


R0015334 Fit Centralise Front Table

Fitting and setting details for Sy assembly and centralise top table

 Difficulty **Hard**

 Duration **4 hour(s)**

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Comments

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

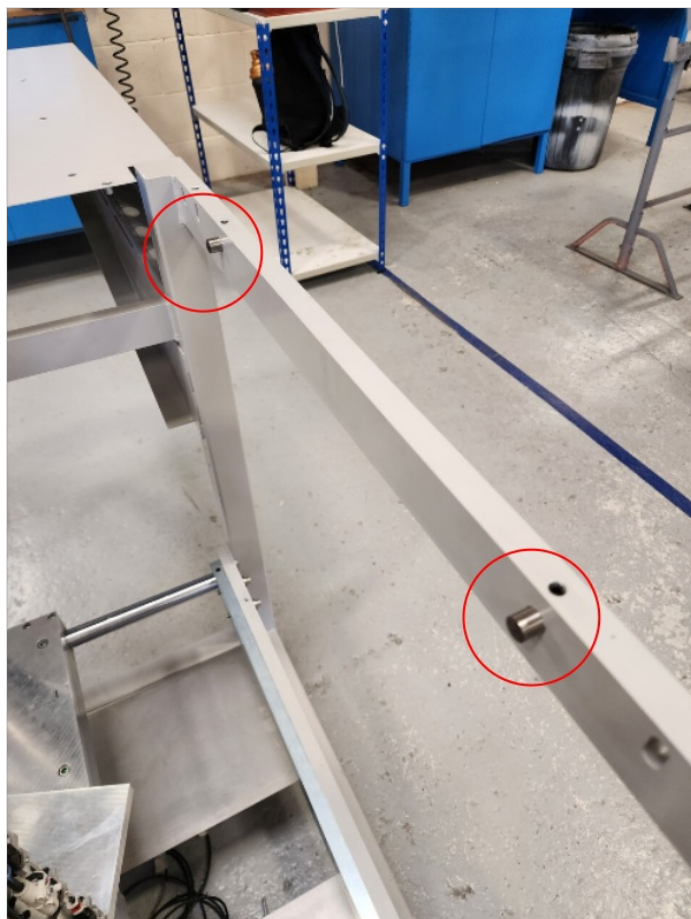
All bolts to be pen marked once adhesive applied and correct tension added



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 grub screws



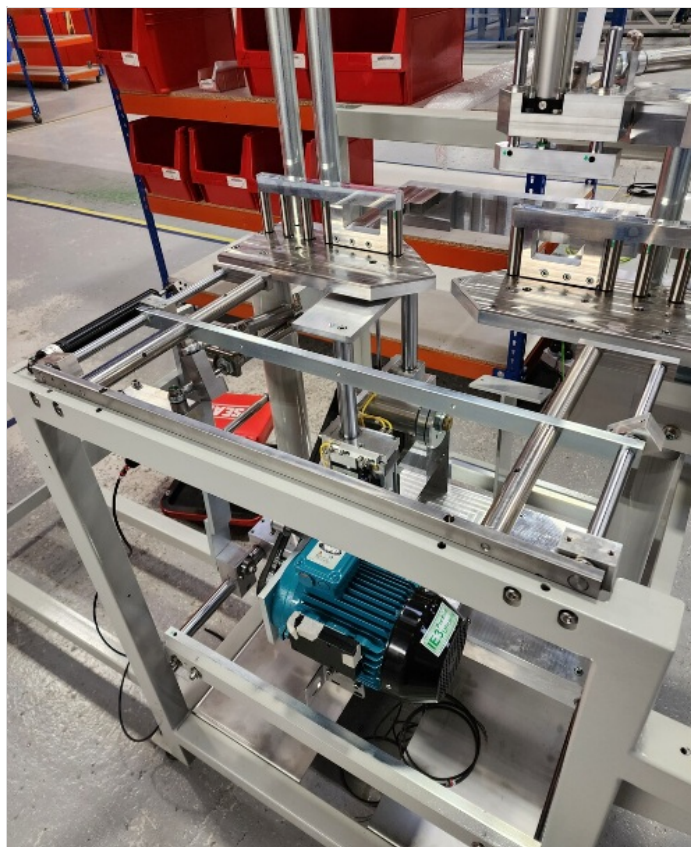
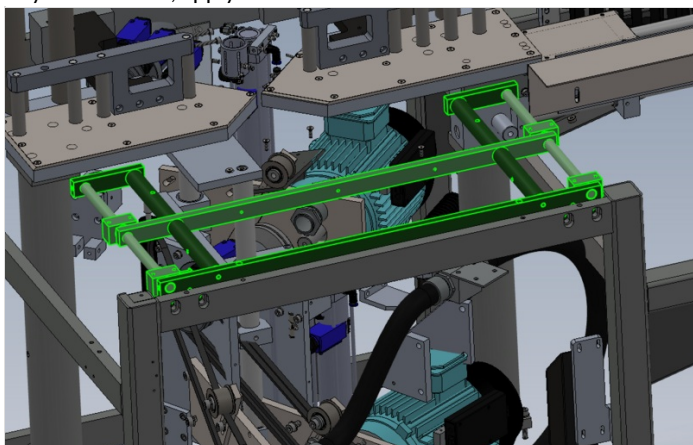
Step 3 - Mount R0000562 Bench assemble centralise top table

Attach R0000562 Bench assemble centralise top table as shown

Use 4 off M8 x 20 socket caps

Fit assembly at highest position in slots

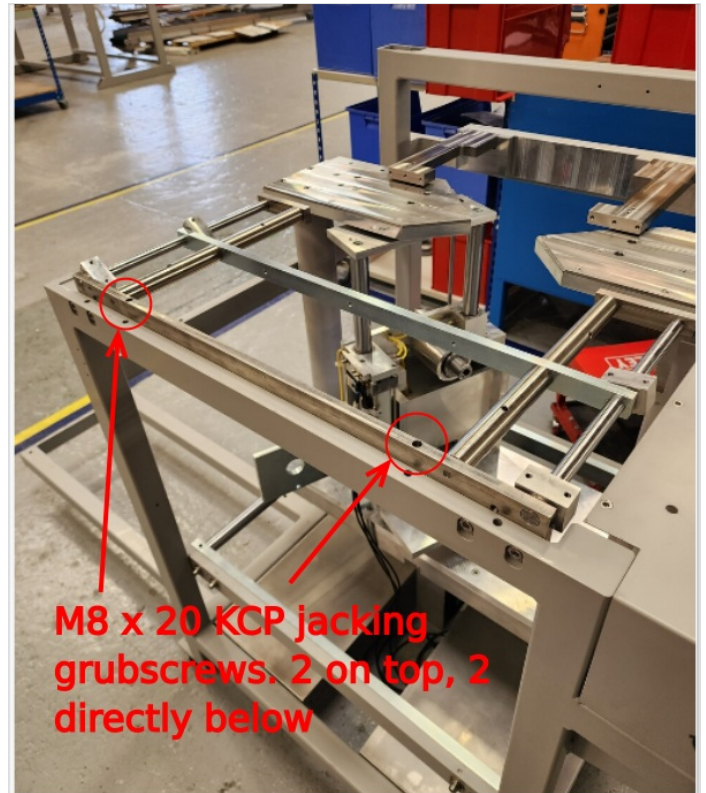
Dry fit fasteners, apply medium tension



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





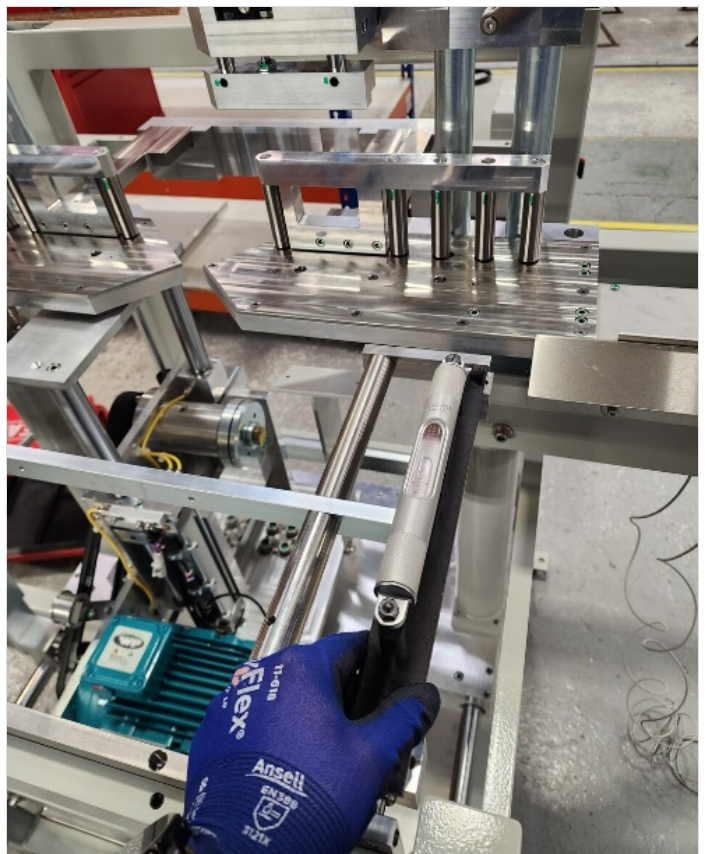
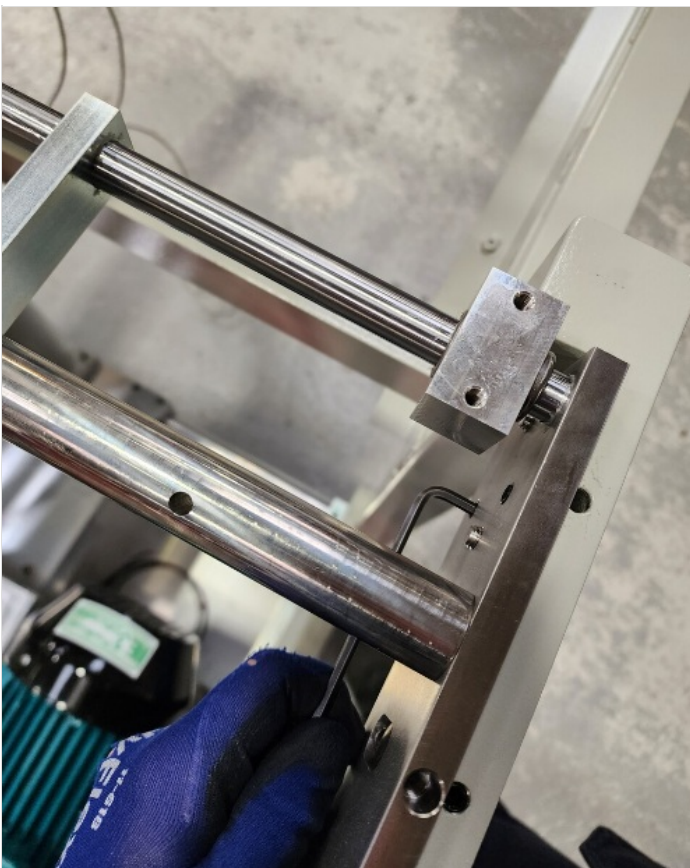
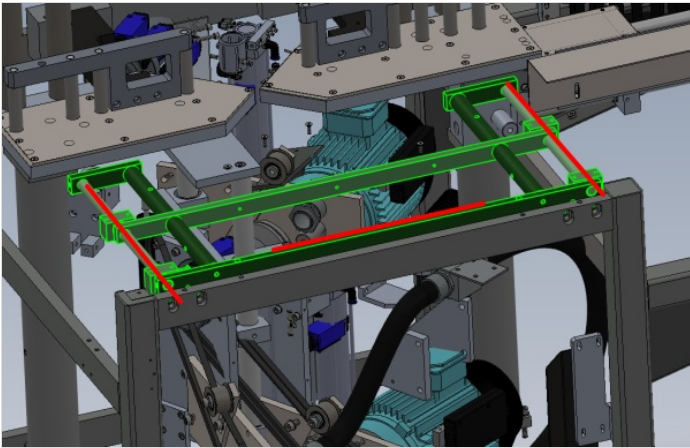


Step 6 - Adjust position

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

Use M8 squareness adjusting grub screws to set position

Set both positions level

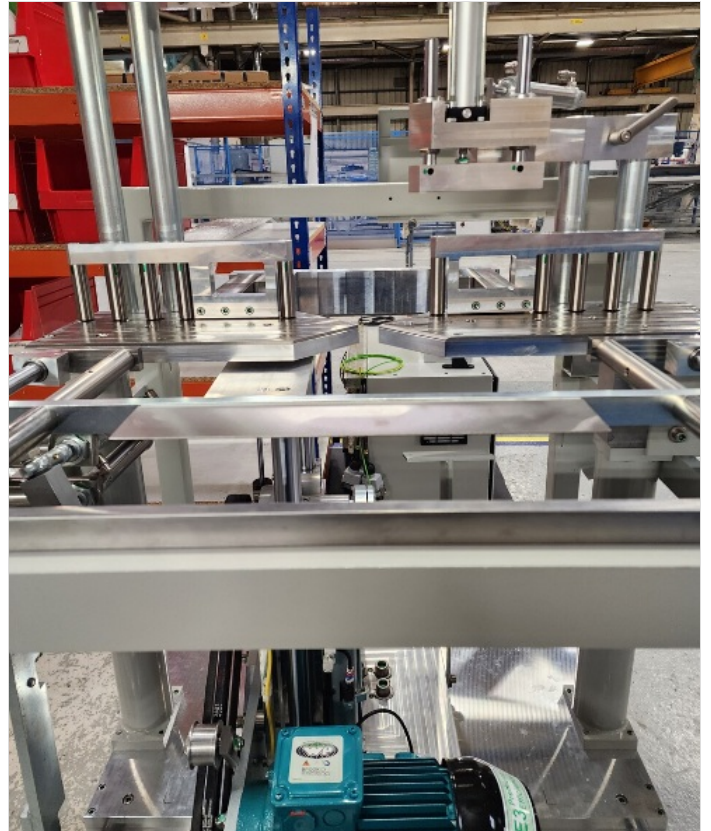
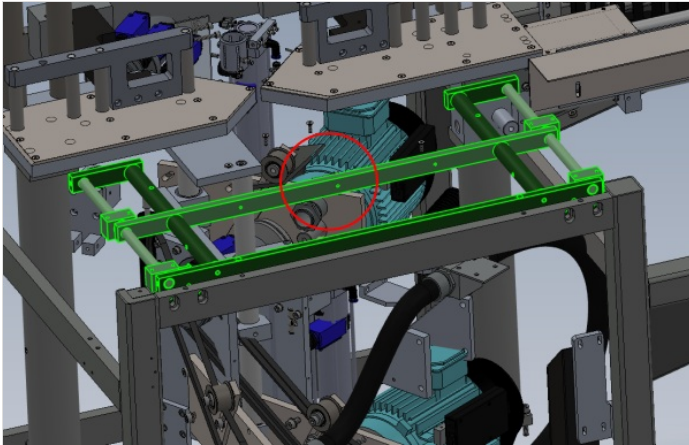


Step 7 - Fit finger Guard

Fit H0004543 Gap cover saw finger guard to assembly

Use 3 off M5 x 12 socket caps and A form washers

finalise fasteners



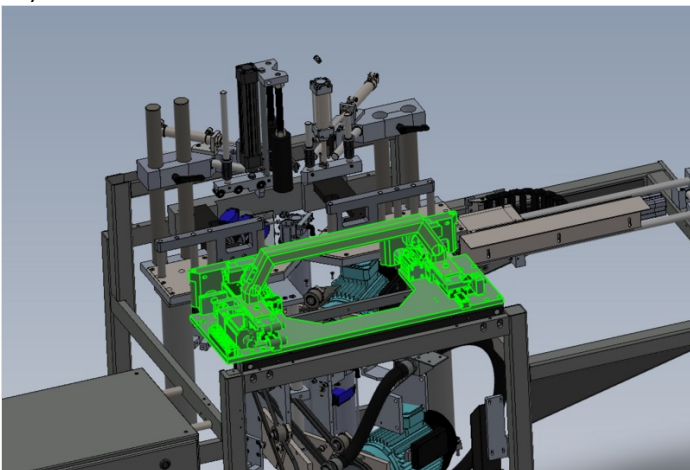


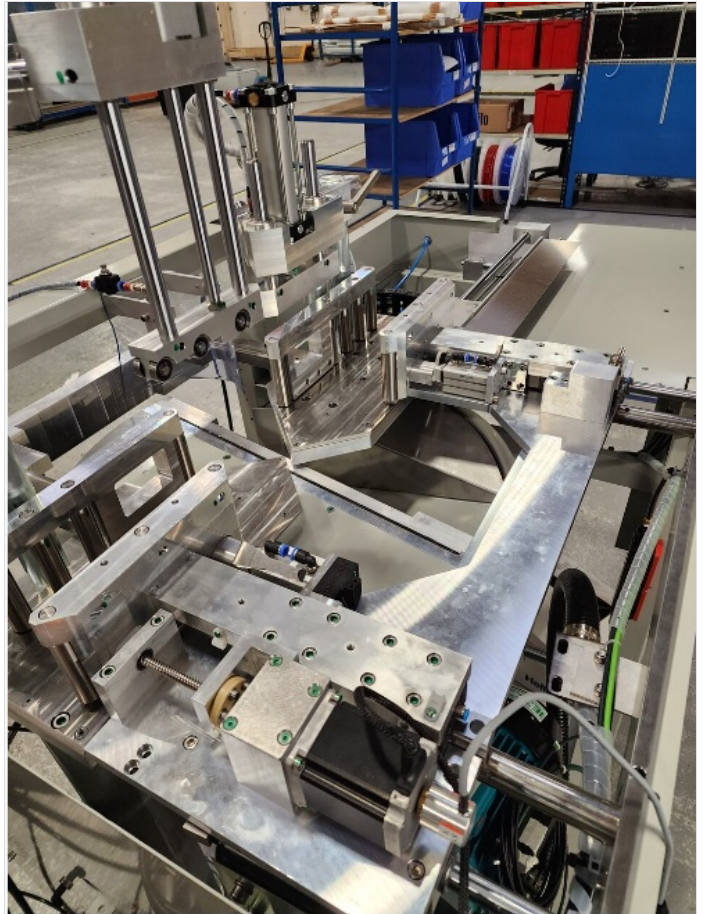
Step 8 - Mount R0015037 Bench assemble SY Assembly

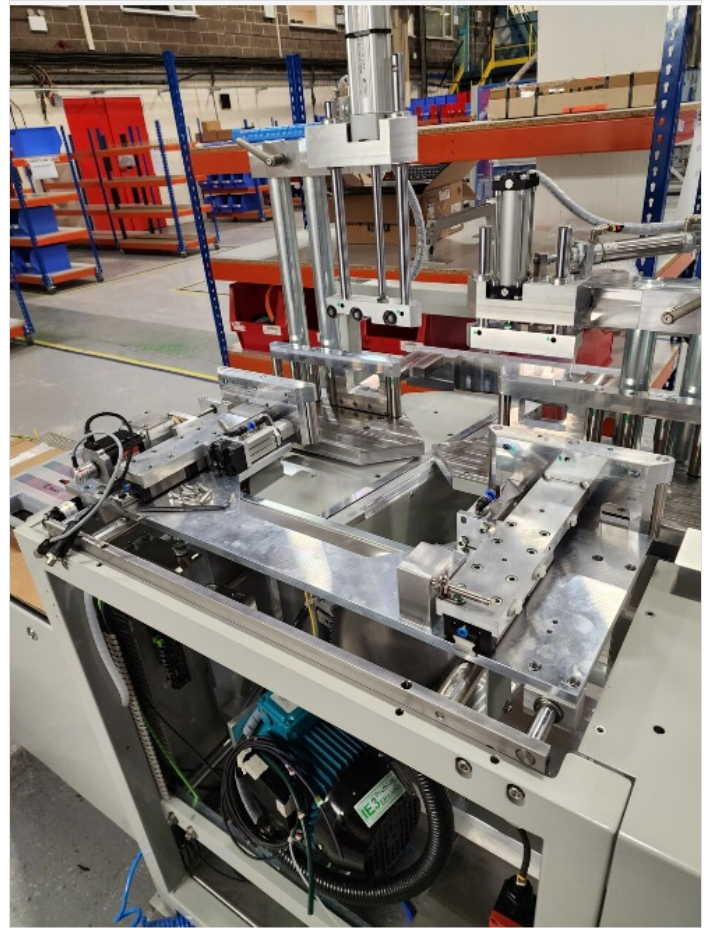
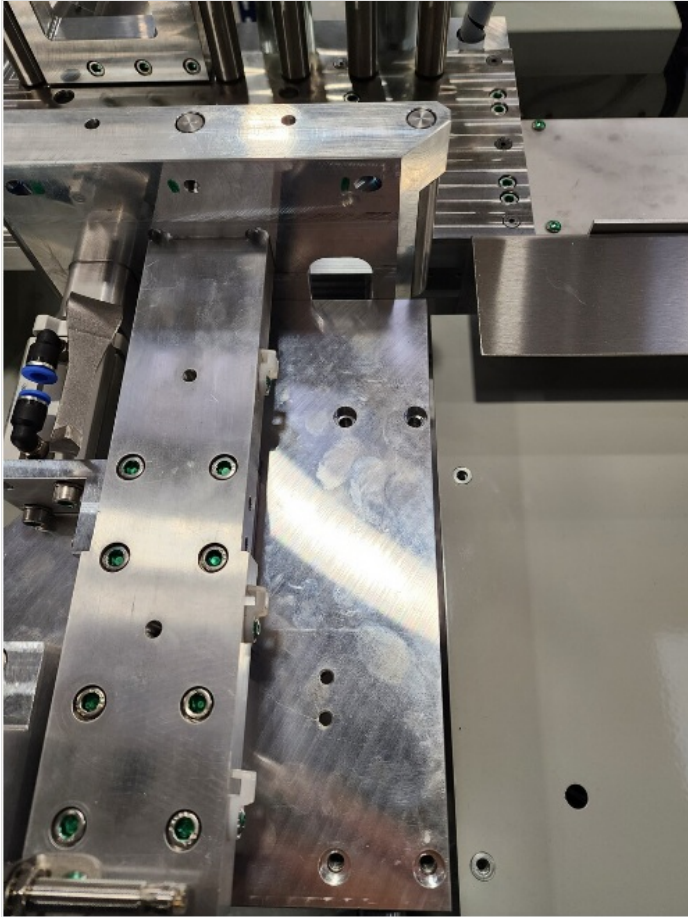
Mount R0015037 Bench assemble SY Assembly

Use 8 off M6 x 20 socket caps

Dry fit fasteners







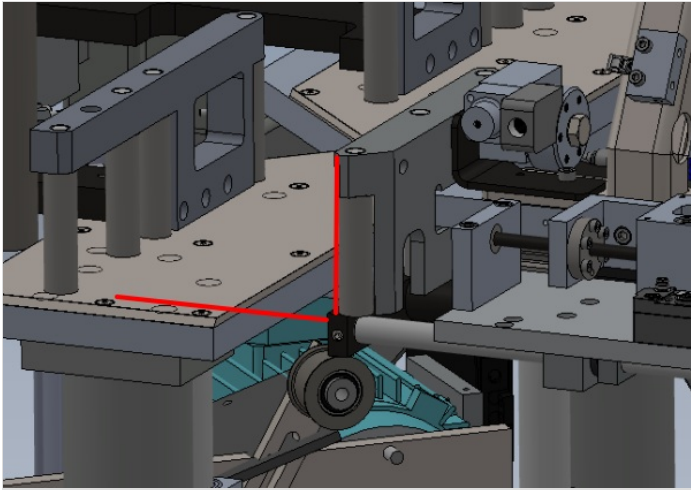
Step 9 - Adjust square

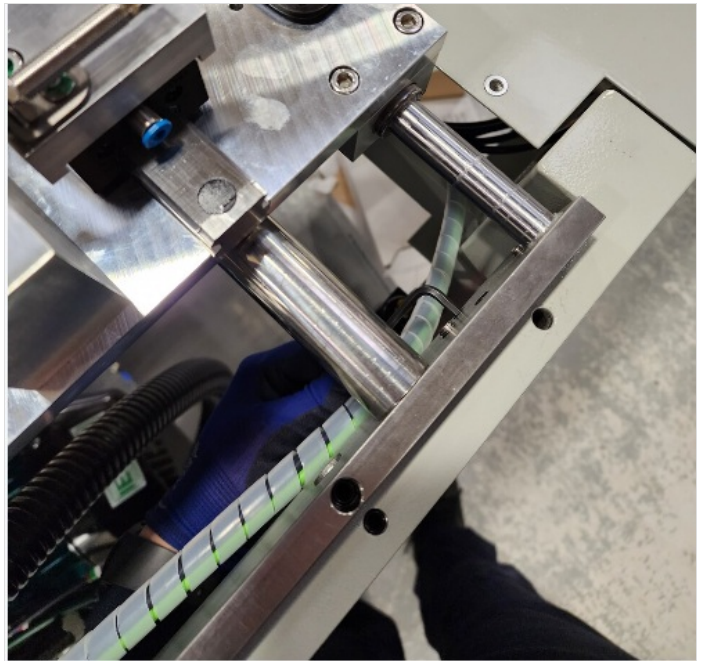
Use engineers square to check squareness of front rollers to infeed and outfeed cut tables

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







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

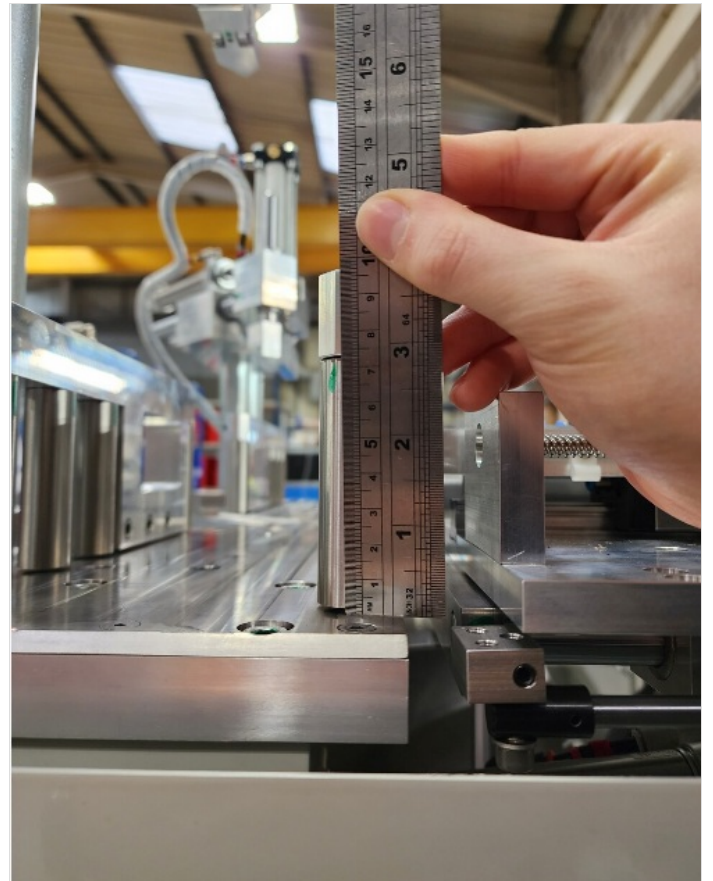
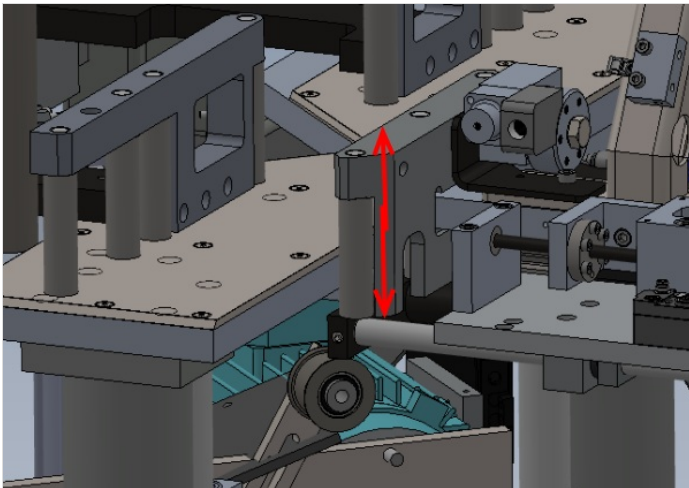
Release pressure on front 4 off M8 x 20 socket caps

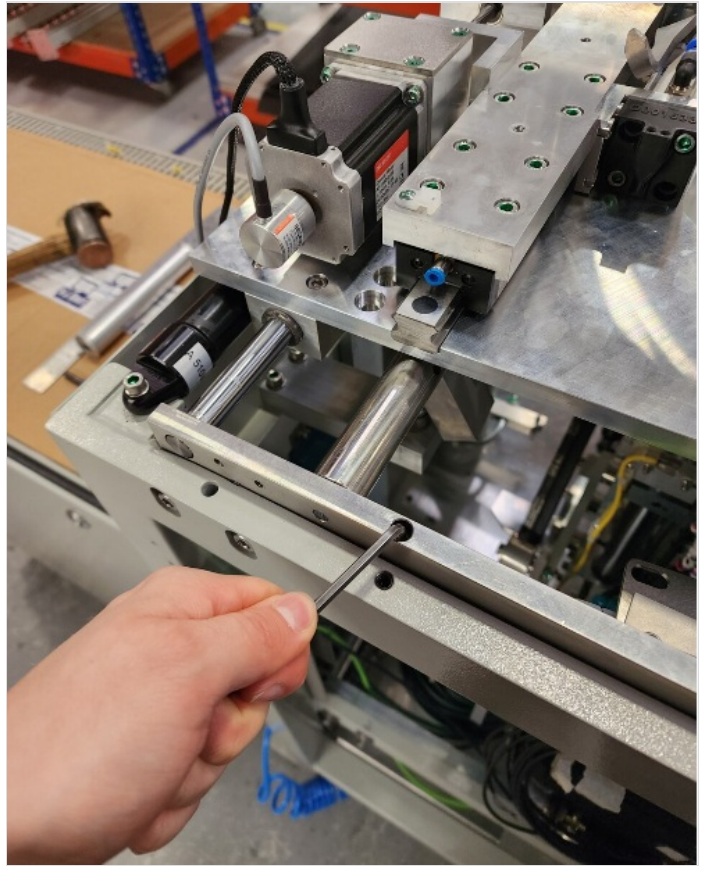
Use M8 x 20 grubscrews to adjust height of assembly

Set to gap of 1.5mm \pm 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



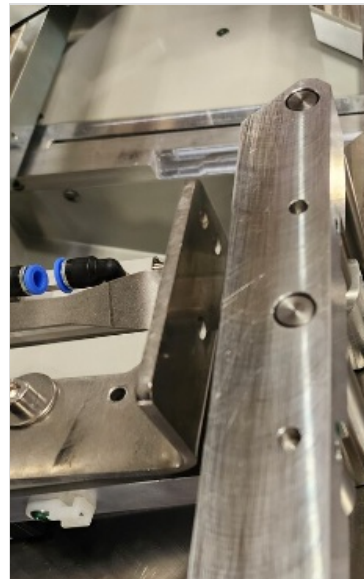
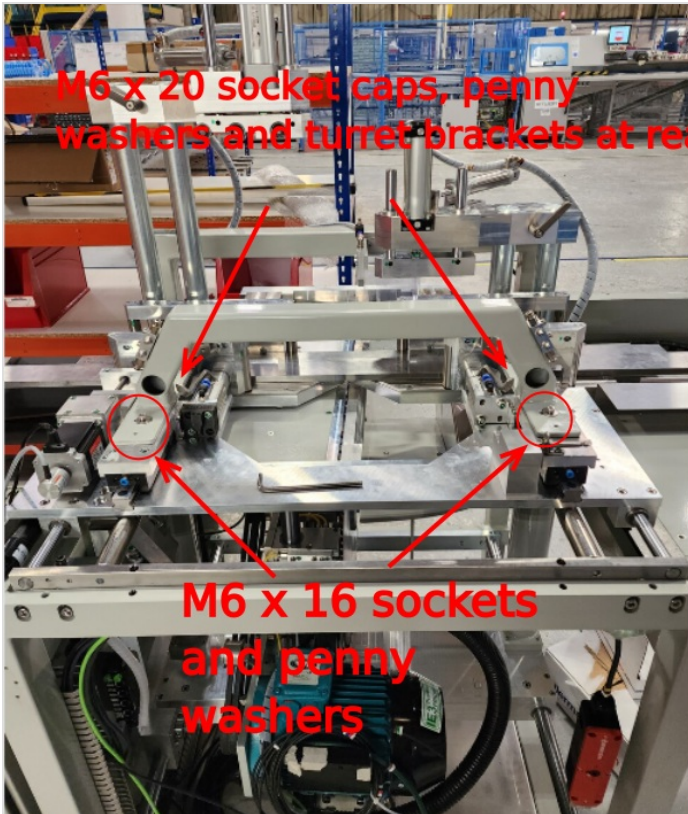
Step 13 - Attach saddle brace

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





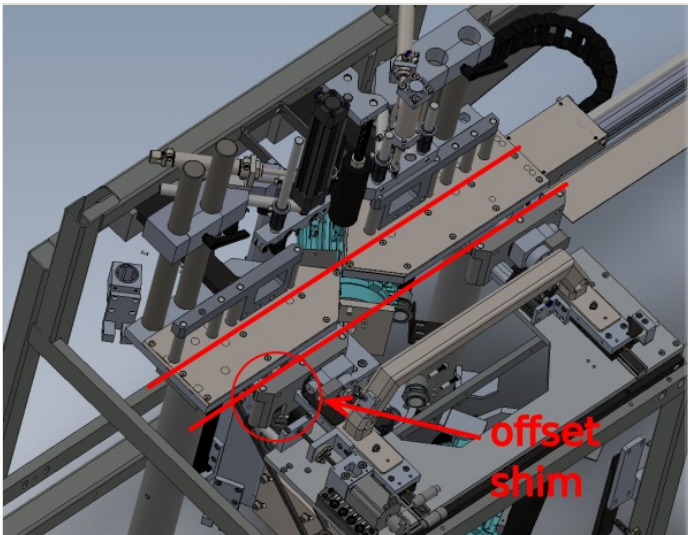
Step 14 - Set Parallel to backfences

Use 2 off straight edges against back roller fence

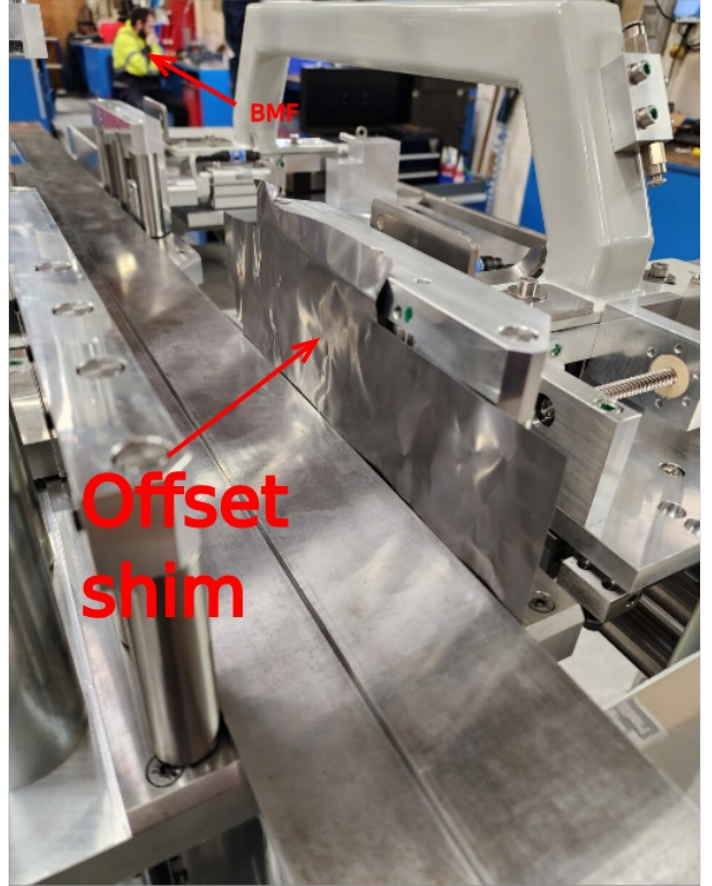
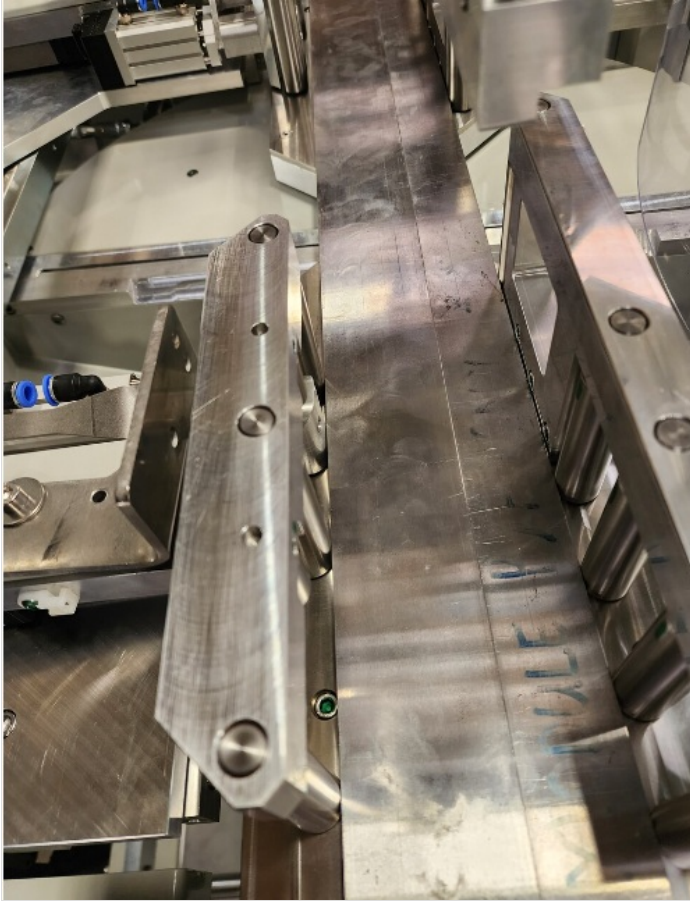
Add offset shim of 0.002"/0.05mm to driven side

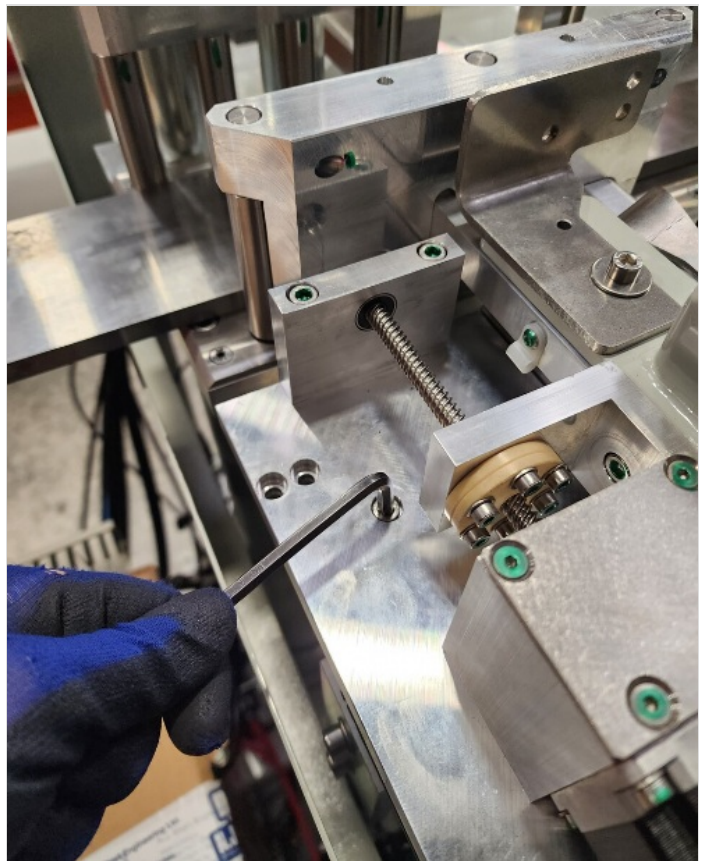
Set front rollers to touch, using M6 socket caps and counter bore clearance to adjust

Report if unable to achieve parallel from this movement





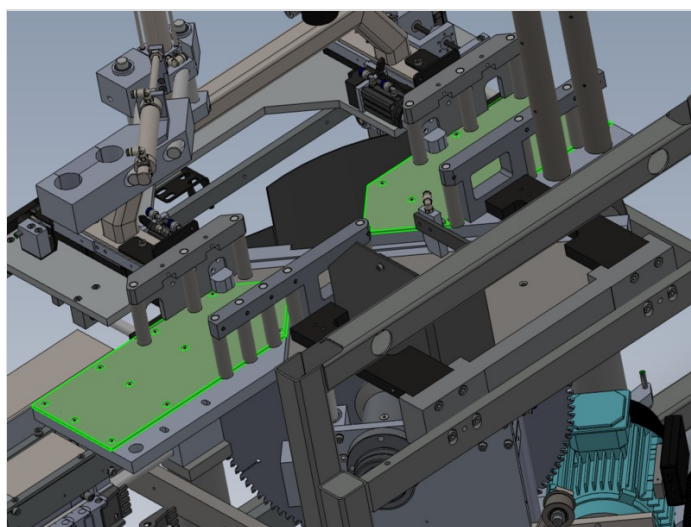
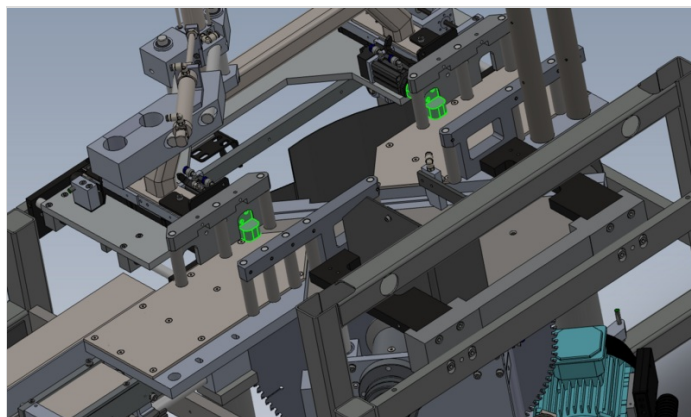




Step 15 - Quality check

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

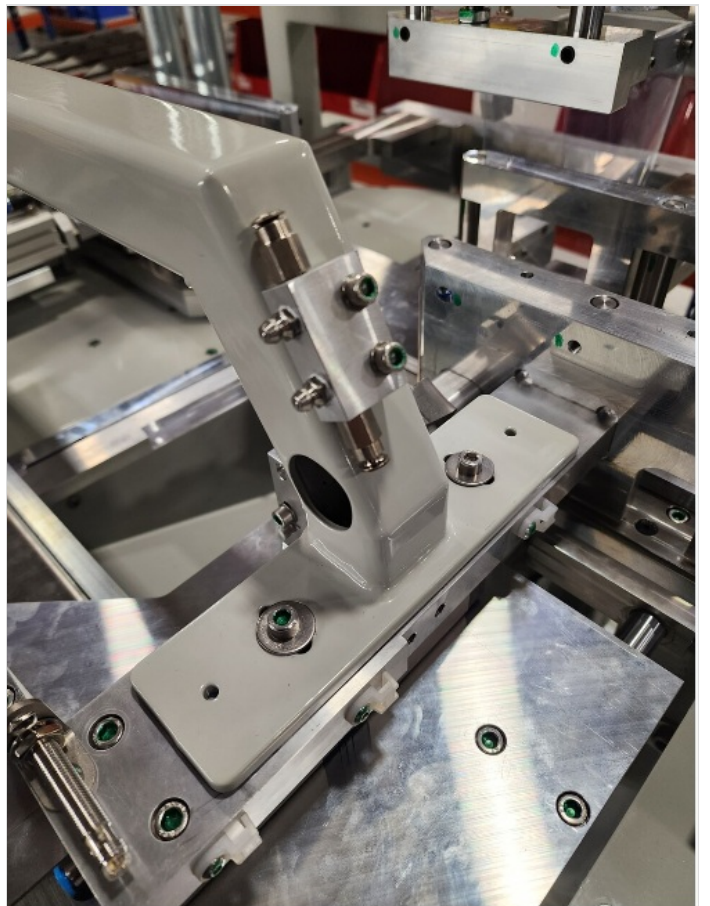
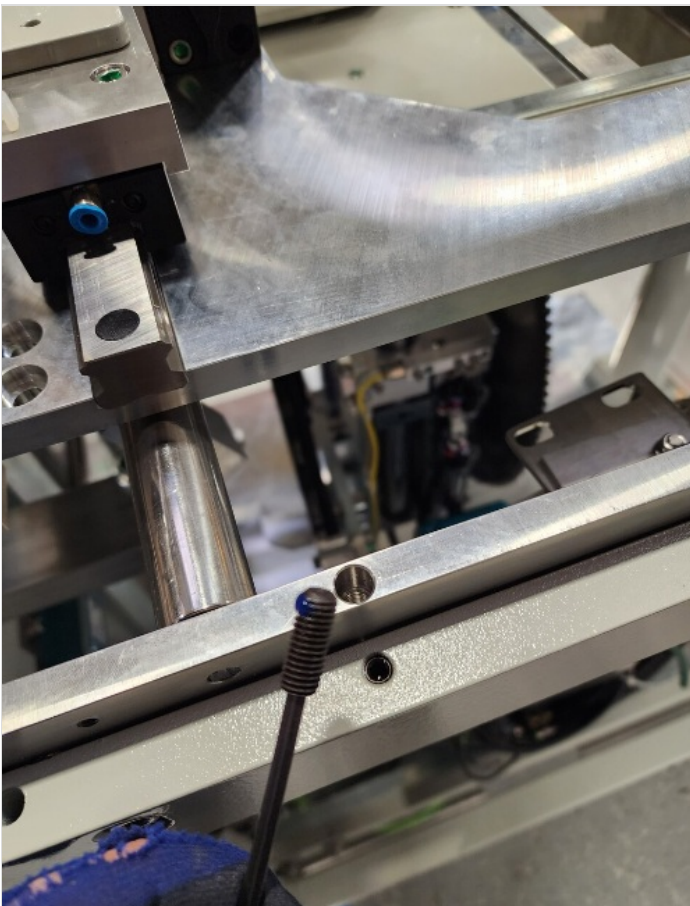
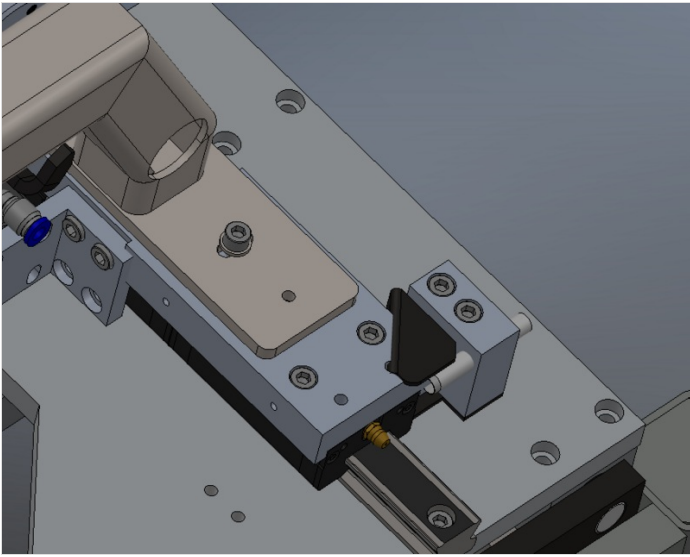
Parallel to back fences



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 grub screws

Check that no adjustment grub screws are loose.

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

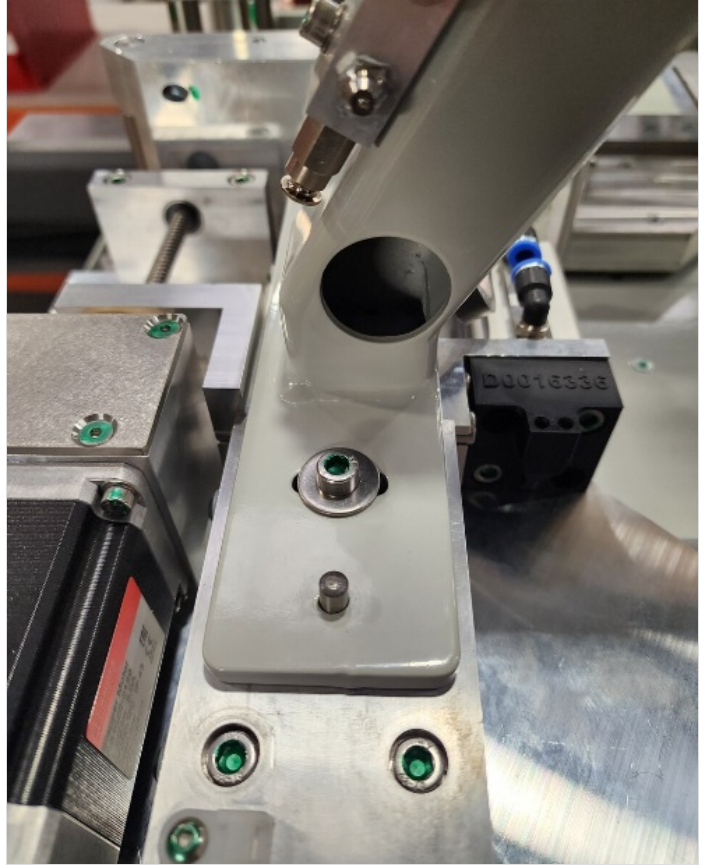


Step 20 - Dowel Saddle brace

Drill 4 off dowel points in saddle brace 5.8mm to a depth of 20mm

Ream to 6mm H7 tolerance

Use 4 off 6mm x 20 dowels to secure



Step 21 - Recheck settings

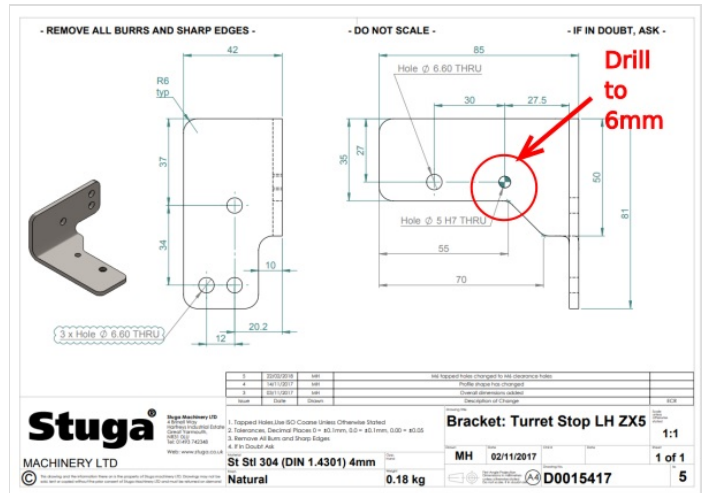
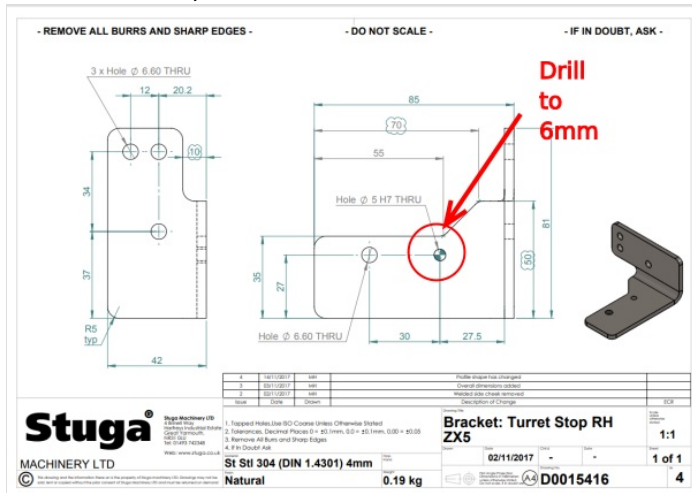
Recheck all settings once dowelled to ensure no movement has occurred



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



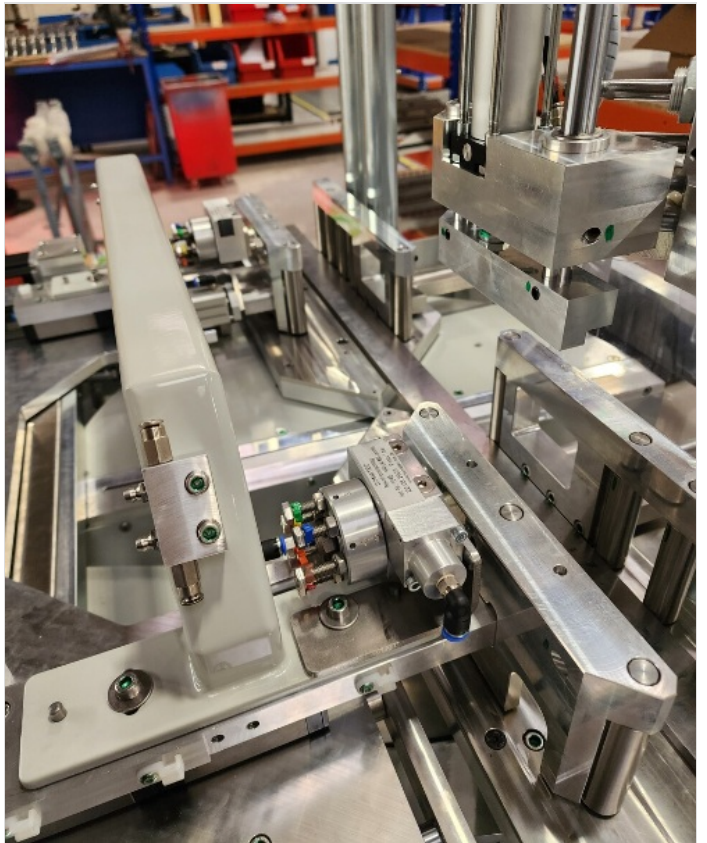
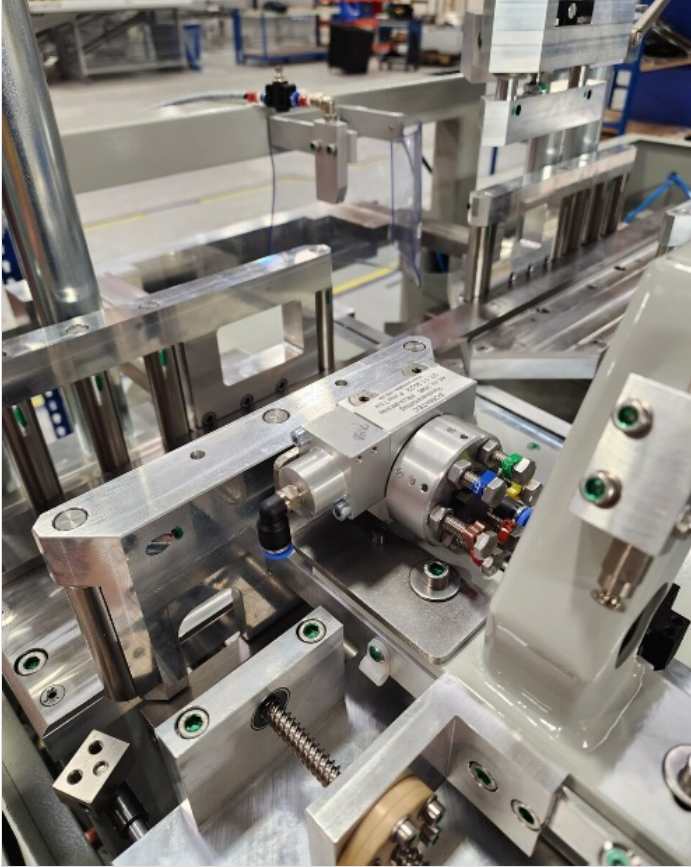
Step 23 - Fit turret stops to brackets

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



Step 25 - Dowel lower frame

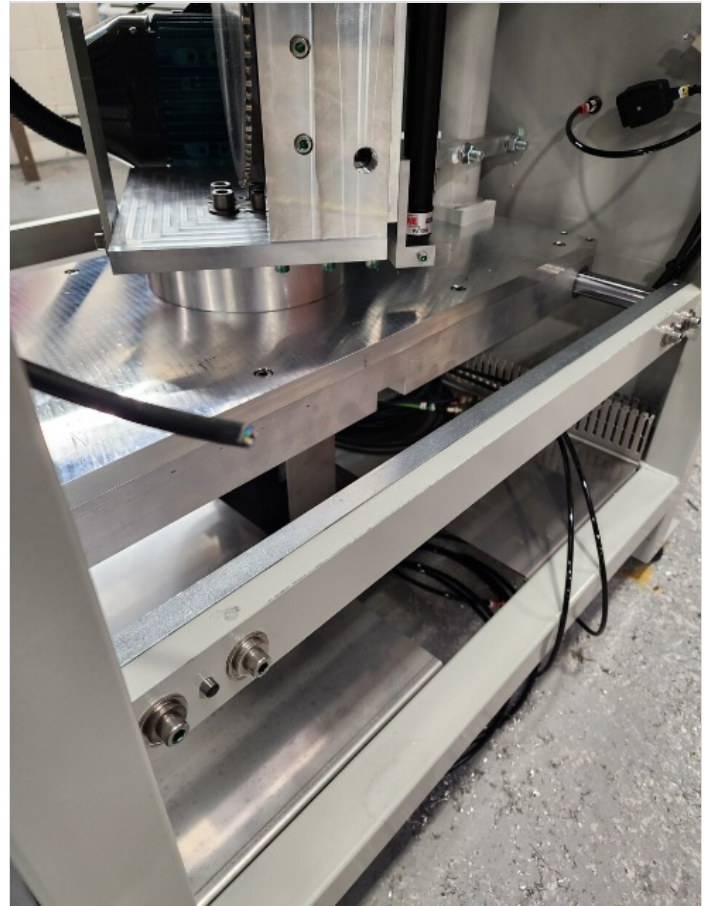
Drill 4 off holes indicated to 7.8mm through and Ream to 8mm H7

Clean with FE 10

fit 4 off 8mm x 50mm dowels to fix

Add Loctite 270 to dowels





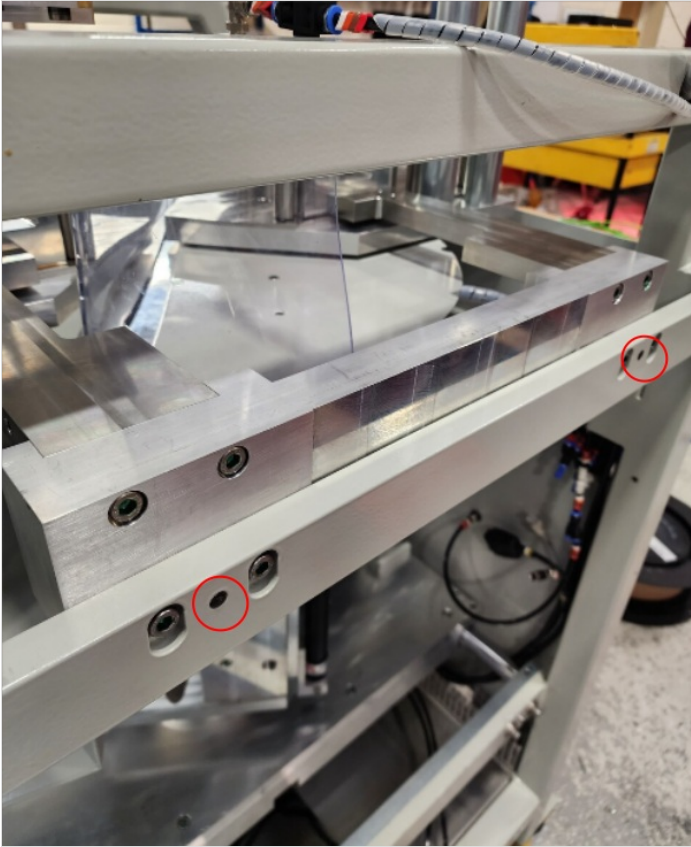
Step 26 - Dowel backfence

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

