusted to be correct

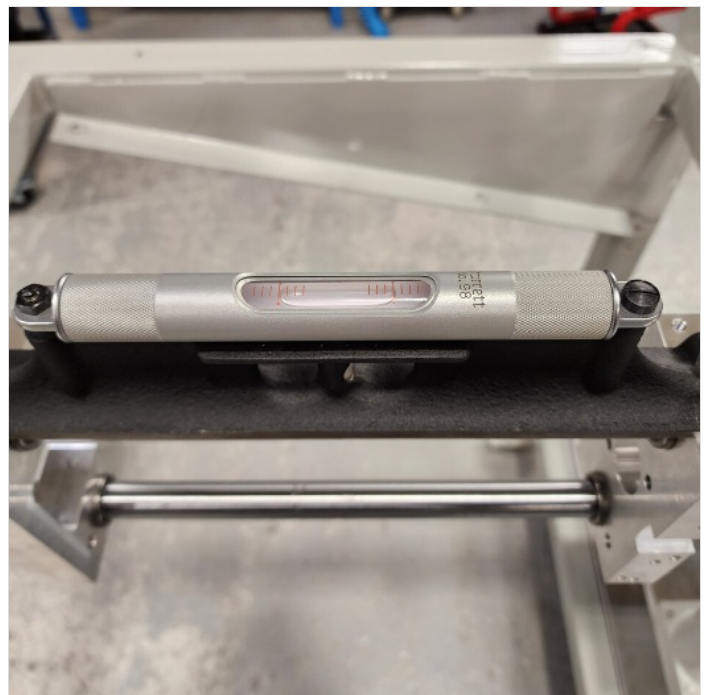
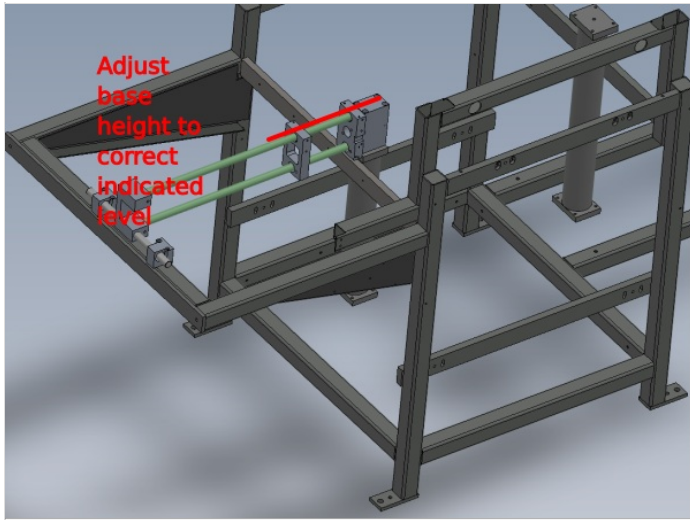


Step 9 - Level eject shafts

1 Use engineers level to check level of eject assembly at 3 points of movement.

2 Adjust base evenly to maintain base level , to adjust eject shafts level

3 Once correct height of base is achieved to set eject shafts level, and a discrepancy is noticeable on level of eject shafts at 3 positions , recheck previous step for being set level



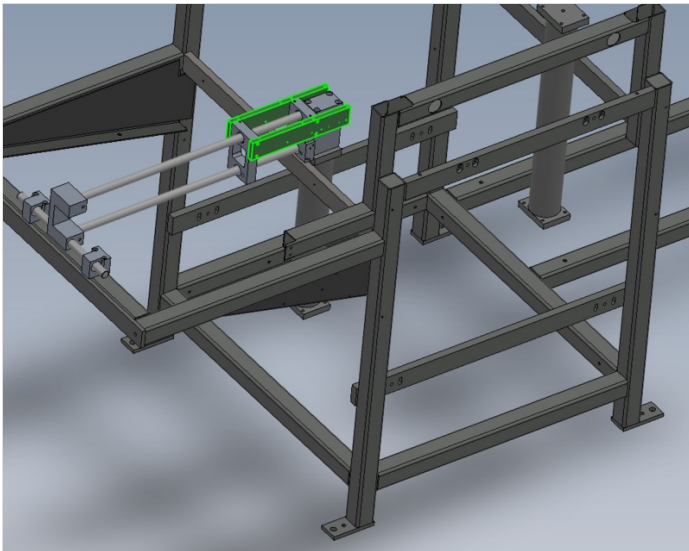
Step 10 - Finalise Grubscrews

Finalise grubscrews in support block individually



Step 11 - Fit ejector tie bars

Fit ejector tie bars to ejector bearing blocks, using 8 off M6 x 25 set bolts and A form washers. Only apply light tension and do not use adhesive

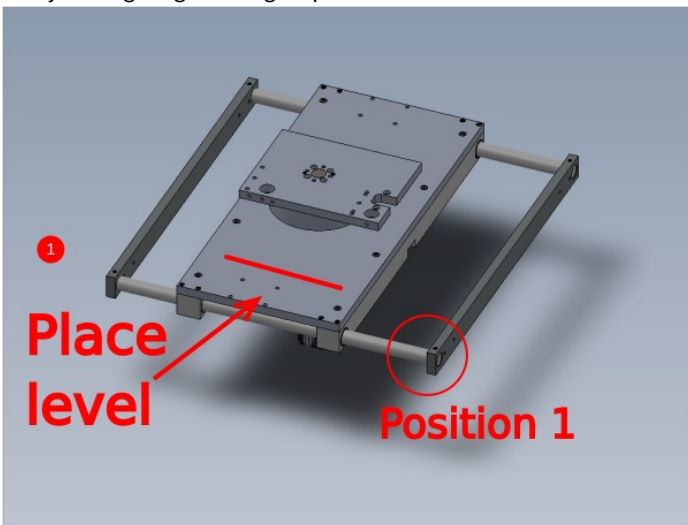




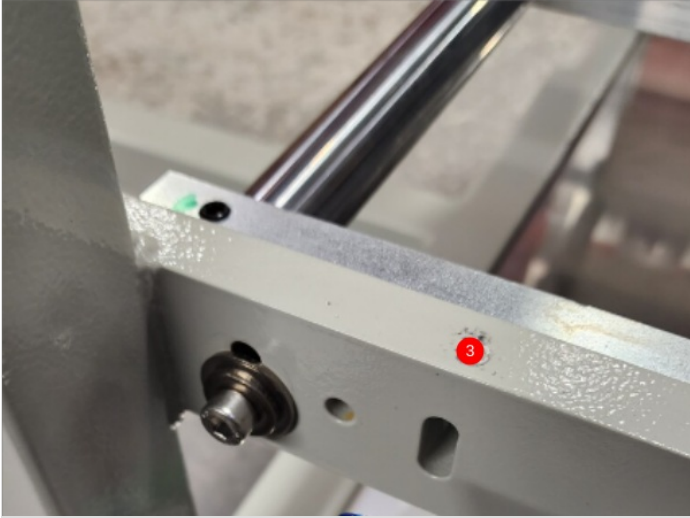
Step 12 - Finalise position of base Point 1

Adjusting brackets should be removed individually once all settings are complete

- 1 Place level on base on marked points to use to identify if base moves position when final tension to holding bolts is added
- 2 Add final tension to fitted M8 socket cap
- 3 Remove Support bracket
- 4 Adjust level if moved. Use copper hammer to impact shaft in direction required to adjust level
- 5 Add and finalise M8 socket cap with same washer configuration as previous fitted M8
- 6 Remove first M8 fastener, add Loctite 243 and add final tension
- 7 Adjust height again using step 4 if level indicates movement has occurred when fitting second fastener

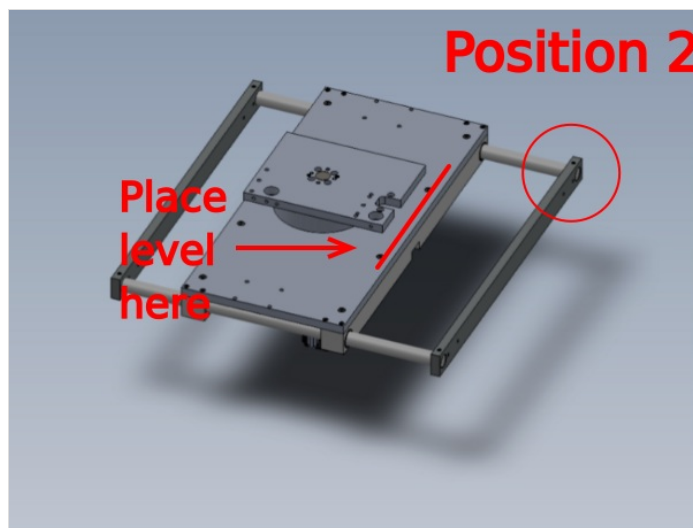






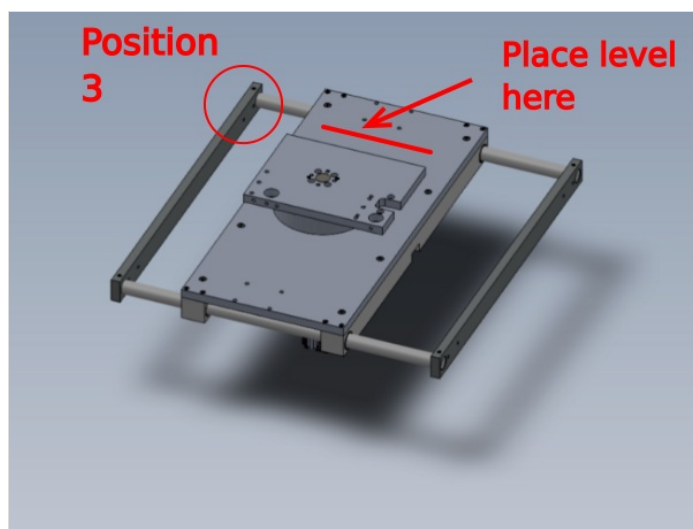
Step 13 - Finalise position of base Point 2

Repeat step 11 at these points



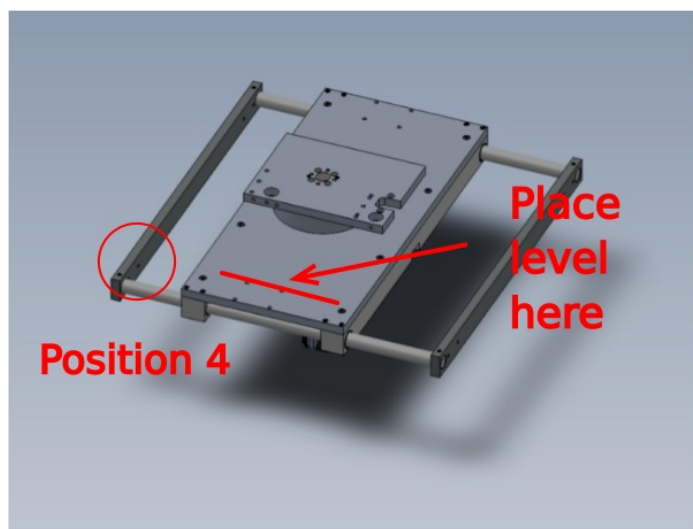
Step 14 - Finalise position of base Point 3

Repeat step 11 at these points



Step 15 - Finalise position of base Point 4

Repeat step 11 at these points



Step 16 - Check all settings

Recheck all previous settings stated in this procedure, and ensure all have met and retained specified settings

Supervisor sign off required

