


R0015332 Mount Backfences and Align

Fitting and setting details for back fences

 Difficulty **Hard**

 Duration **2 hour(s)**

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Comments

Introduction

Tools Required

Standard hex key set
1 Meter straight edge
Feeler gauges
engineers square
Shim pack

Parts Required

R0000559 Bench assemble machined parts
R0015326 Bench Assemble Roller Backfences

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

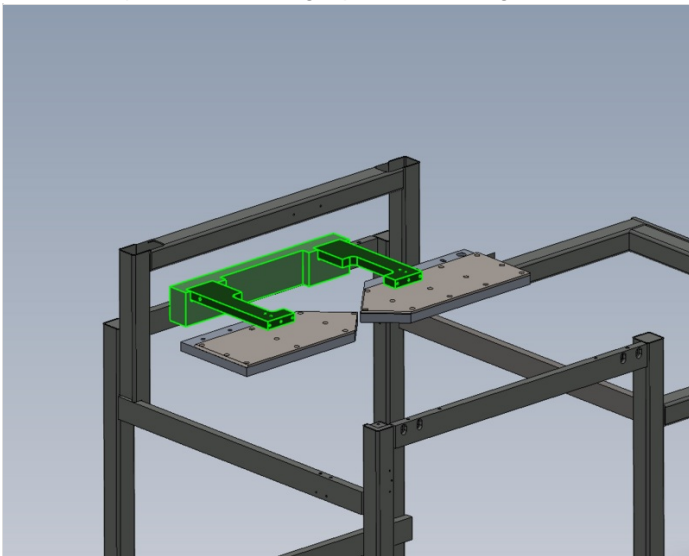


Step 2 - Attach backfence support

Attach pre machined back fence support to main frame

Use 4 off M8 x 25 socket caps , do not apply adhesive

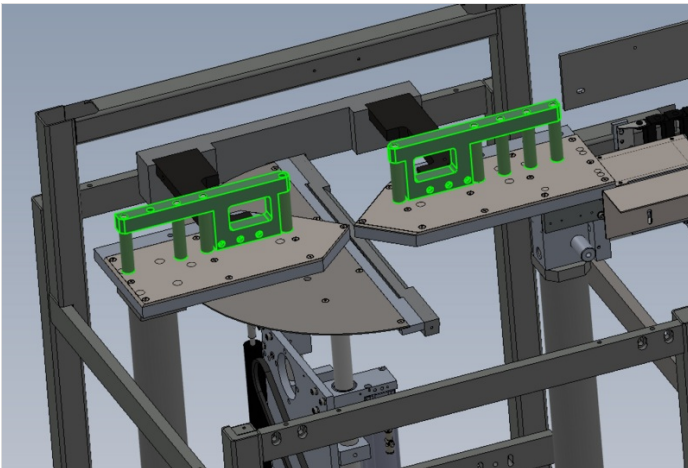
Set assembly to maximum height position in fixing slots





Step 3 - Attach roller fences

Attach pre build roller fences to backfence support bar using M6 x 35 socket caps . Do not apply adhesive





Step 4 - Set squareness

1 Use engineers square to check squareness of roller fences to cut tables. Check at multiple points


2 Identify movement required to adjust square.

Gap between square and roller:

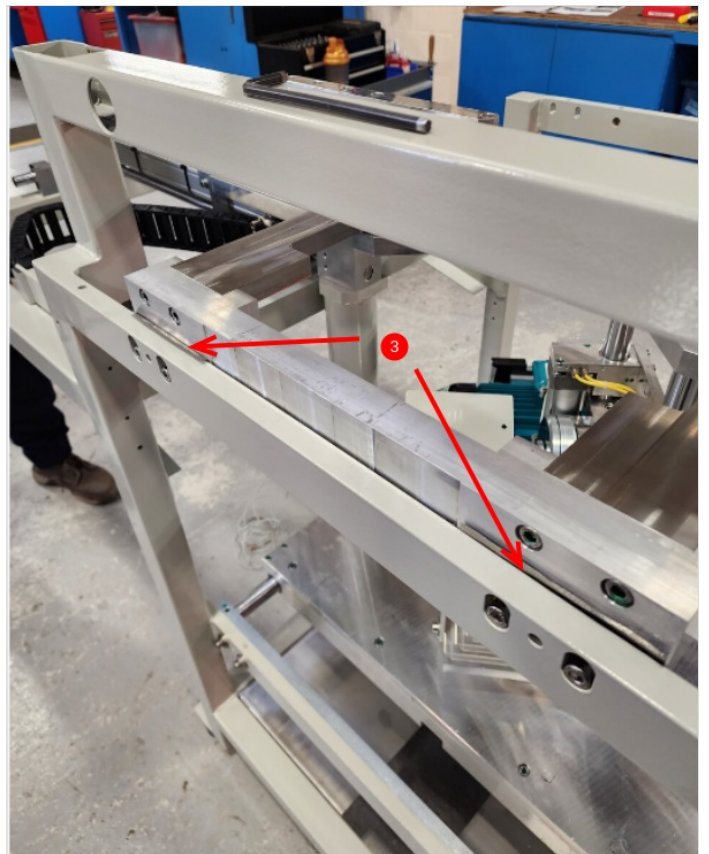
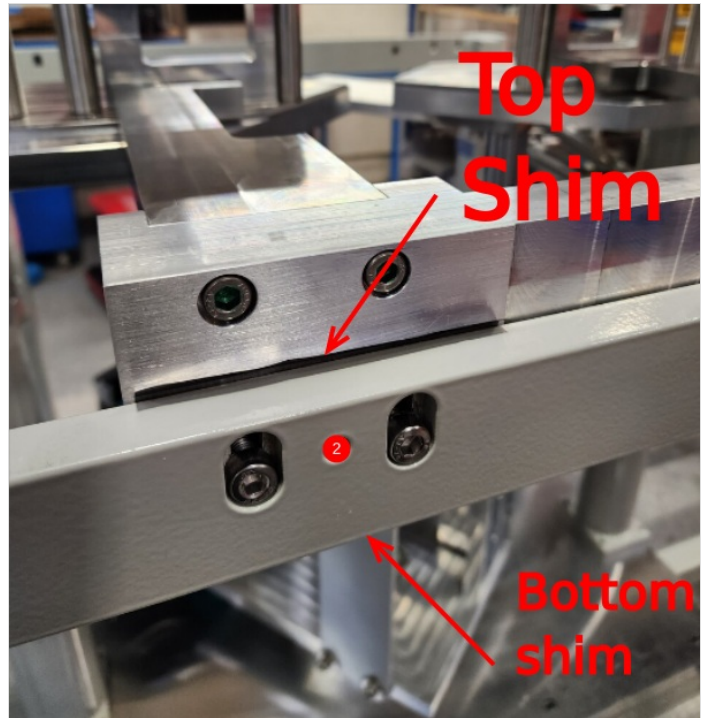
Top = add shim to top of bar

Bottom = Add shim to bottom of bar

3 Cut and add shim ensuring shim bottoms out on M8 fastener, as this will act as a datum

 ...Only use single shims to adjust, do not add shims together to increase size.

4 Adjust until rollers are square with full tension on M8 fixings





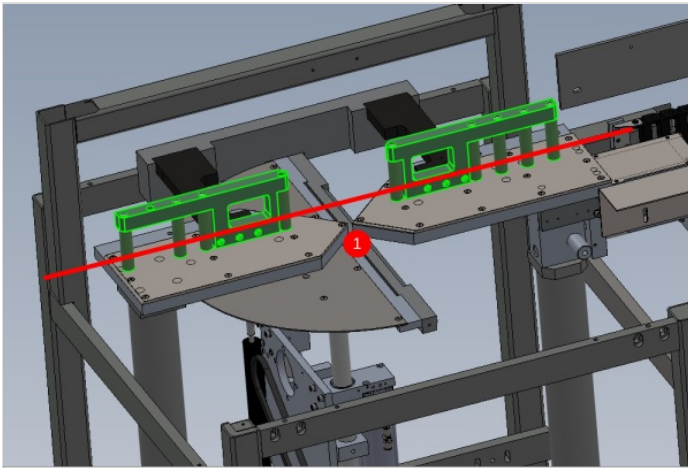
Step 5 - Set alignment between roller fences

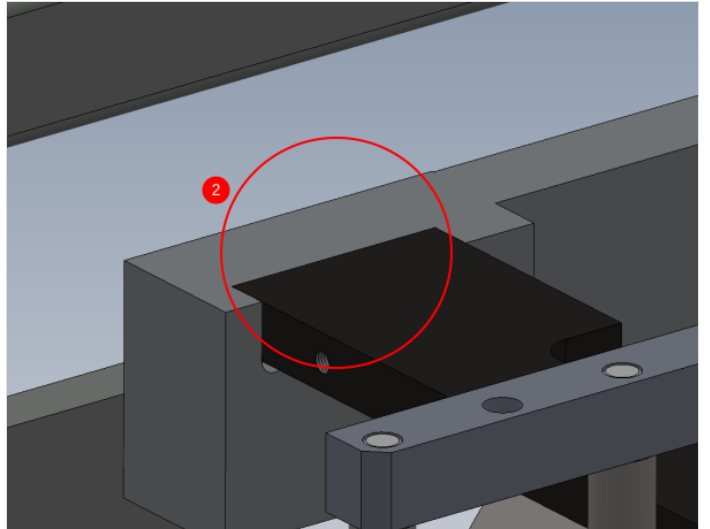
1 Use 1 meter straight edge to check alignment of rollers. Identify which direction movement is required to achieve alignment of all rollers. Tolerance 0.002"/0.05mm

2 Adjust using shim at indicated point on either / both arms

⚠ ...Each arm should only ever have 1 side with shim This retains datum positions

3 Adjust until all rollers are within tolerance to straight edge





Step 6 - Please ensure the following step is adhered to

Tolerance in following step must be adhered to

Ensure all measurements are set equal so roller fences are the same height above tables

To confirm the gap must be no bigger than 2mm between rollers and cut tables



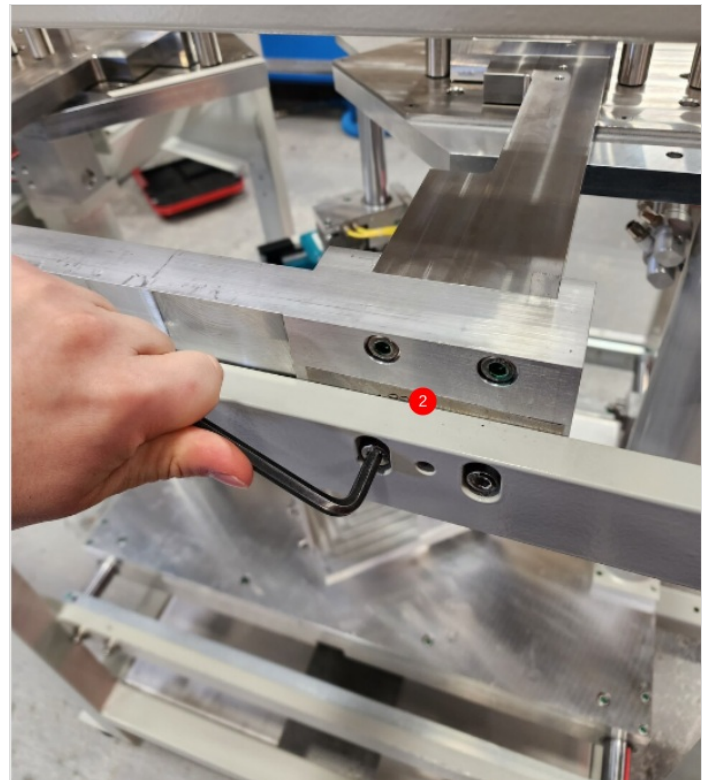
Step 7 - Set height

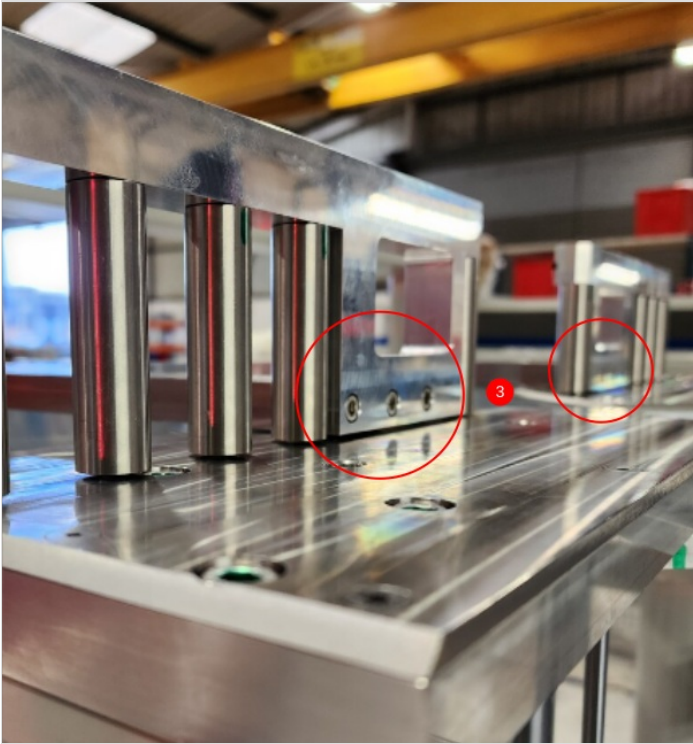
1 Set heights of all rollers to cut tables to a gap of 1.5 mm . tolerance ± 0.5 mm

2 Use slots shown for main adjustment

3 Use counterbores shown for fine adjustment

4 Check all measurements on all rollers are correct





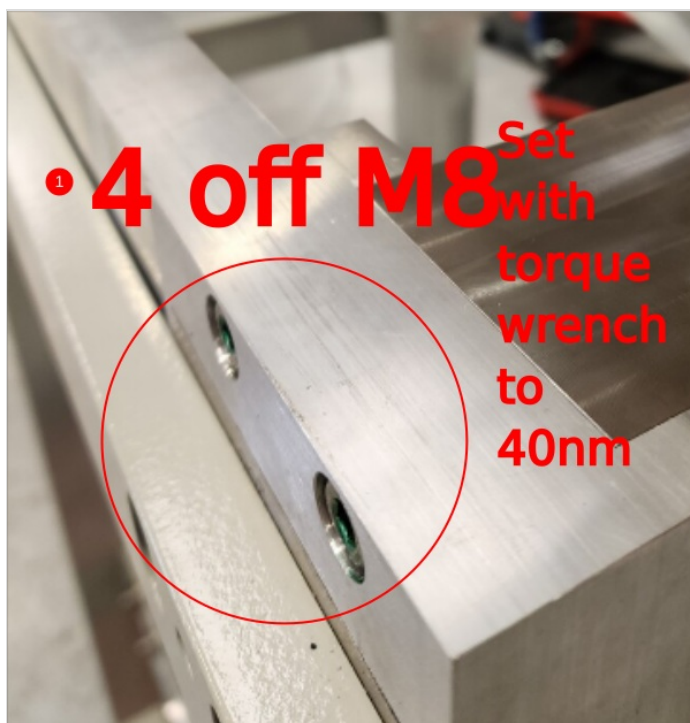
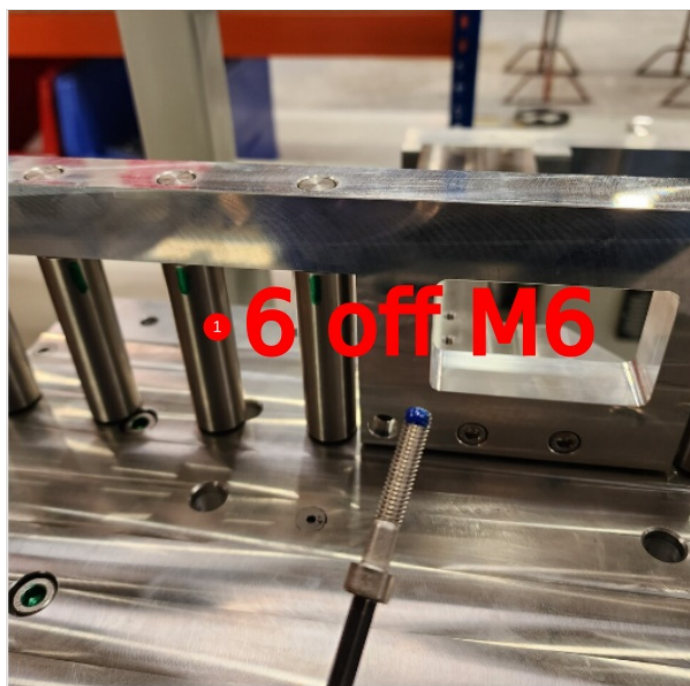
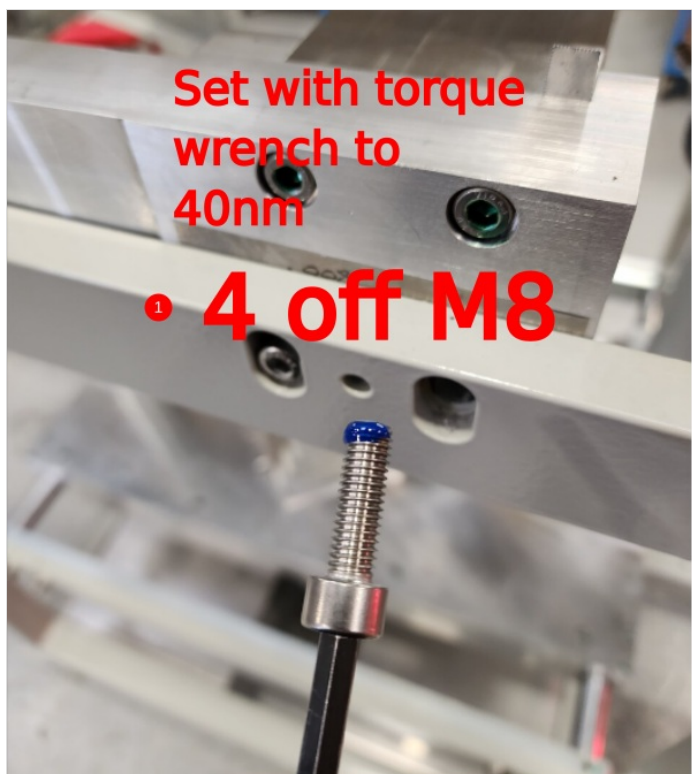
Step 8 - Recheck all settings

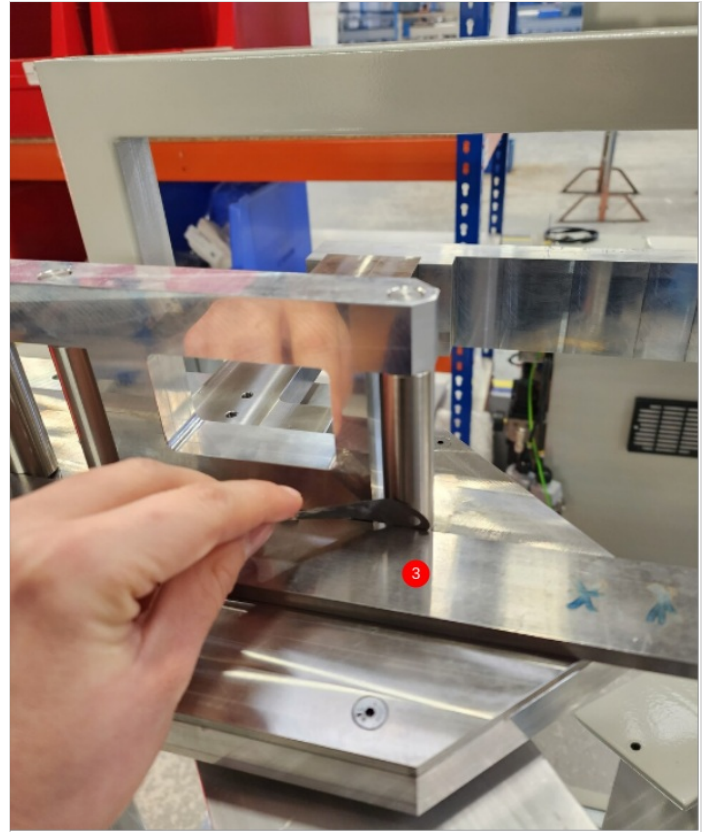
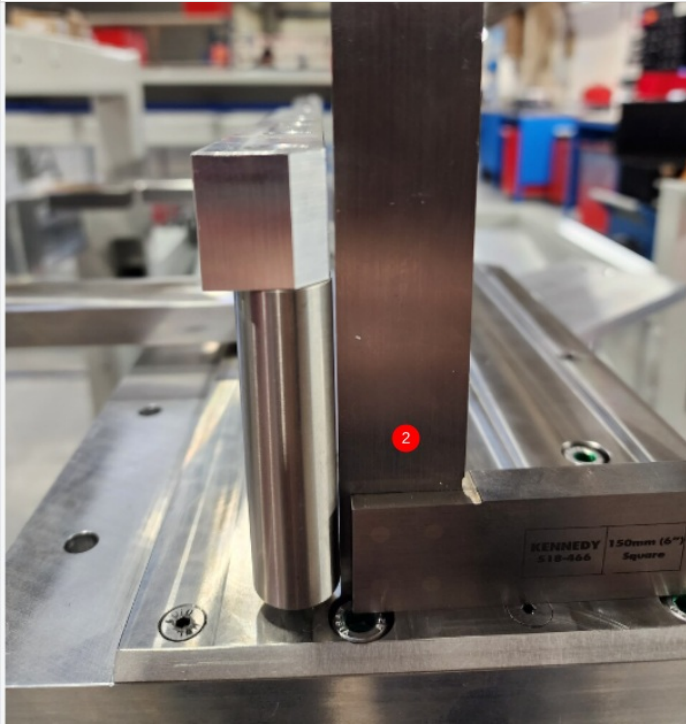
1 Finalise all fasteners shown. 8 off M8 indicated should be set to 40 nm torque setting
Once final adjustment has been done, recheck all settings as movement is possible when adjusting

2 Table /roller squareness

3 Roller alignment

4 Roller height





Step 9 - Remove all sharp edges

Once all fasteners are finalised and settings checked, shim overhangs must be removed.

Ensure no cut points are left from exposed shims

