



# R0015333 Fit Clamp Assembly

Fitting and assembly details for material clamps

 Difficulty **Hard**

 Duration **1 hour(s)**

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Comments

## Introduction

### Tools Required

Standard hex key set  
Standard spanner set  
1 meter straight edge  
Feeler gauges  
Soft hammer  
Engineers square

### Parts Required

R0015064 Bench Assemble Clamp Assy ZX5

## 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

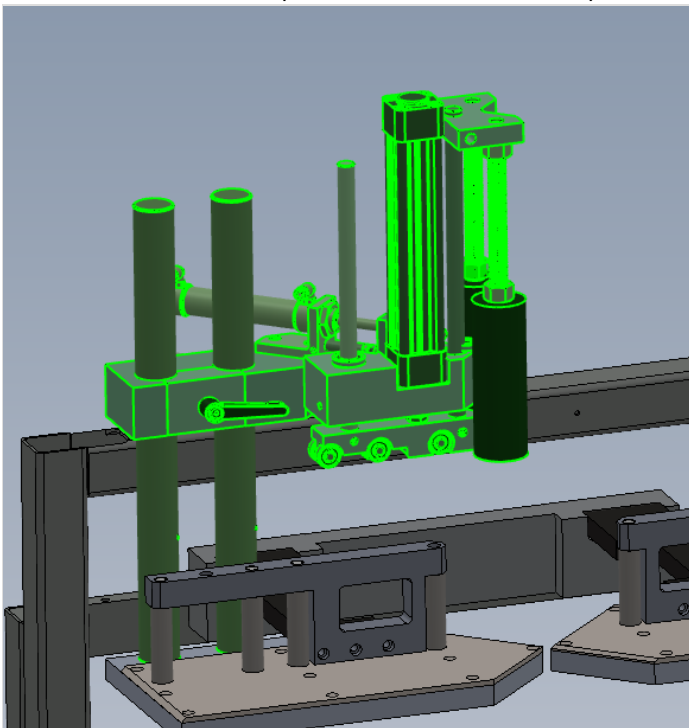


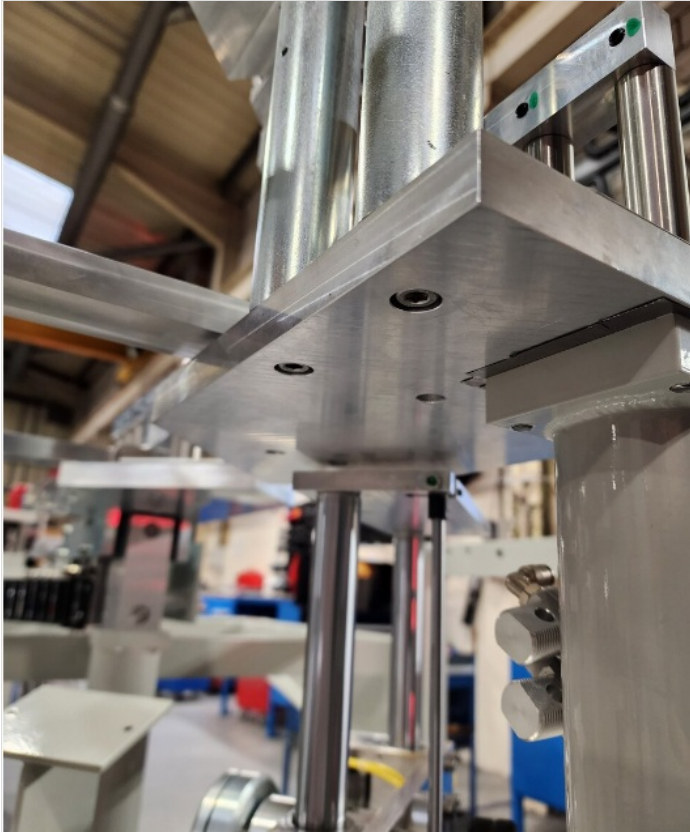
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## Step 2 - Attach Infeed clamp assembly

Attach infeed clamp assembly to infeed pad

Use 2 off M8 x 35 socket caps Do not use adhesive at this point





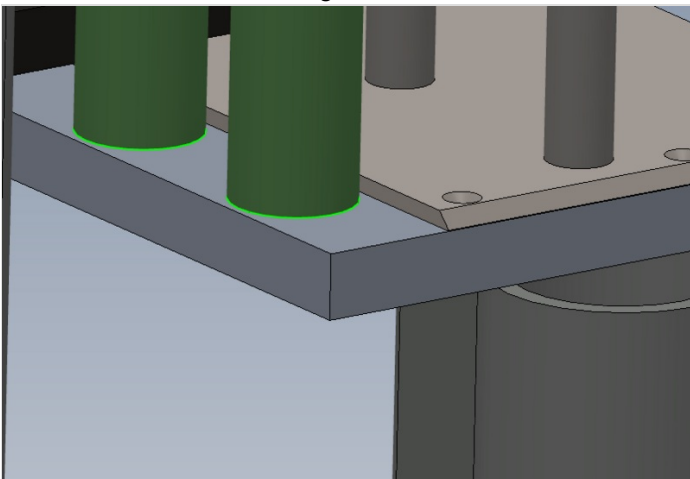
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## Step 3 - Set position

Use soft hammer to adjust pillar position to be flush with cut table

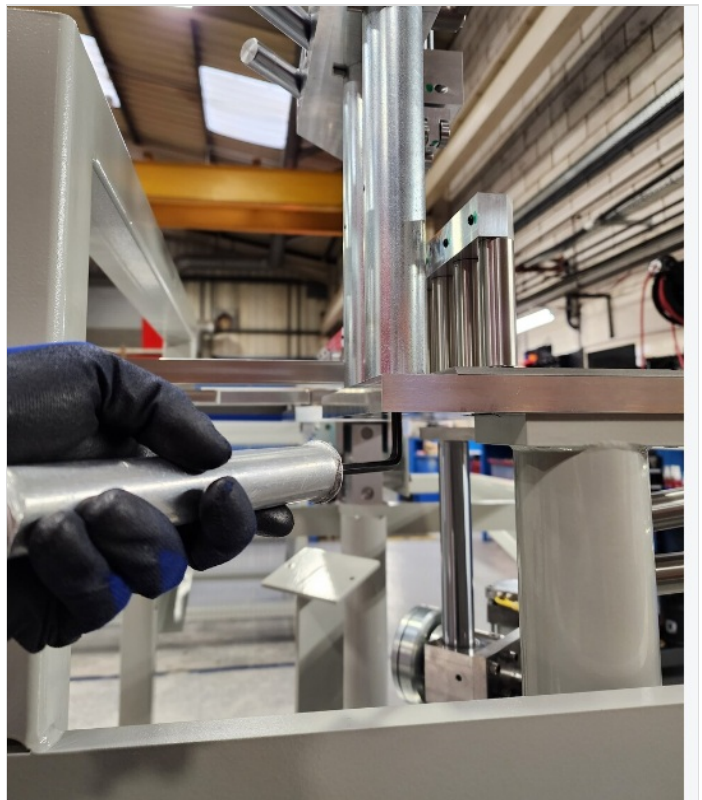
Check position using engineers square as shown

Add final tension to M8 securing fasteners









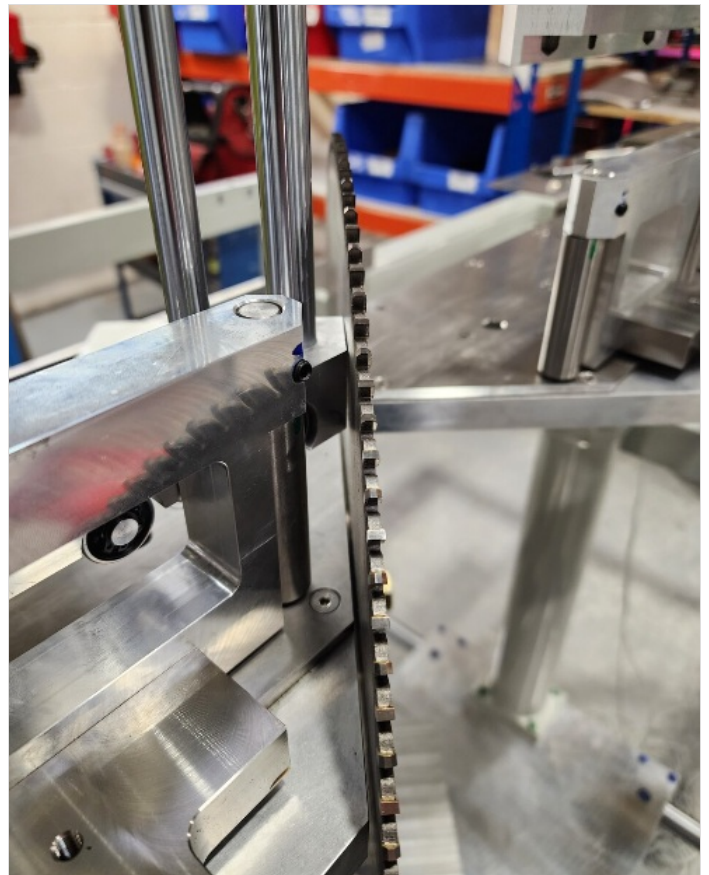
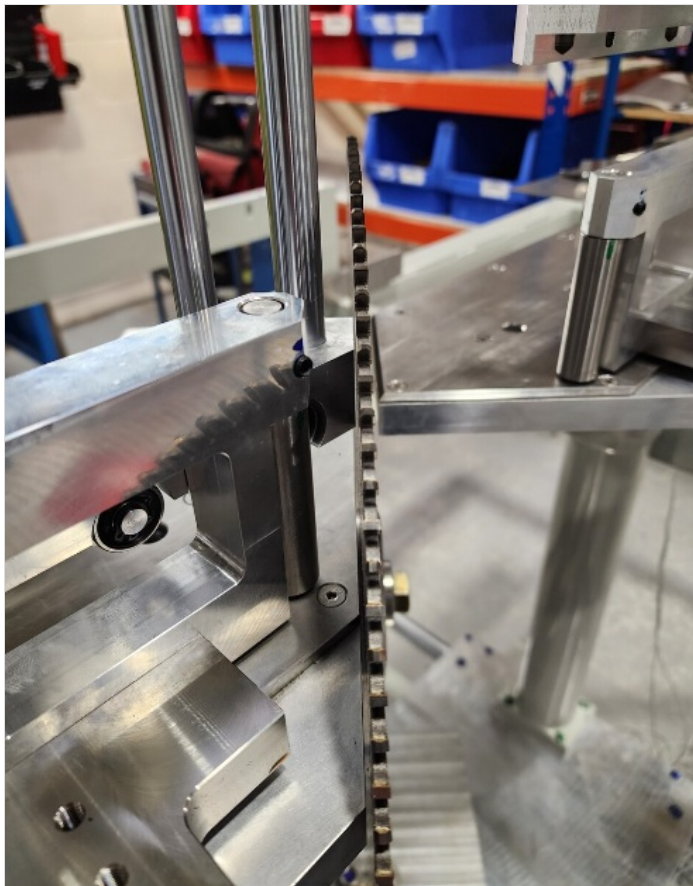
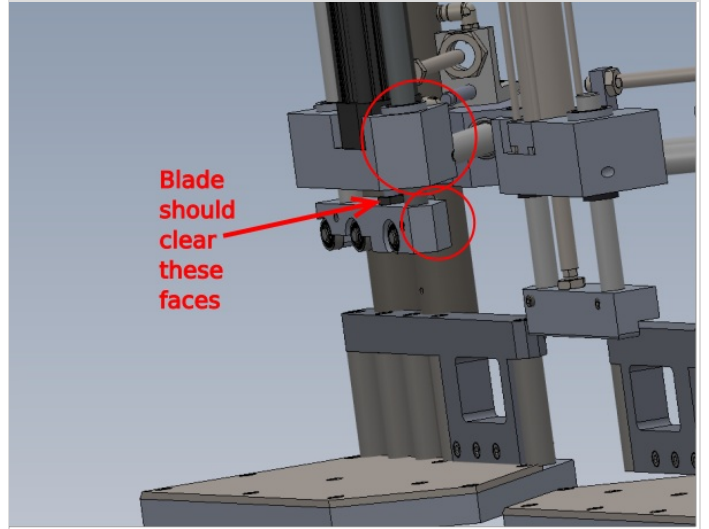
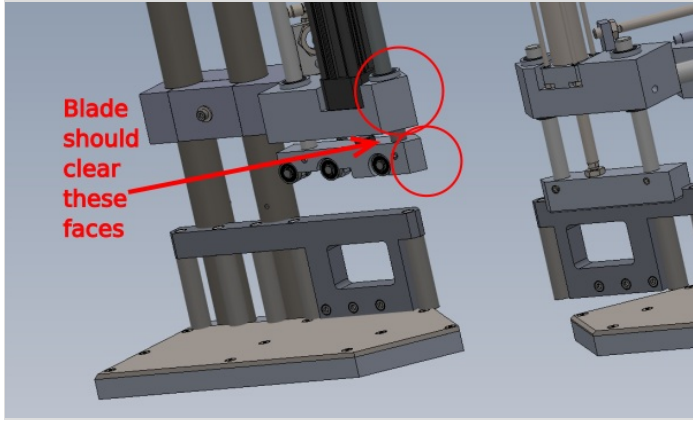
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## Step 4 - Check clearance to saw blade

Clearance between clamps and saw blade must be checked. To do this

- 1 Lift saw blade to maximum height
- 2 Rotate turntable to 45 and 135 degrees (full travel in both directions )
- 3 Clearance should be evident between saw blade and clamps in the area shown  
Report to supervisor if contact is present

Please take photos to show this check



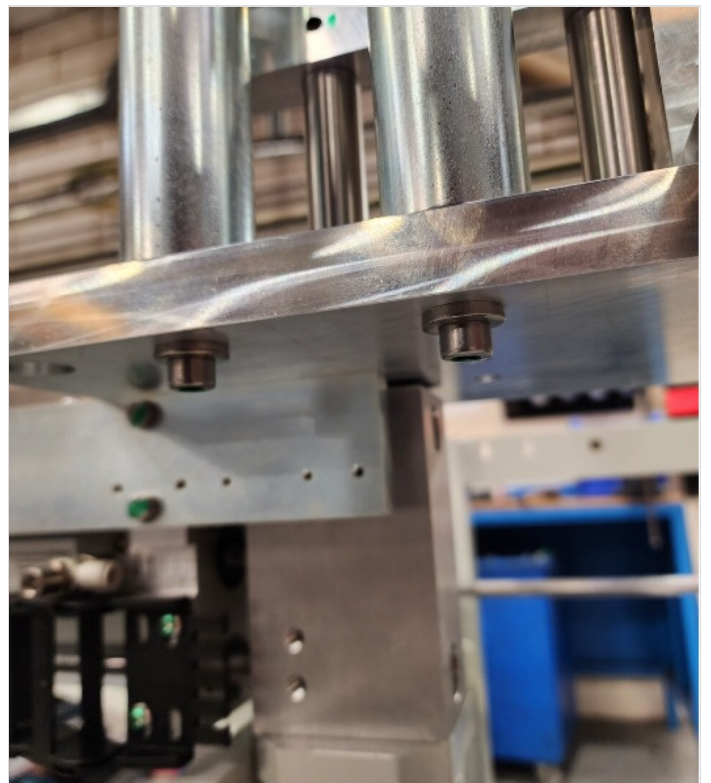
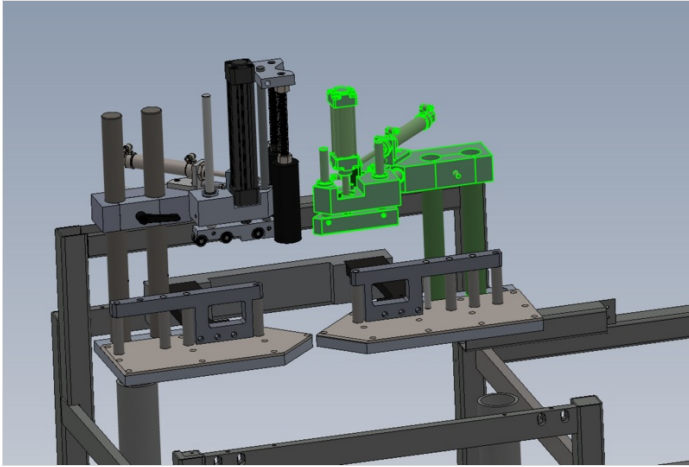




## Step 5 - Fit outfeed clamp assembly

Fit outfeed clamp assembly to outfeed pad sing 2 off M8 x 50 socket caps and M8 motor plate washers

Do not use adhesive at this point

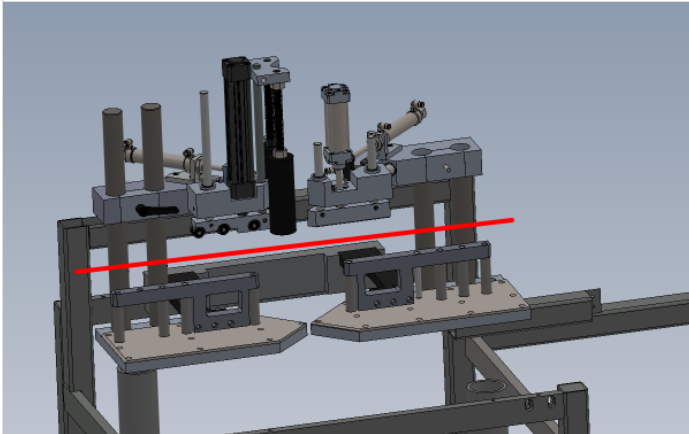


## Step 6 - Align clamps

Use 1 meter straight edge along pillars

Adjust **OUTFEED CLAMP** to set all 4 pillars to contact straight edge

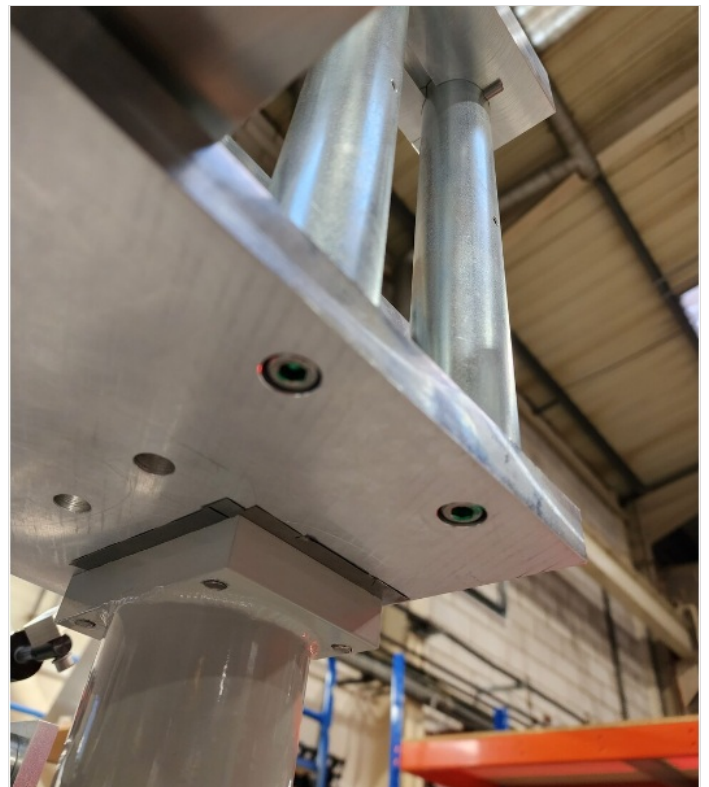
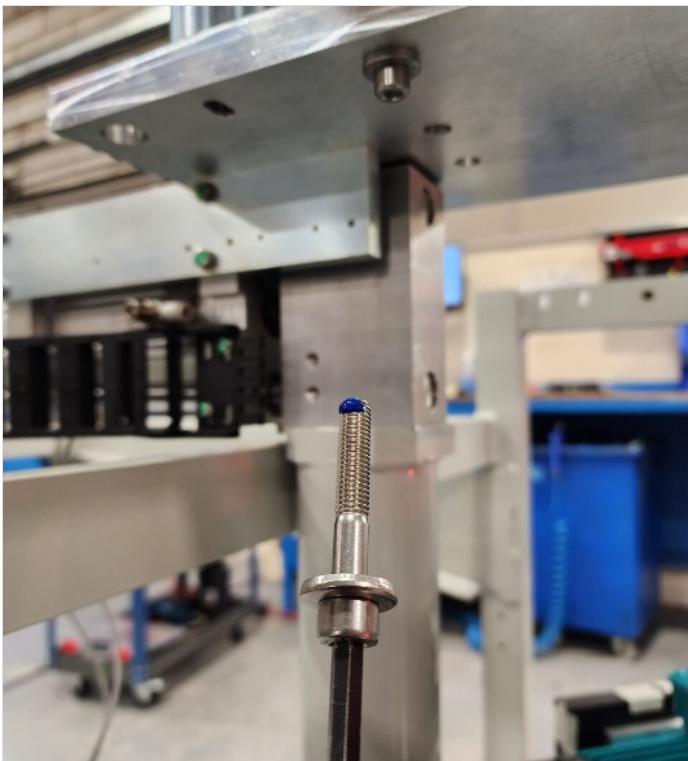
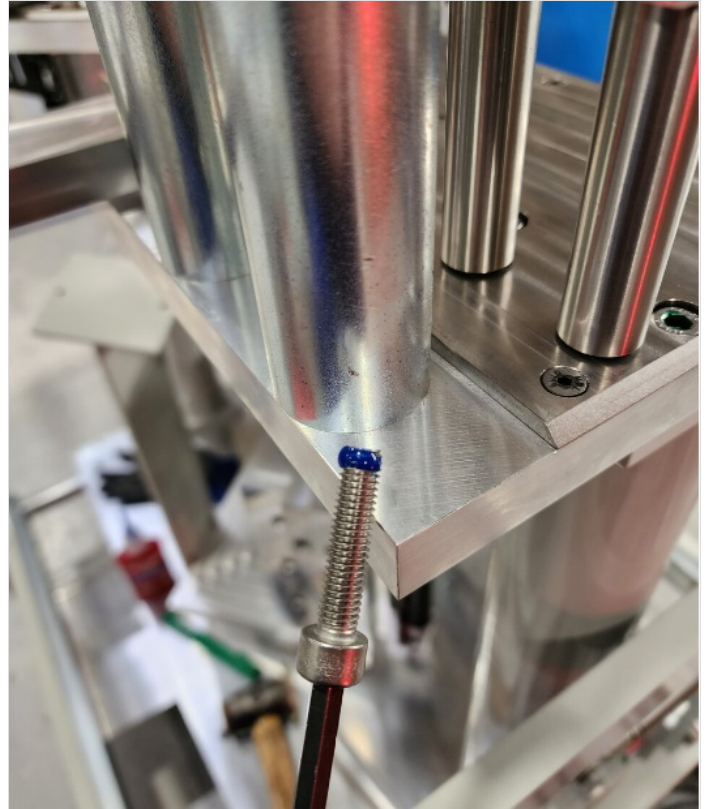
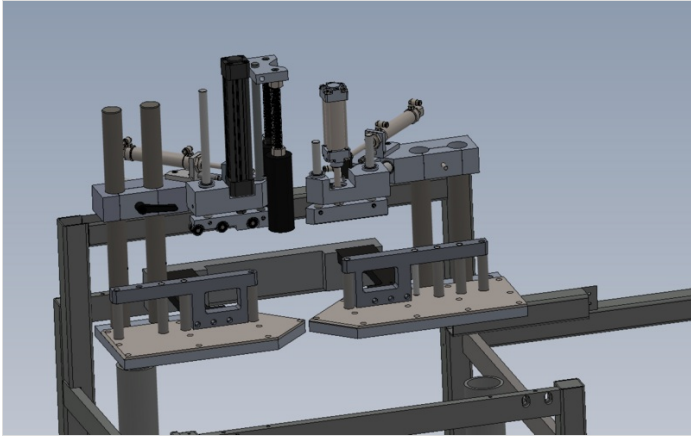
Use feeler 0.002" / 0.05mm gauge as maximum tolerance





## Step 7 - Finalise torque setting

Individually remove and apply adhesive to 4 off M8 fasteners and apply final tension setting to 40nm with torque wrench



## Step 8 - Recheck alignment

Recheck alignment once final tension is added to all fasteners

Check all clamps more freely up and down pillars when quip clamp has tension removed

