# R0015334 Fit Centralise Front Table

Fitting and setting details for Sy assembly and centralise top table

Difficulty **Hard** Duration **4 hour(s)**

## Contents



# Introduction

**Tools Required**

Standard hex keyset
1 meter straight edge
Large parallels
150mm engineers square
Engineers level 300mm

**Parts Required**

H0004543 Gap cover saw finger guard
R0000562 Bench assemble centralise top table
R0015037 Bench assemble SY Assembly

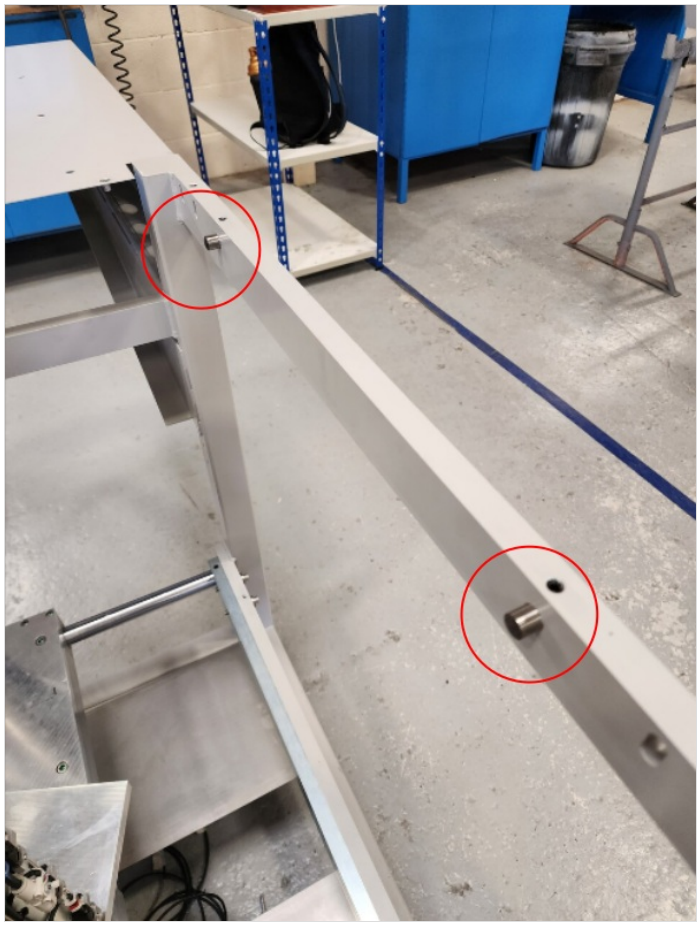
# Step 1 - Unless otherwise stated

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 - Add jacking points to frame

Fit 2 off 1/2" x 1" dowels to frame as shown . Ensure dowels are fully seated . Ensure chamfered end of dowel is inserted first

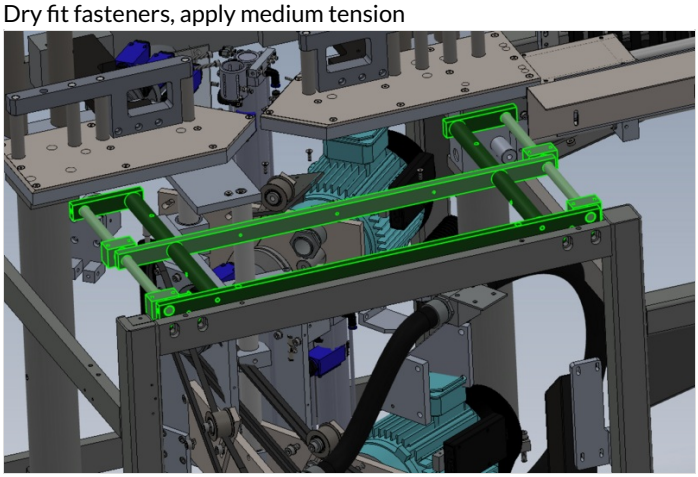
Secure with 2 off M8 x 12 KCP grubscrews

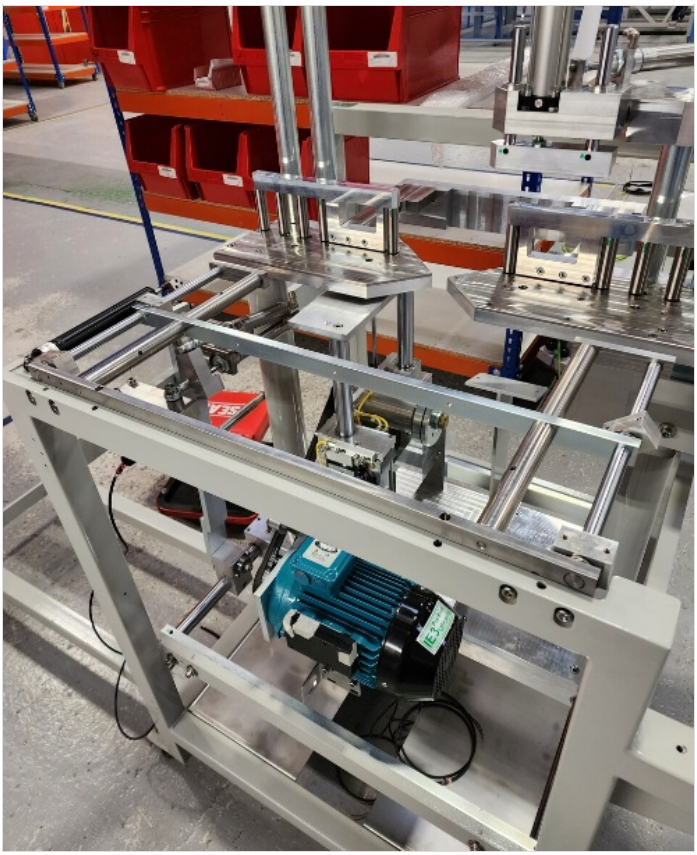


# Step 3 - Mount R0000562 Bench assemble centralise top table

Attach R0000562 Bench assemble centralise top table as shown
Use 4 off M8 x 20 socket caps
Fit assembly at highest position in slots

Dry fit fasteners, apply medium tension

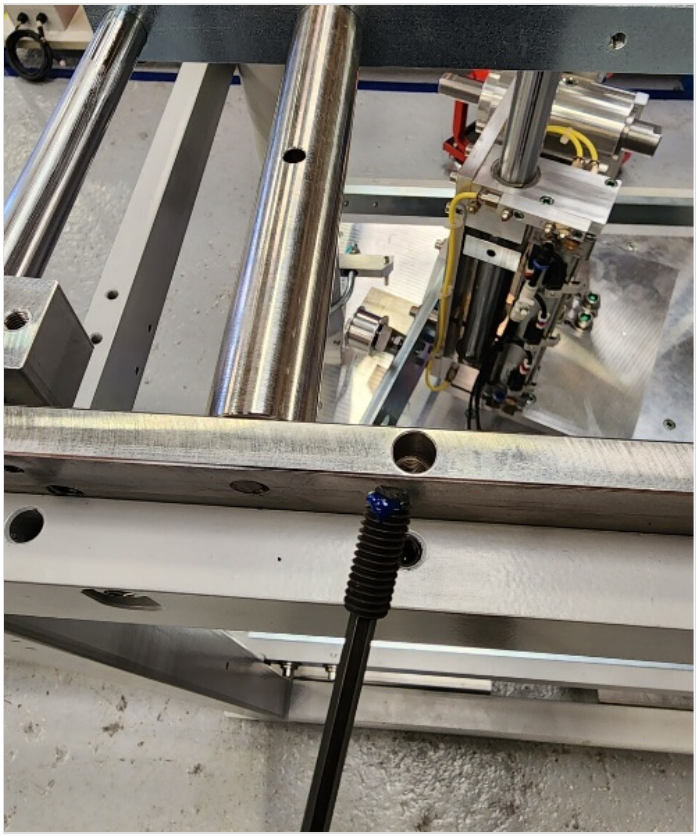


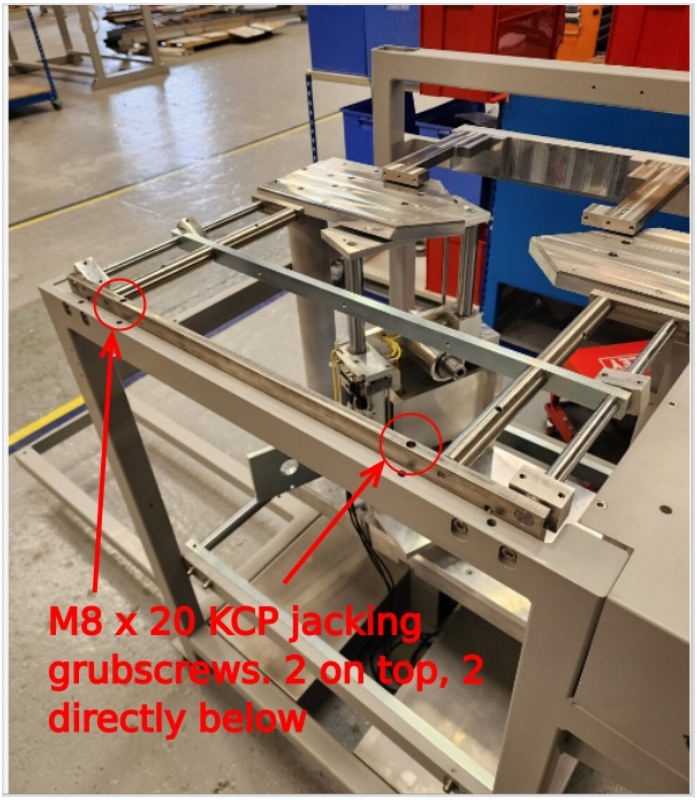


# Step 4 - Add height adjustment points

Add 4 off M8 x 20 KCP grubscrews to points shown .

Adjust grubscrews to touch dowels






## Step 5 - Add squareness adjustment points

Fit 4 off M8 x 12 flat bottomed grubscrews to the points shown

Wind grubscrews to touch frame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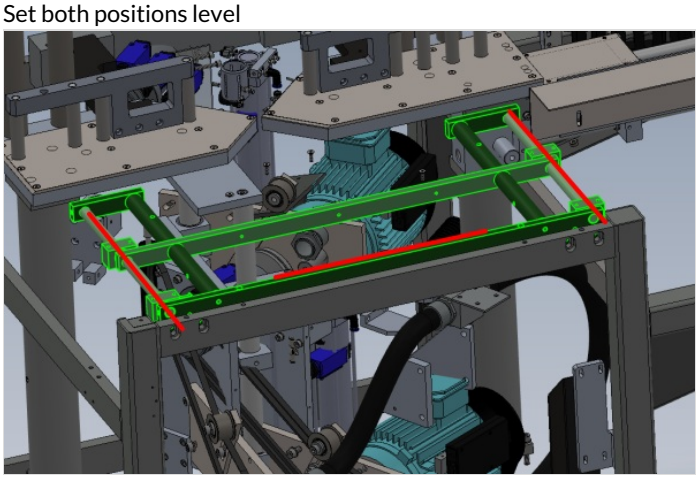
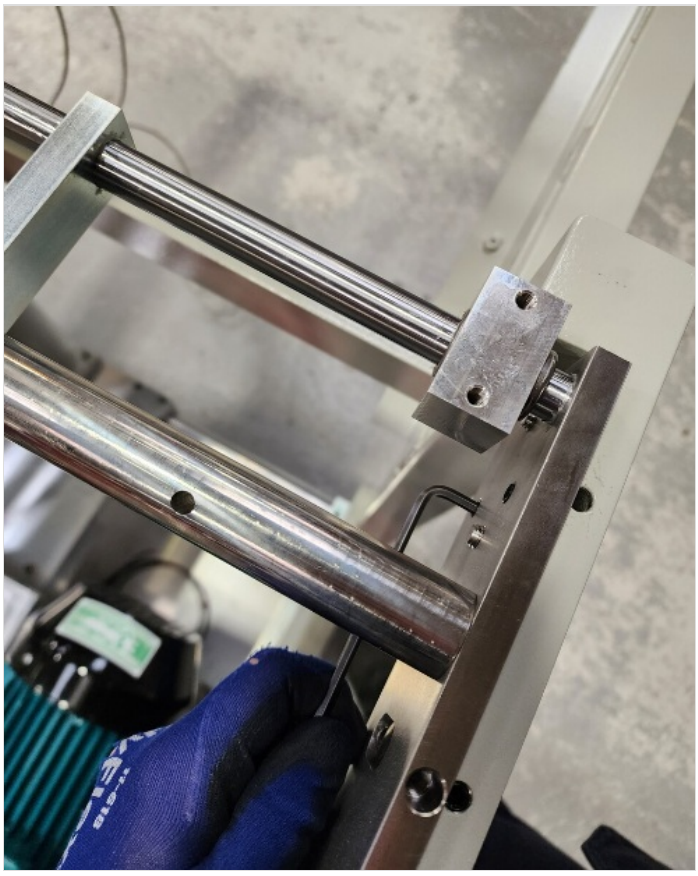
## Step 6 - Adjust position

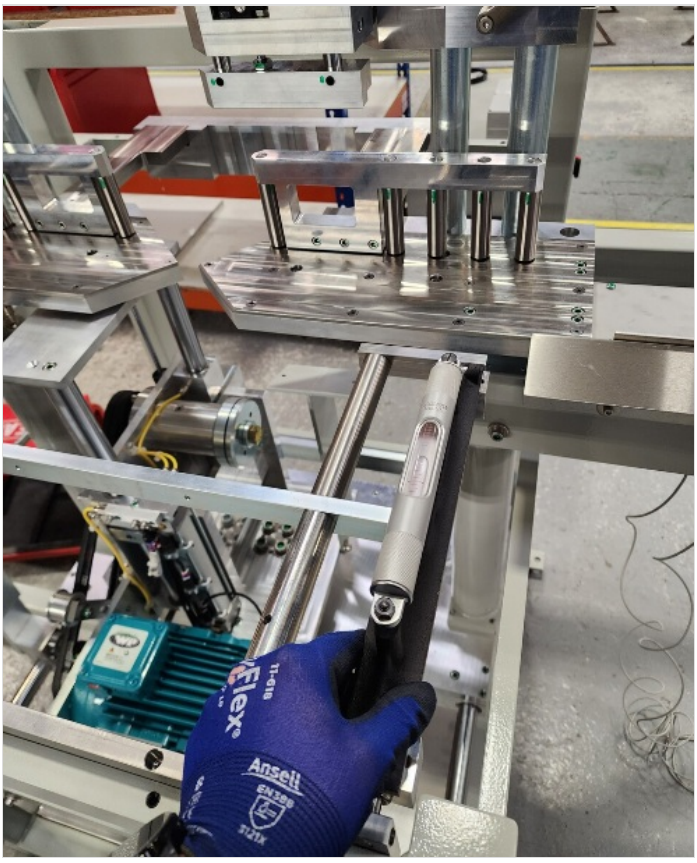
Set initial position of assembly using engineers level on the indicated axis

Use M8 squareness adjusting grubscrews to set position

Set both positions level



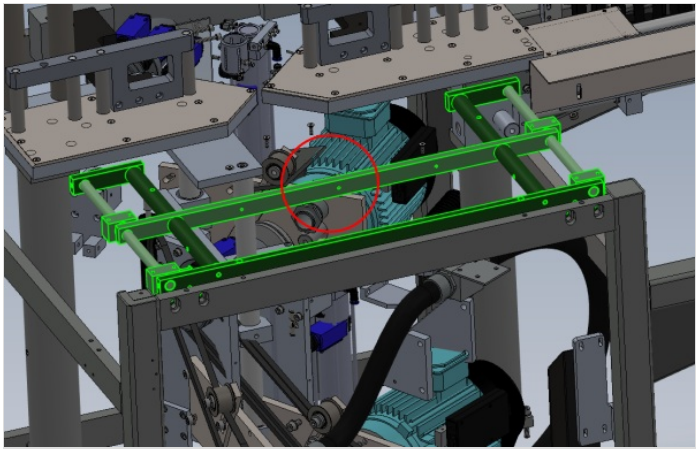



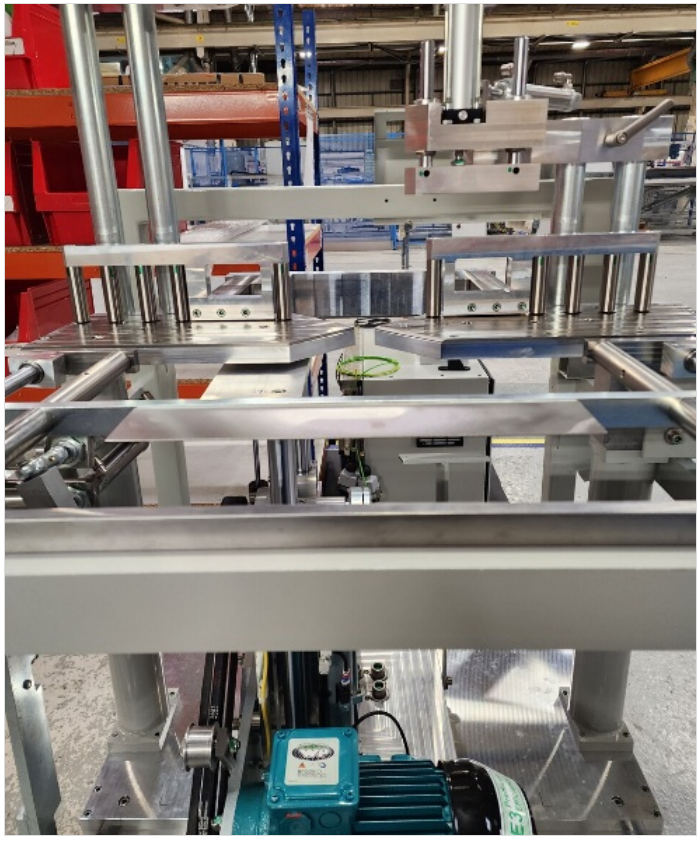



## Step 7 - Fit finger Guard

Fit H0004543 Gap cover saw finger guard to assembly
Use 3 off M5 x 12 socket caps and A form washers

finalise fasteners



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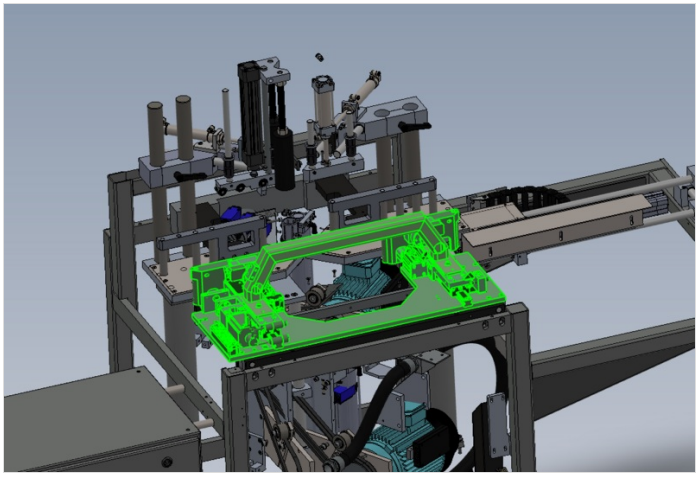
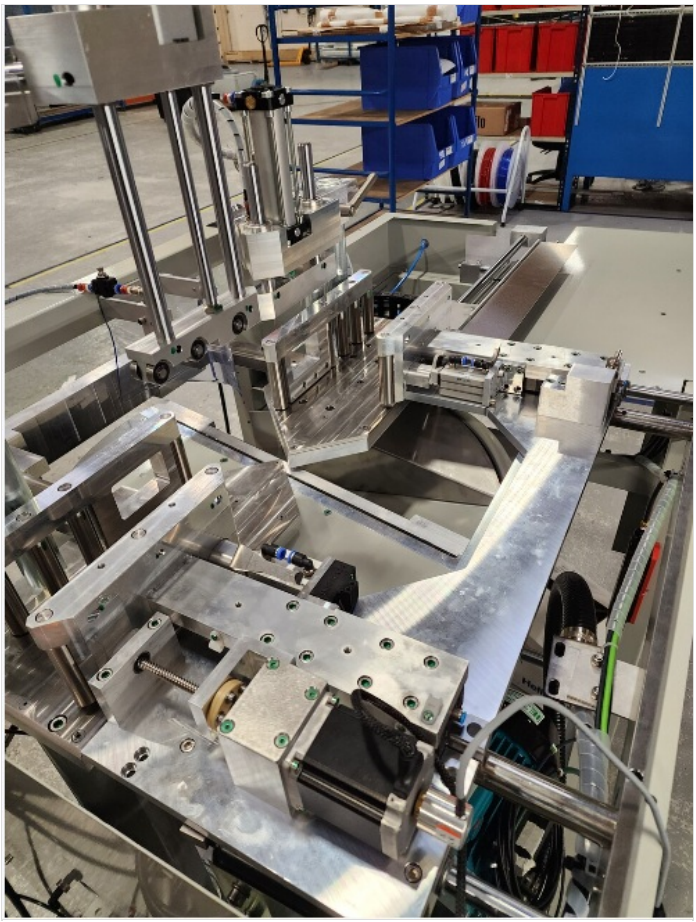
## Step 8 - Mount R0015037 Bench assemble SY Assembly

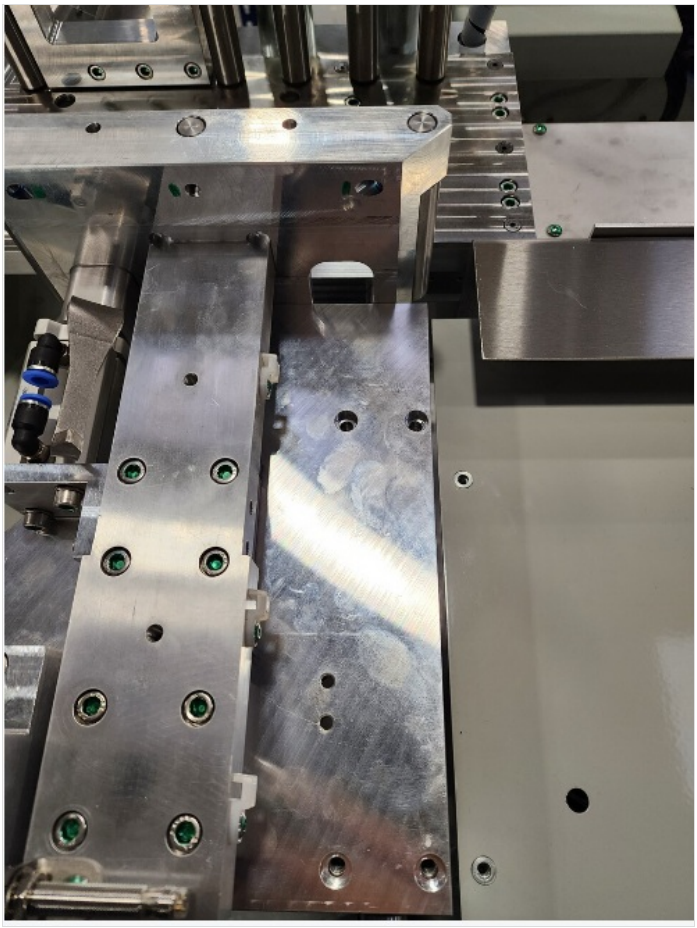
Mount R0015037 Bench assemble SY Assembly

Use 8 off M6 x 20 socket caps

Dry fit fasteners



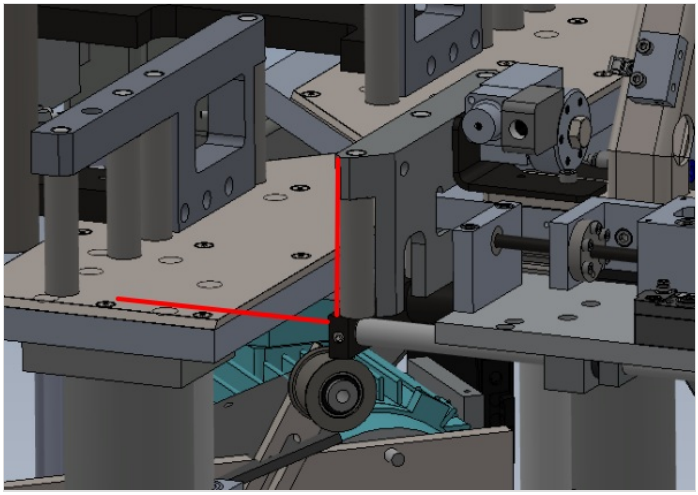


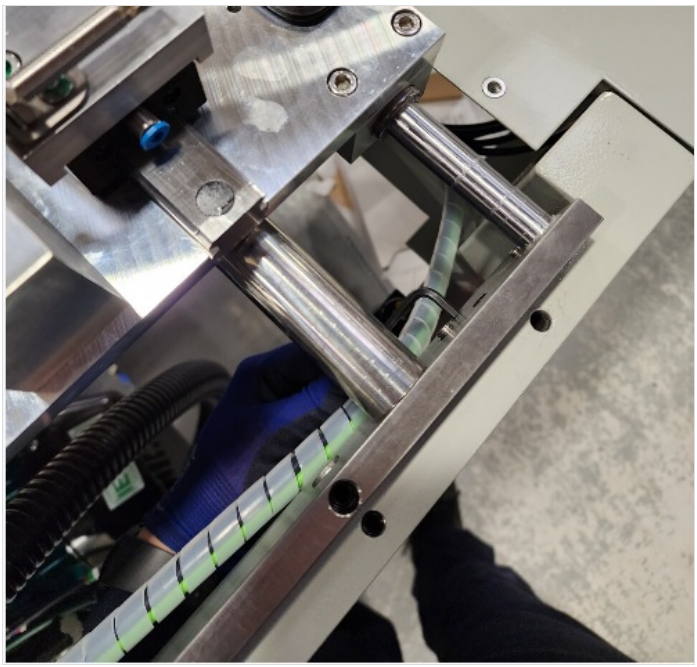


## Step 9 - Adjust square

Use engineers square to check squareness of front rollers to infeed and outfeed cut tables

Use adjusting grubscrews to set square accurately
Adjusting grubscrews must be set under tension
Only adjust 1 off grubscrew in each pair. Do not jack top table frame away from main frame . 1 point of contact must always be present



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## Step 10 - Please ensure the following step is followed correctly

Please ensure the gap is set correctly between the rollers and the cut tables.

Maximum gap is 2mm

Ensure gap is even over all rollers when setting

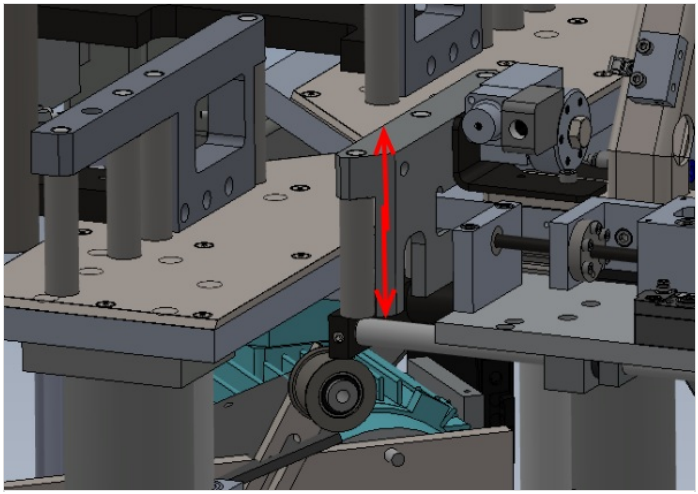

## Step 11 - Adjust Height of Sy assembly

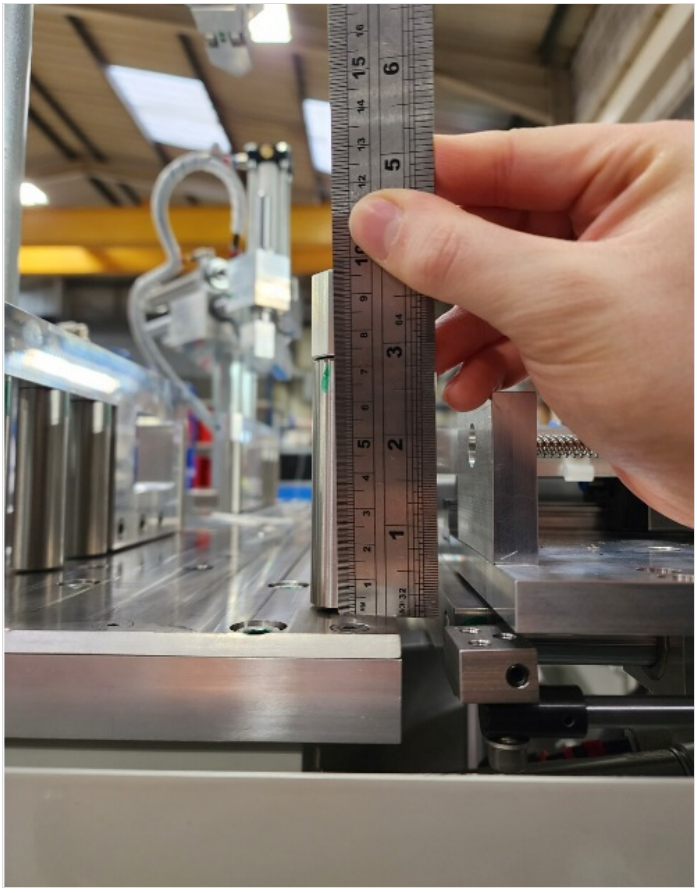
Set height of Sy assembly to cut tables using jacking grubscrews

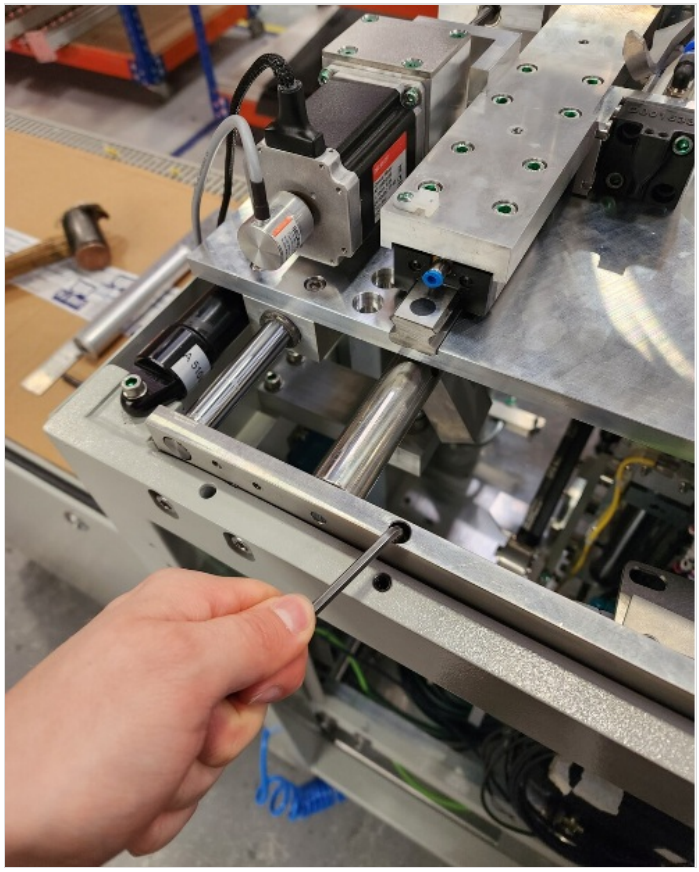
Release pressure on front 4 off M8 x 20 socket caps

Use M8 x 20 grubscrews to adjust height of assembly

Set to gap of 1.5mm -+ 0.5mm
Ensure assembly sits level/even across all rollers
Apply final tension with adhesive to front M8 x 20 socket caps







## Step 12 - Recheck squareness of rollers

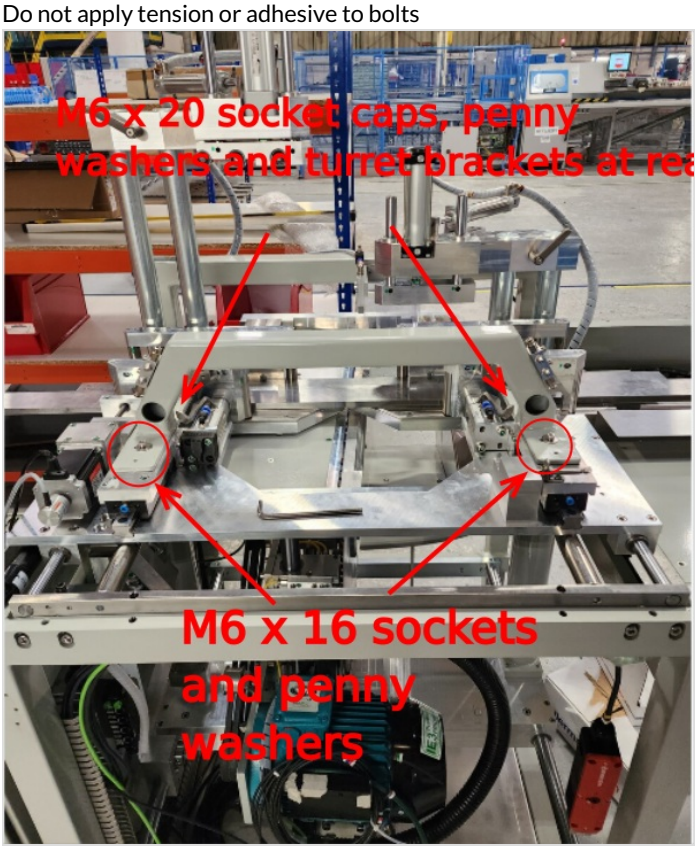
Once height has been adjusted, roller squareness must be checked and reset if movement has occurred . Both height and squareness will have to be manipulated together to achieve all settings to requested specification

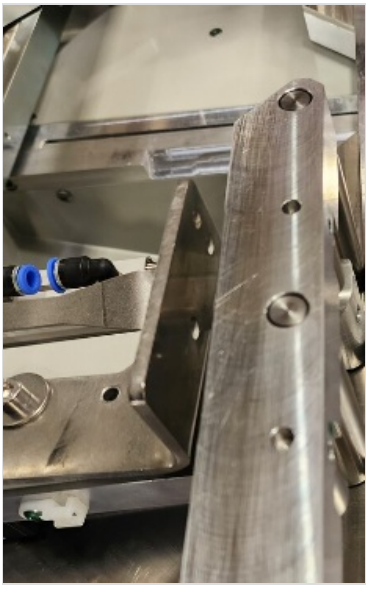

## Step 13 - Attach saddle brace

Attach saddle brace to assembly using 2 off M6 x 16 socket caps 2 off M6 x 20 socket caps all with penny washers

Incorporate turret brackets at rear fixing point when mounting saddle brace
Saddle brace has slots for sideways movement. Utilize this to ensure Z turret brackets sit square in position to fences

Do not apply tension or adhesive to bolts



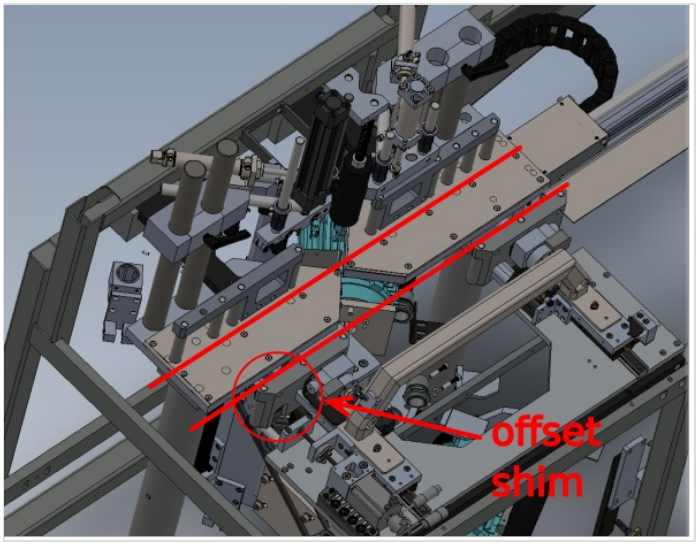

## Step 14 - Set Parallel to backfences

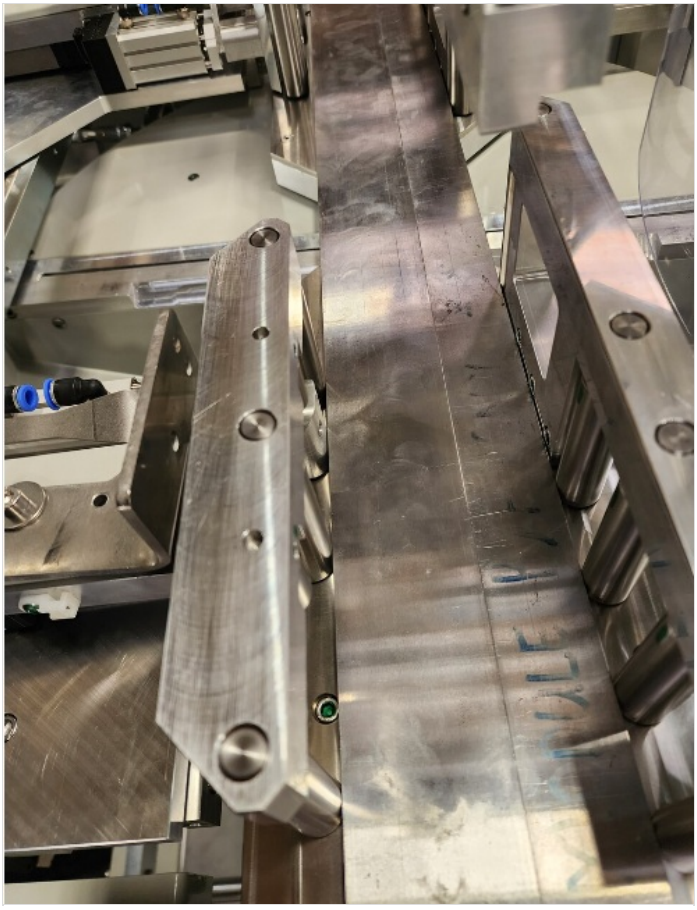
Use 2 off straight edges against back roller fence

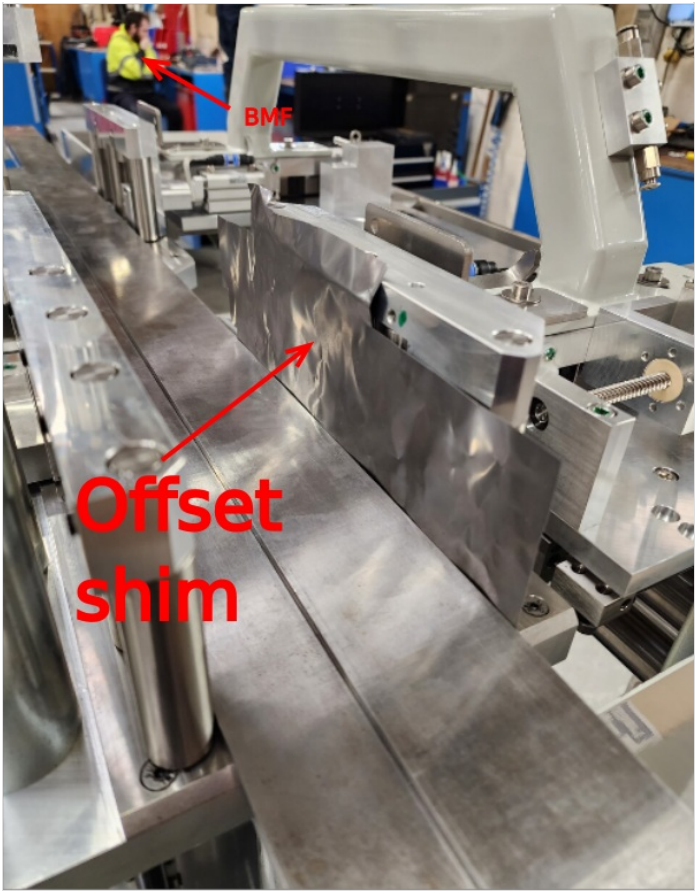
Add offset shim of 0.002"/0.05mm to driven side

Set front rollers to touch, using M6 socket caps and counter bore clearance to adjust

Report if unable to achieve parallel from this movement



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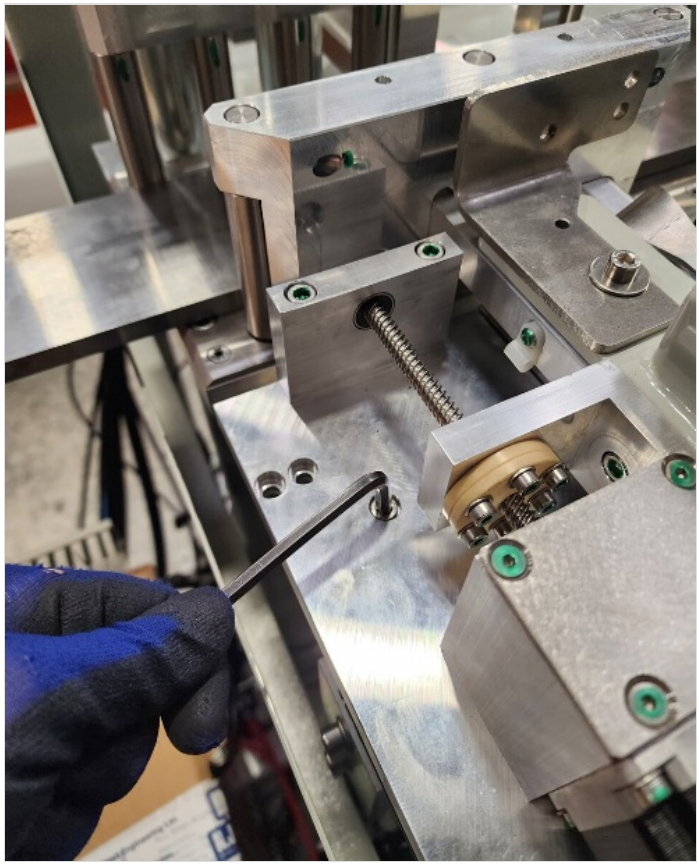
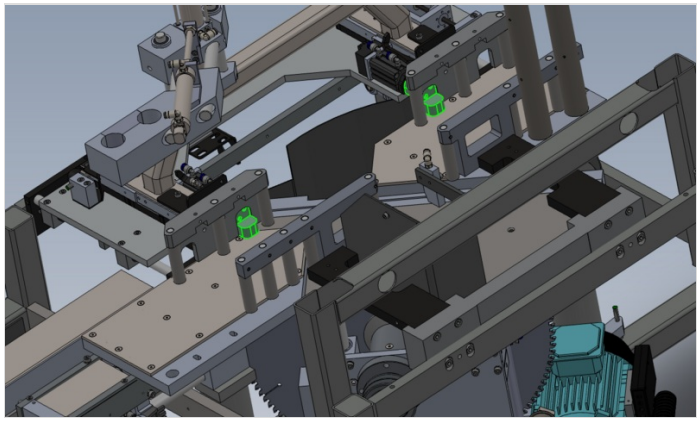
Offset
shim

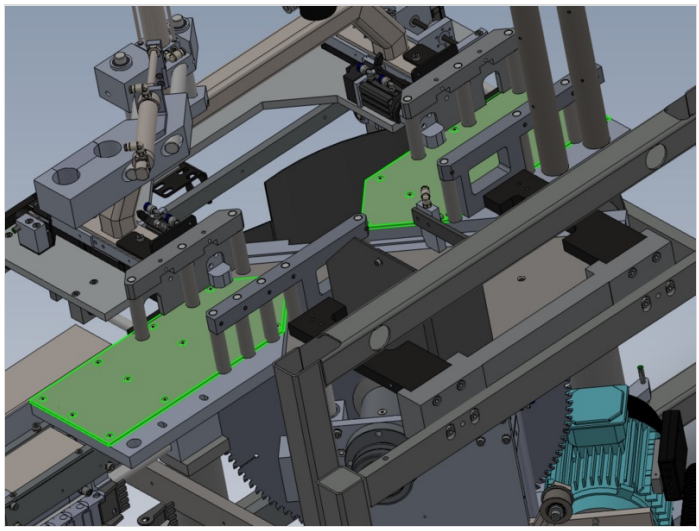


# Step 15 - Quality check

Check settings are adjusted, check that Z block operation does not foul cut tables

To do this move both z blocks by hand to active and home position and check contact is not made with the cut tables



# Step 16 - Recheck Settings

Recheck all settings once final adjustment has been made

Roller squareness to cut tables

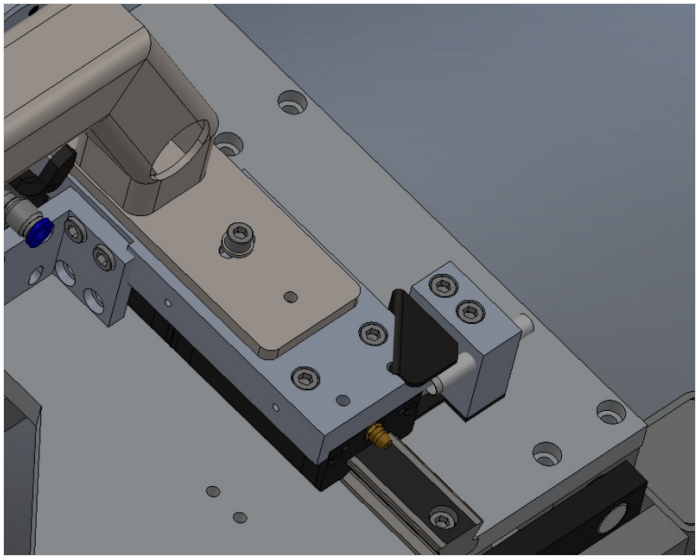
Roller height to cut tables

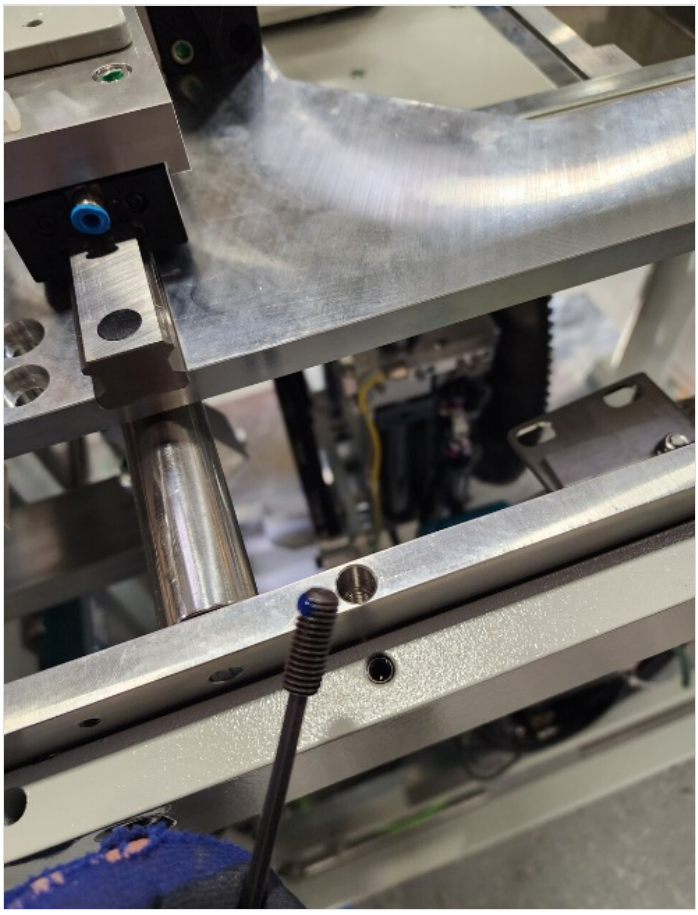
Parallel to back fences

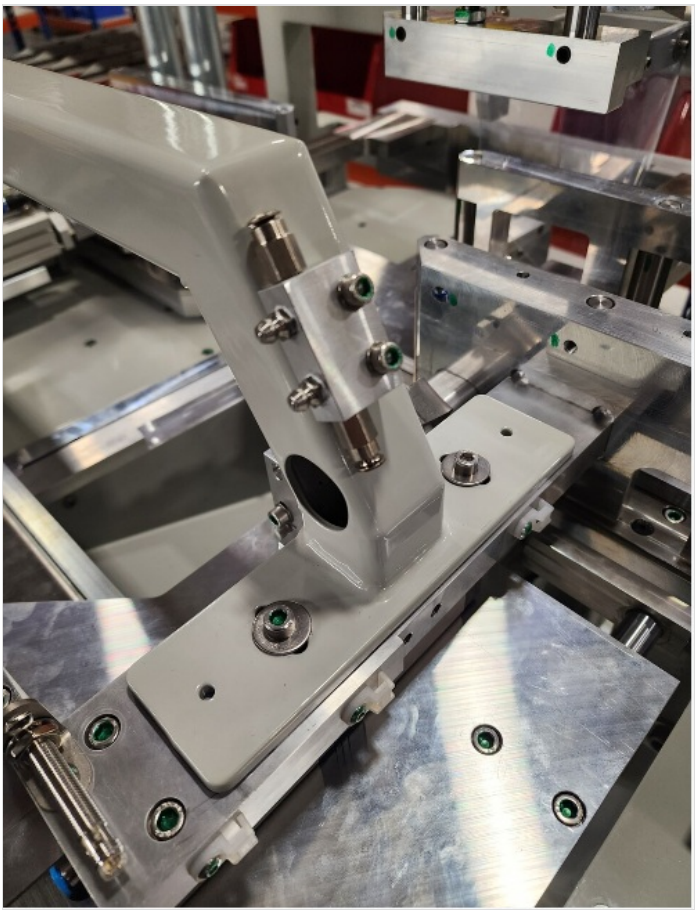

# Step 17 - Finalise Fasteners

Remove turret brackets ( required for later step of dowelling)

Individually remove and apply adhesive to all dry fasteners and apply final tension







## Step 18 - Recheck settings

Recheck all settings once final adjustment has been made
Roller squareness to cut tables
Roller height to cut tables
Parallel to back fences


## Step 19 - Check adjustment grubscrews

Check that no adjustment grubscrews are loose.

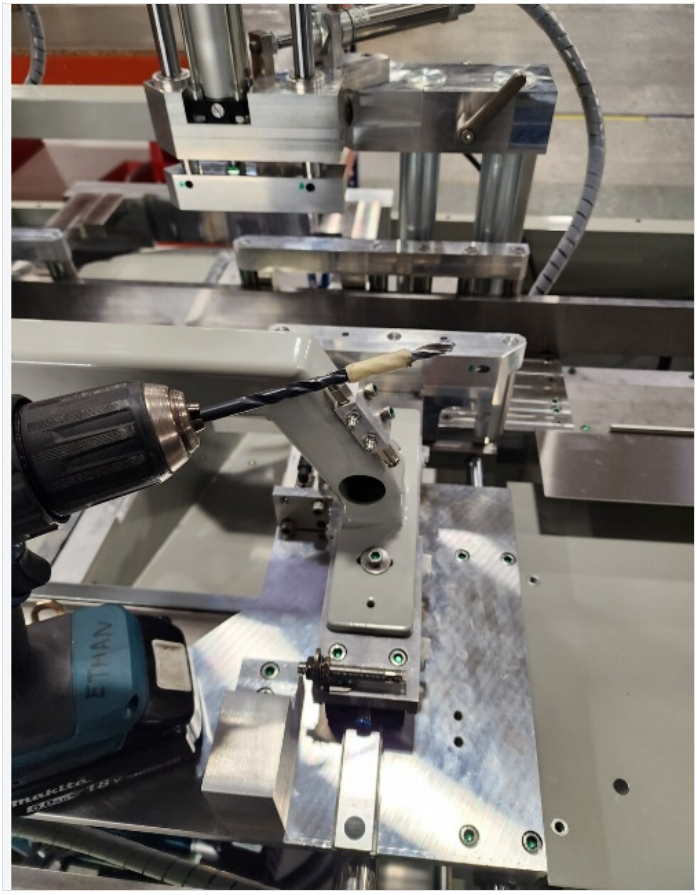
Any grubscrews that are not required should still have adhesive applied and lightly tensioned to set in position

## Step 20 - Dowel Saddle brace

Drill4 off dowel points in saddle brace 5.8mm to a depth of 20mm

Ream to 6mm H7 tolerance

Use 4 off 6mm x 30 dowels to secure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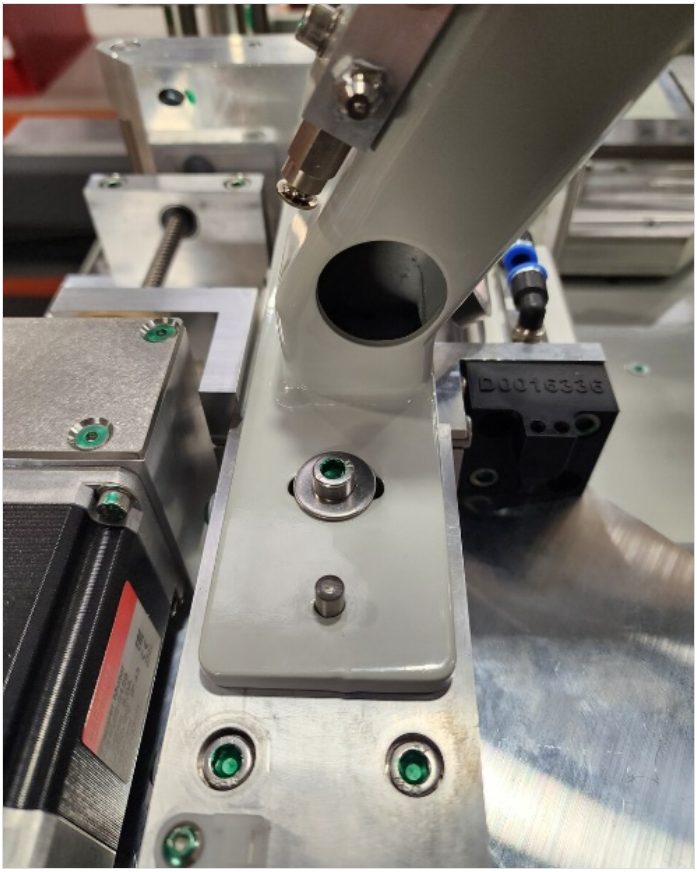
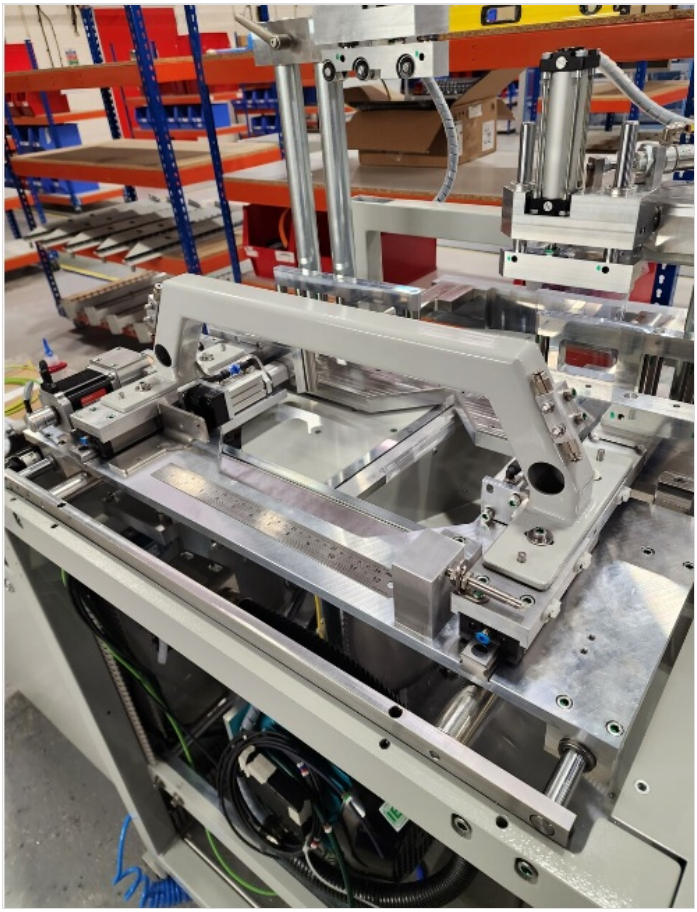




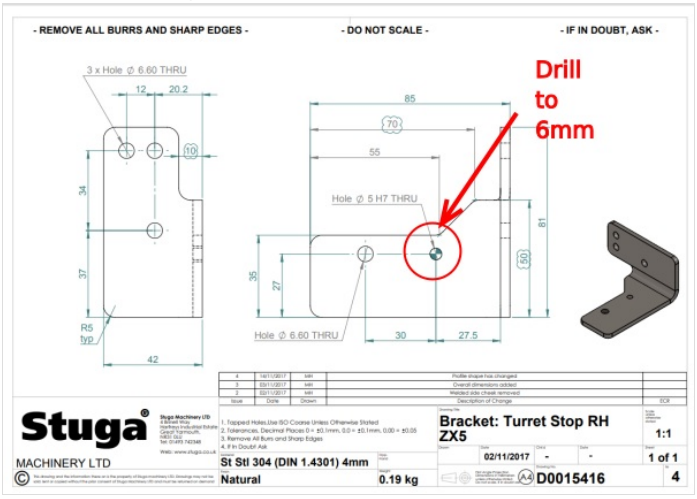
# Step 21 - Recheck settings

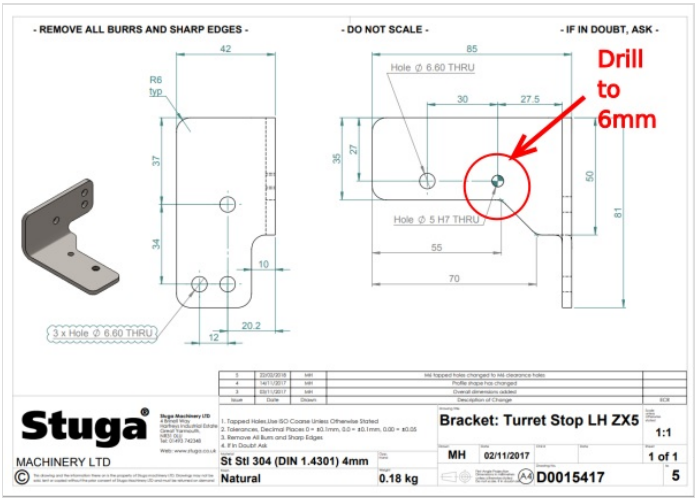
Recheck all settings once dowelled to ensure no movement has occurred


# Step 22 - Amend Turret brackets

Ecr raised 12/12/23 to amend turret bracket D0015416 and D0015417 hole size to 6mm

Amend hole size by hand to 6mm until



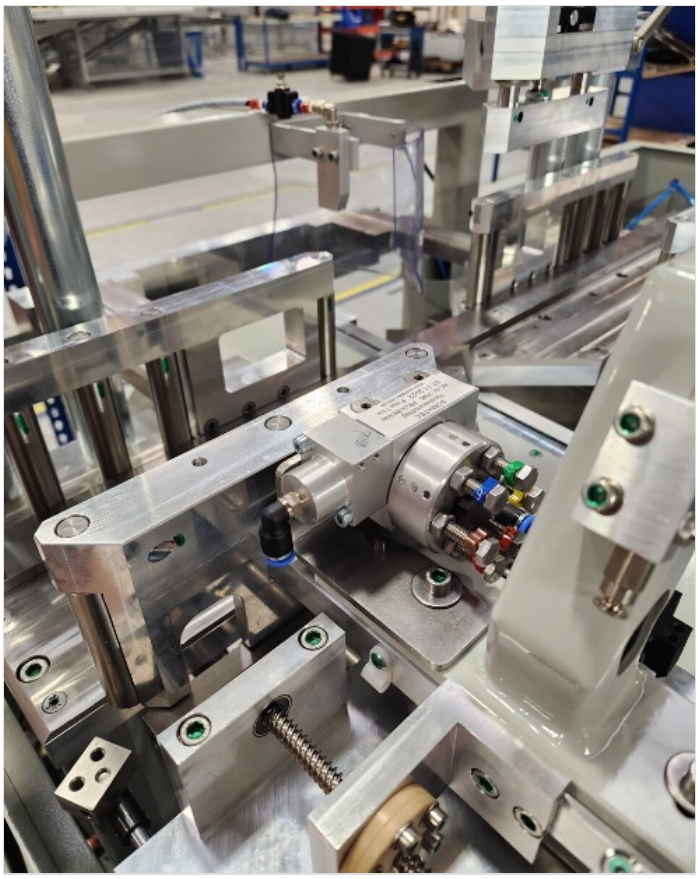




# Step 23 - Fit turret stops to brackets

Fit turret assemblies to brackets using 6 off M6 x 16 socket caps and A form washers

## Step 24 - Fit turret stops to saddle brace

Fit turret stops to saddle braces as shown. Use existing m6 x 20 socket caps and washers to fix. Align over dowels on rear of saddle brace

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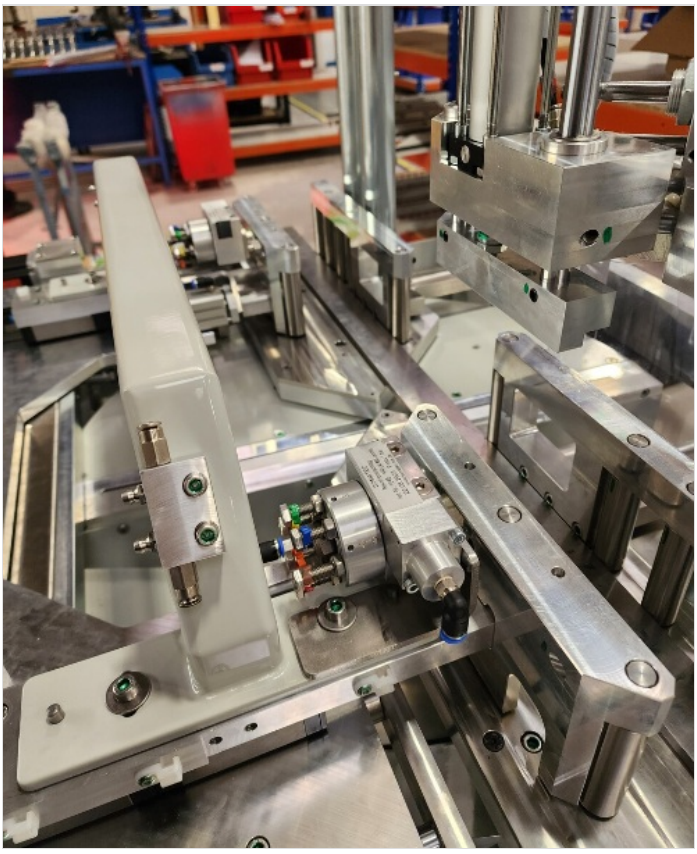


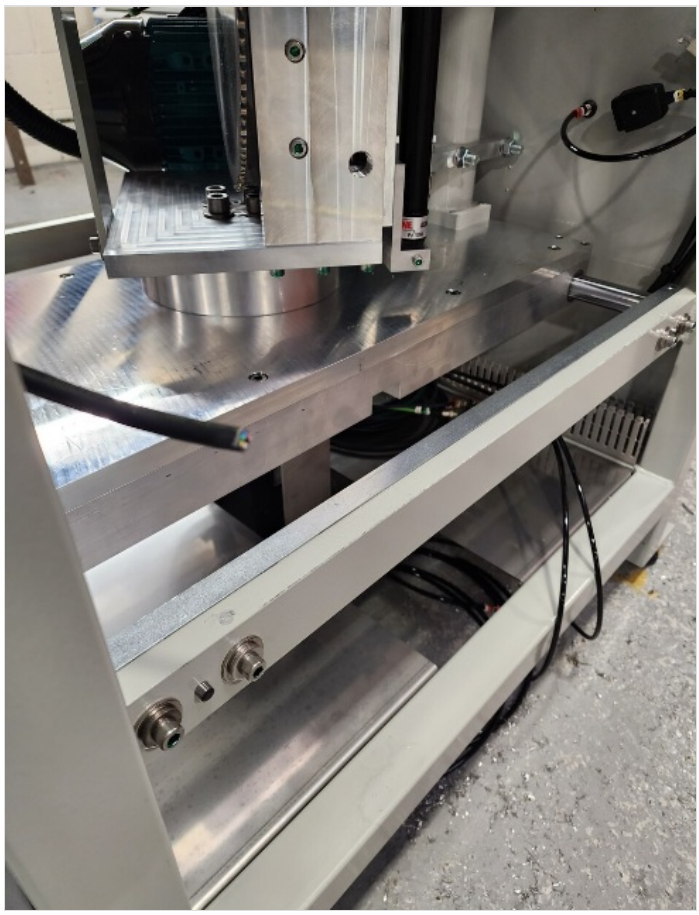
# Step 25 - Dowel lower frame

Drill 4 off holes indicated to 7.8mm through and Ream to 8mm H7

Clean with FE 10

fit 4 off 8mm x 50mm dowels to fix

Add Loctite 270 to dowels



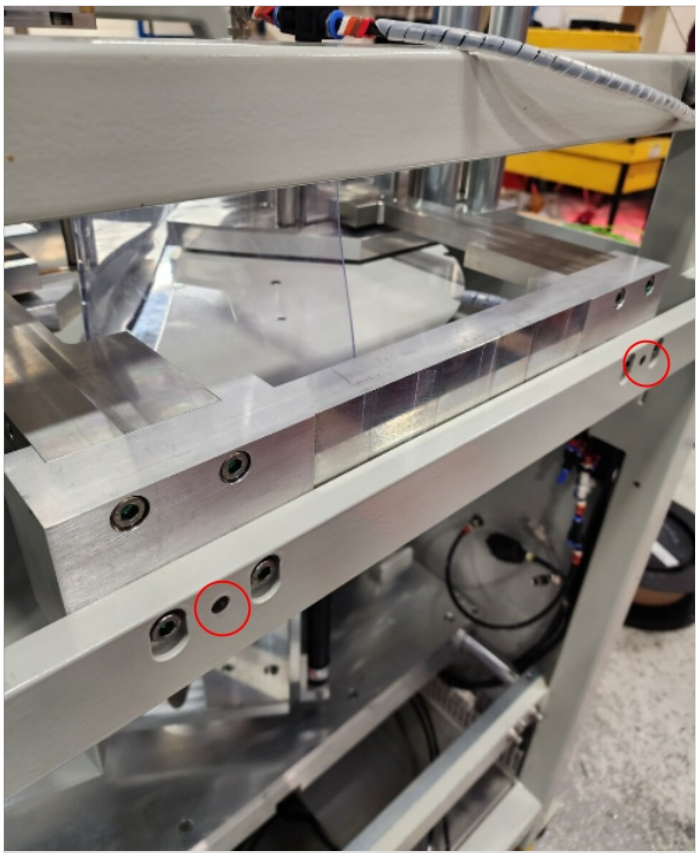
## Step 26 - Dowel backfence

Drill 2 off back fence dowel points to 7.8mm . Drill to 65mm deep to allow flush fitment of dowel

Ream to 8mm H7

Wash out with solvent

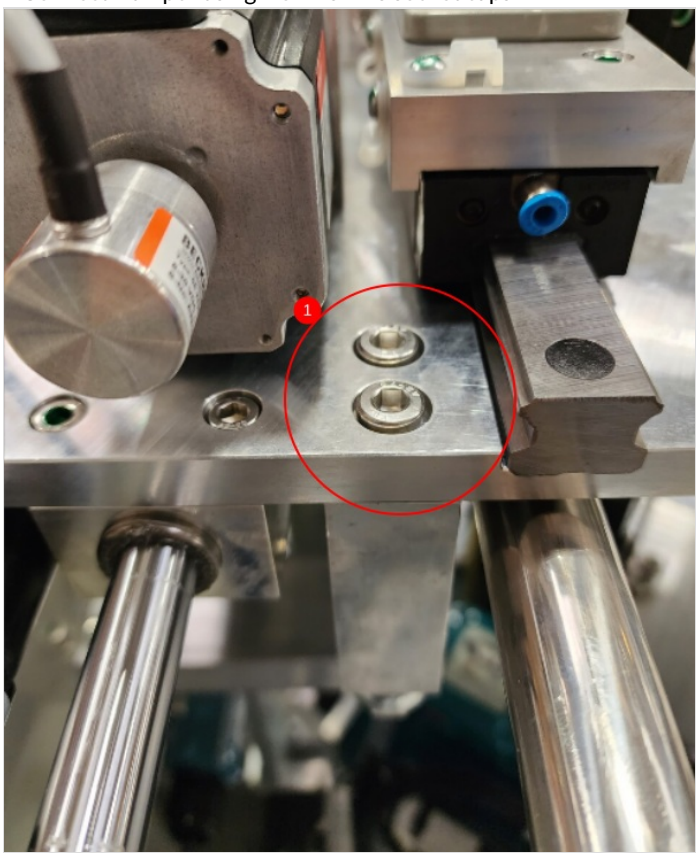
Fit 2 off 8mm x 50mm dowels with Loctite 270



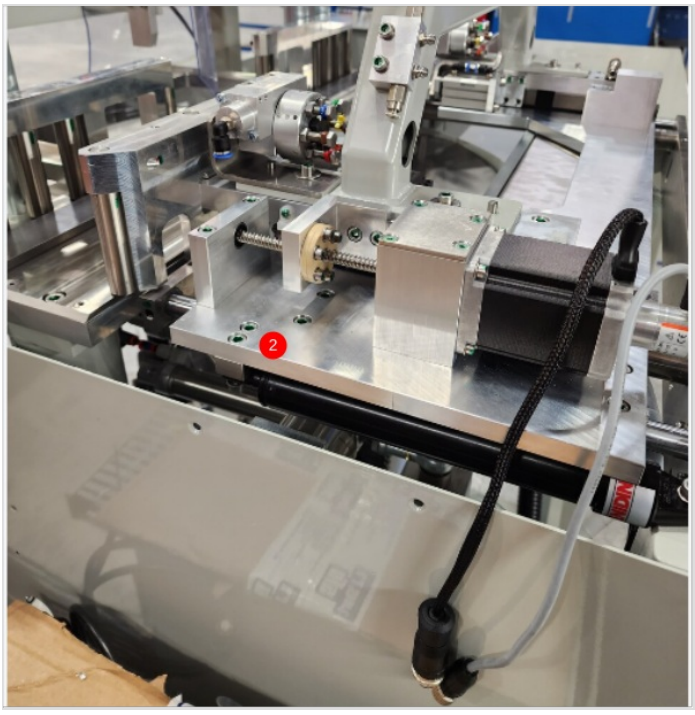
# Step 27 - Connect Damper and cylinder

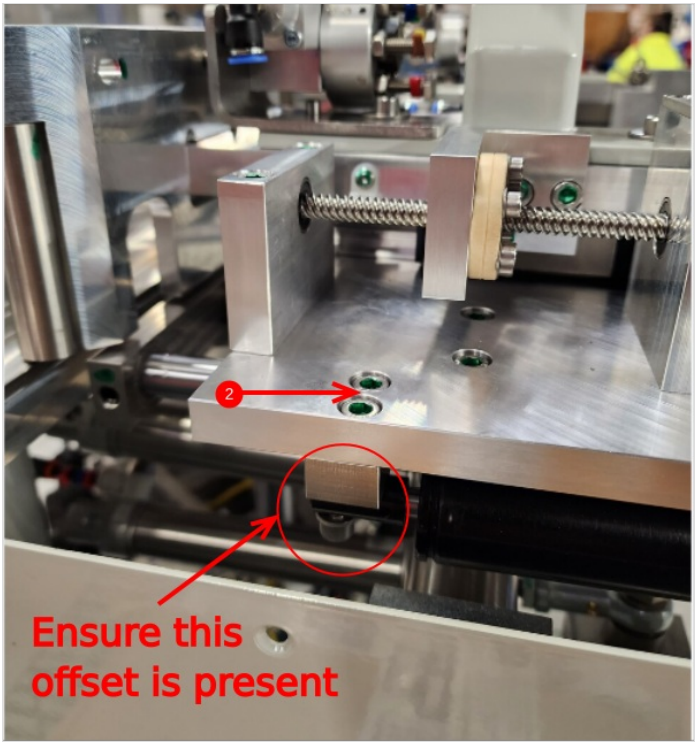
1 Connect Cylinder mount block with 2 off M8 x 25 socket caps

2 Connect Damper using 2 of M6 x 16 socket caps



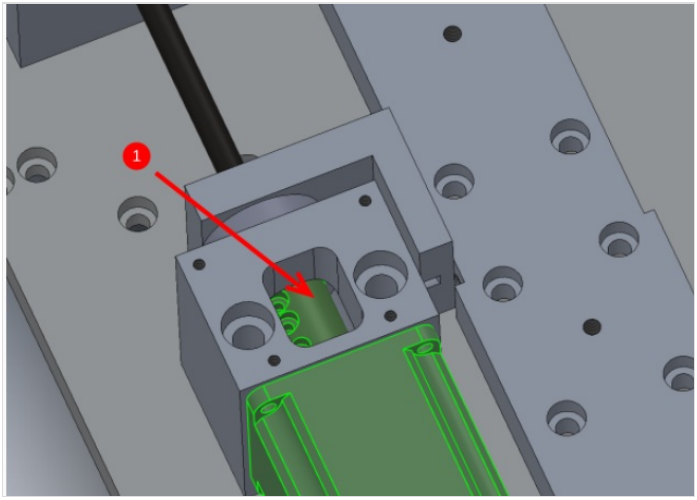


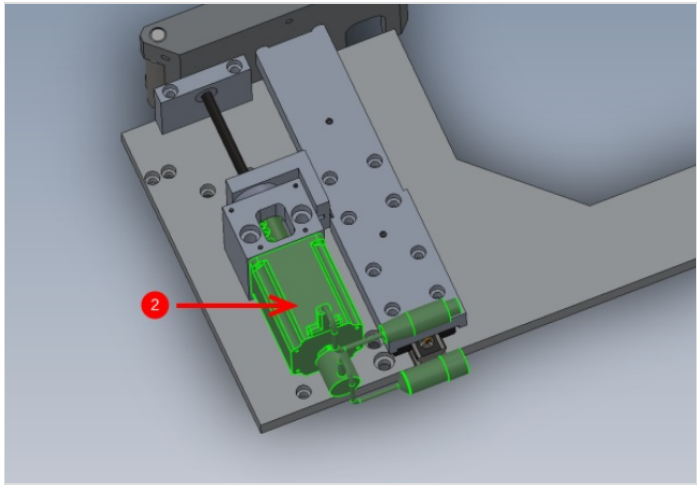


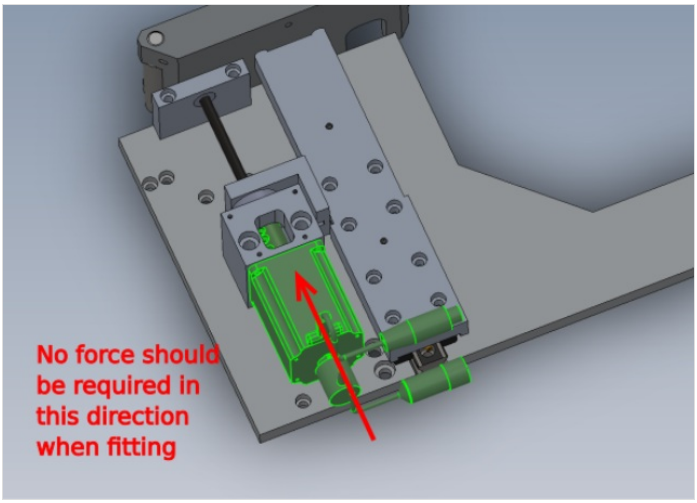


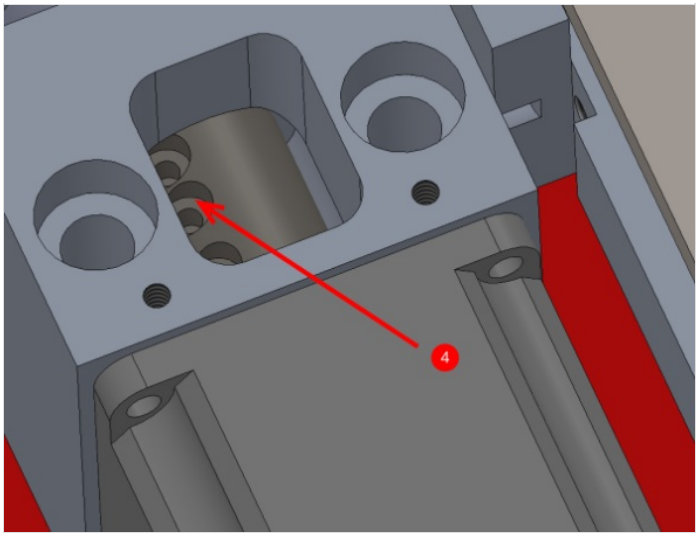

## Step 28 - Fit stepper motor and coupling

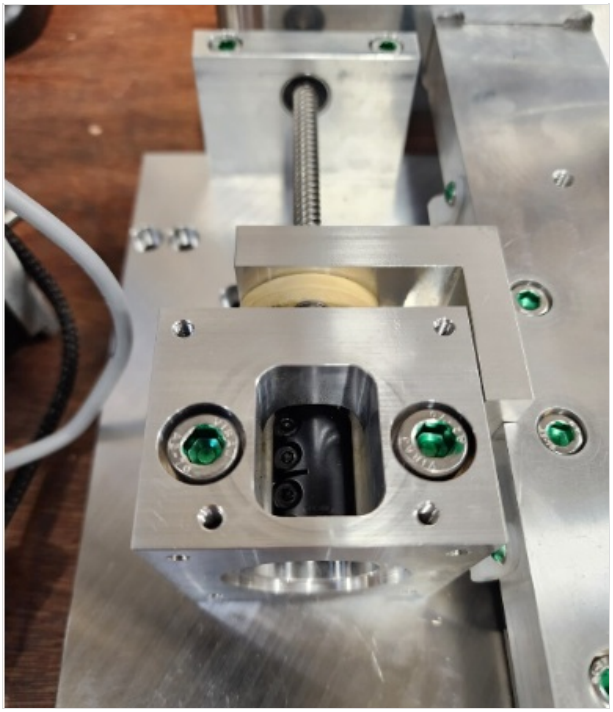
1 Fit D0015240 Collar Clamp to leadscrew as shown
2 Fit C0001005 Stepper Motor AS1050 as shown. One side will fit to stepper motor, Ensure orientation the correct way





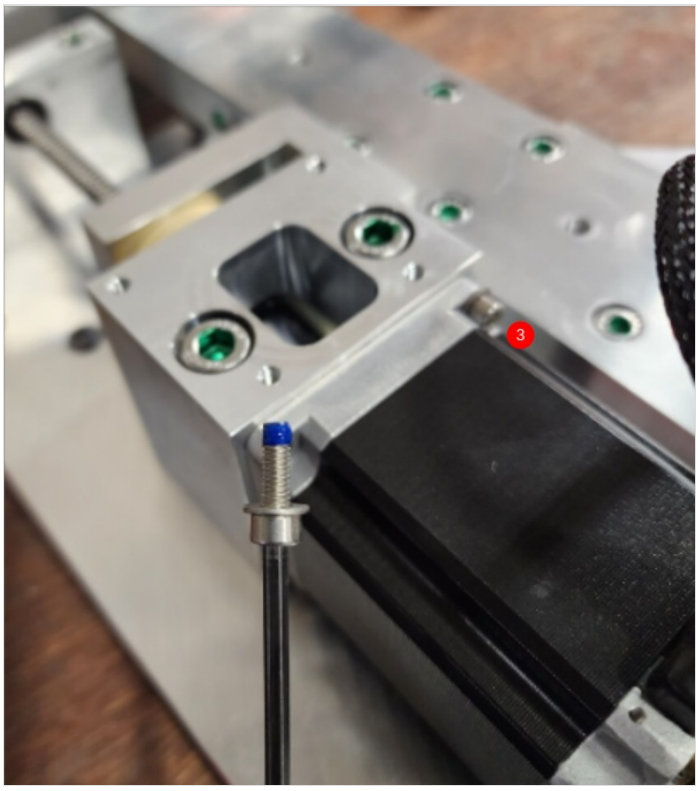



## Step 29 - Fit stepper motor and coupling

3 Secure stepper motor with 4 of M4 x 12 socket caps
4 Check Coupling is not in contact with housing wall
Apply adhesive to coupling fasteners and tighten to maximum

> ...There must be no force required in the direction shown when fitting these components. If force is required investigate to identify cause

5 Fit D0015316 Leadscrew Bearing Block Cover with M4 x 10 countersunk boltsS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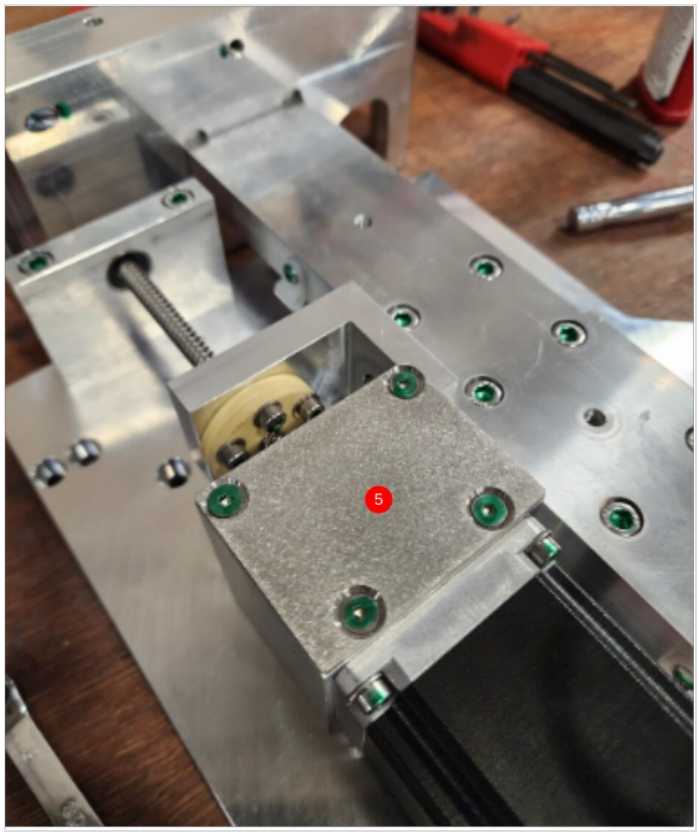
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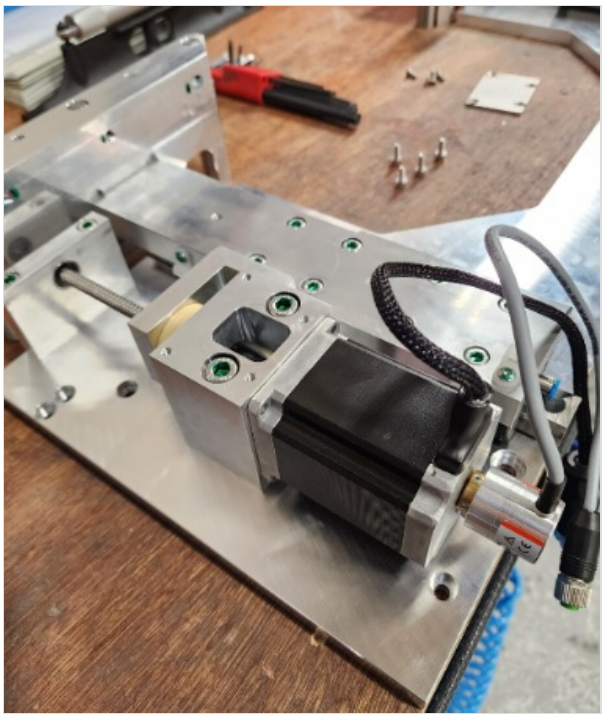

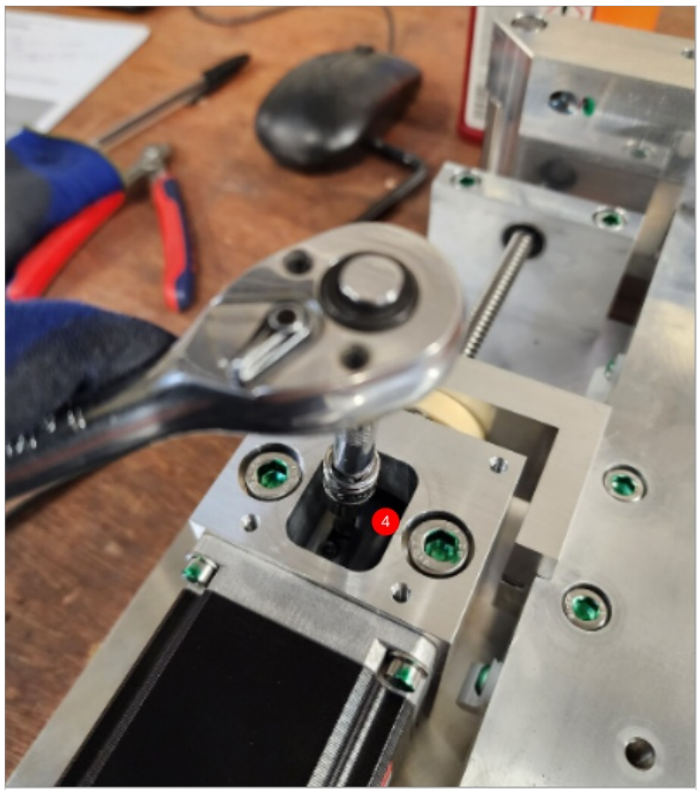
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