

# R0015341 Bench Assemble Electrical Cabinet with Pneumatics and controls

Assembly details for Module F cabinet pneumatics

 Difficulty Hard

 Duration 4 hour(s)

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Comments

## Introduction

### Tools required

Tape rule

Steel rule

standard hex keys

Standard HSS drill set

Standard Tap set

Hack saw

Ball Pein hammer

Centre punch

### Part Required

P0000010 Elbow Adaptor 6mm - 1/8 BSPT (Taper thread) x 3

P0000024 Fitting: Hex Nipple 1/4 BSP x 1

P0000096 Fitting: Brass Reducing Bush 1/2 - 1/4 x 2

P0000097 Fitting: Elbow Adaptor 8mm - 1/4 BSPT x 1

P0000159 Fitting: Stem Blanking Plug 6mm x 3

P0000160 Fitting: Flow Controller In Line 6mm x 2

P0000279 Female Cross 1/4" NPT x 1

P0000297 HighLow Pressure Valve x 1

P0000419 Air Service Unit OH (P0283)x 1

P0001070 Valve Base: Type 41 6 Position Ø6 x 2  
P0001074 Fitting: 1/4" BSP Hex Head Silencer x 8  
P0001101 Male straight 12mm to 1/4 bsp x 5  
P0001102 Male elbow 12mm to 1/4 x 2  
P0001186 Valve 24v dc SMC x 12

## 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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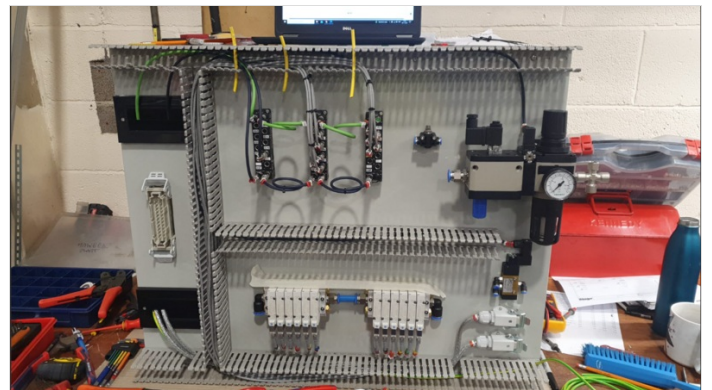
## Step 2 - Handing

Dokit will show configuration for R-L machine

Mirror mounting for all components for L-R configuration

See reference photo

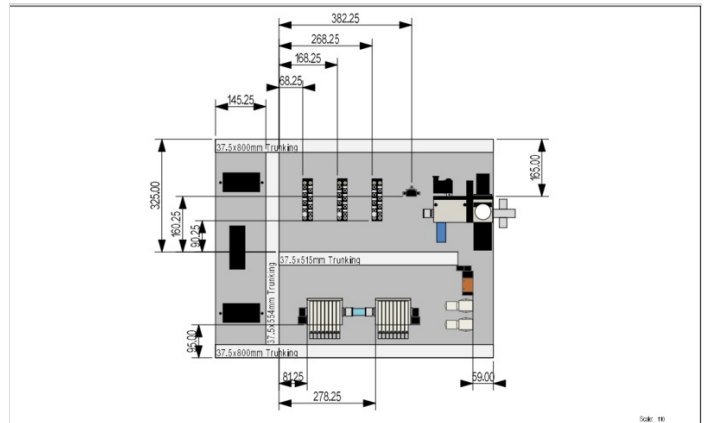
(please take photo of L-R config please)



## Step 3 - Attach trunking

Cut trunking and fit to cabinet securing with M5 x 5 button heads fasteners

Holes will require adding by hand to cabinet to mount trunking



## Step 4 - Assemble Valvebanks

Assemble valve banks configured as shown

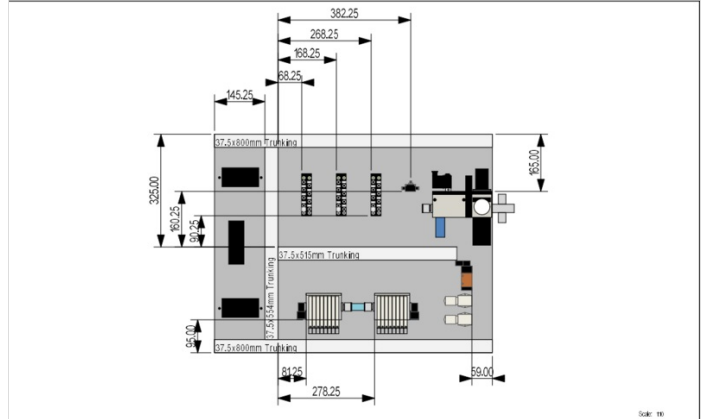


# Step 5 - Mount Valvebanks

Drill Cabinet for mounting of valve banks in position shown

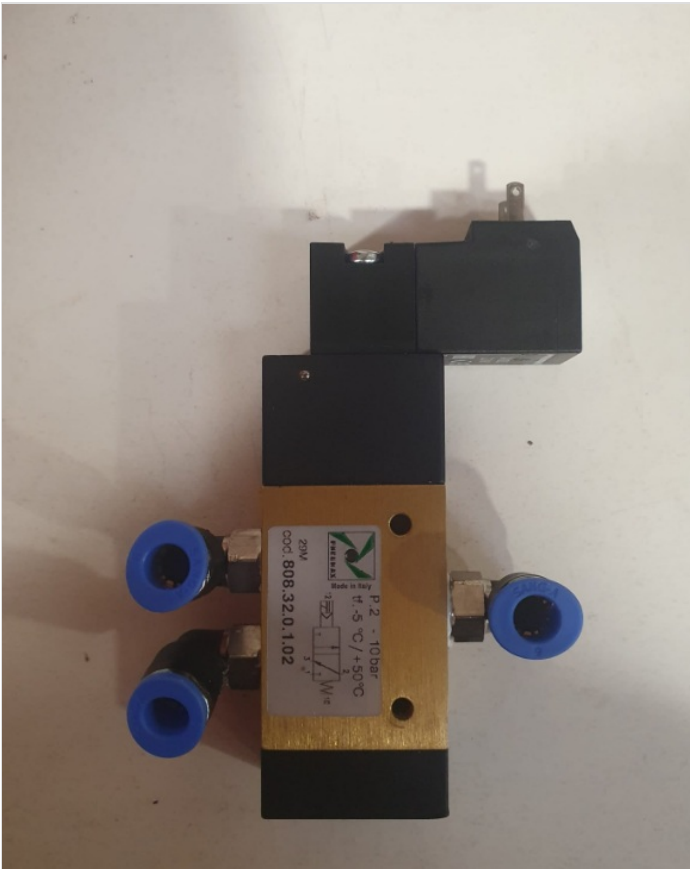
Use M4 x 40 socket caps and M4 A form washers to fix

Ensure 12mm blue pipe is added to pneumatically couple valve banks as shown



# Step 6 - Assemble High Low pressure valve

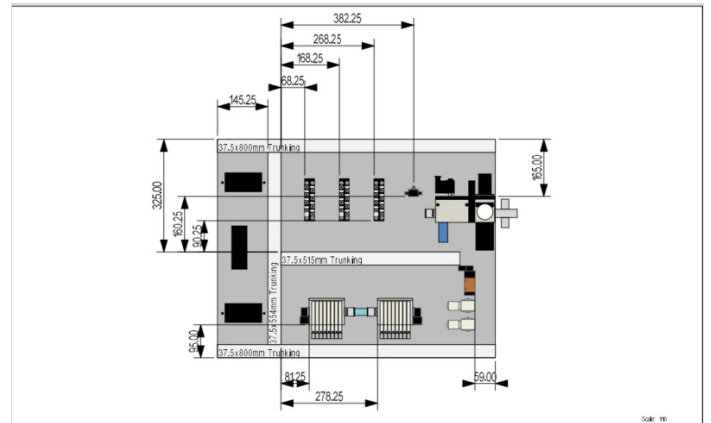
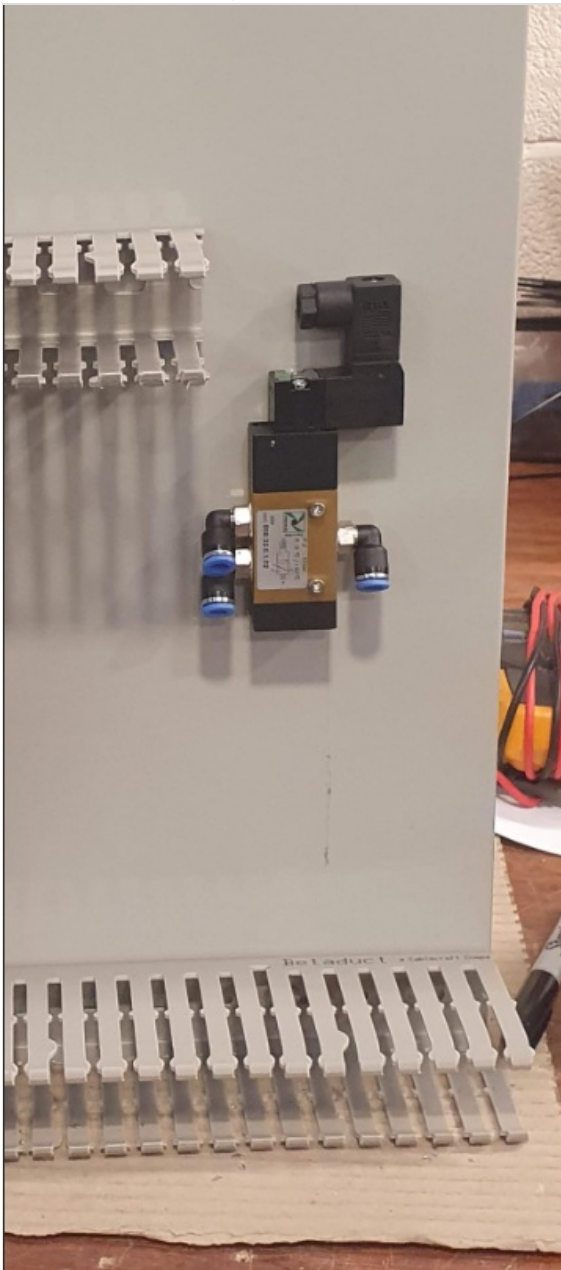
Assemble P0000297 valve with 3 off P0000010 air fittings as shown



## Step 7 - Mount valve to cabinet

Mount valve to cabinet positioned as shown.

Use M3 x 25 socket caps to fix

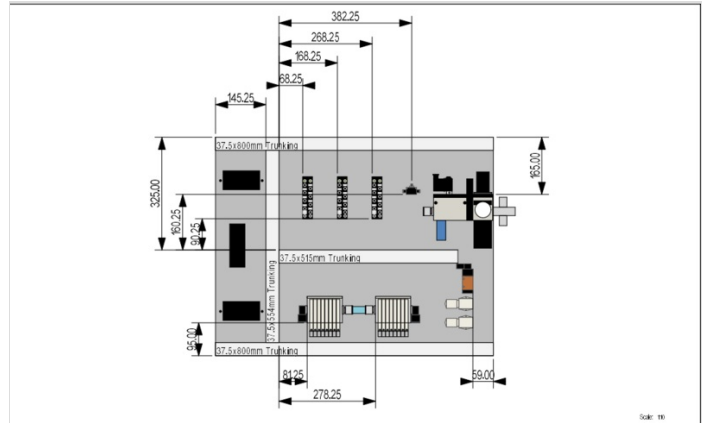
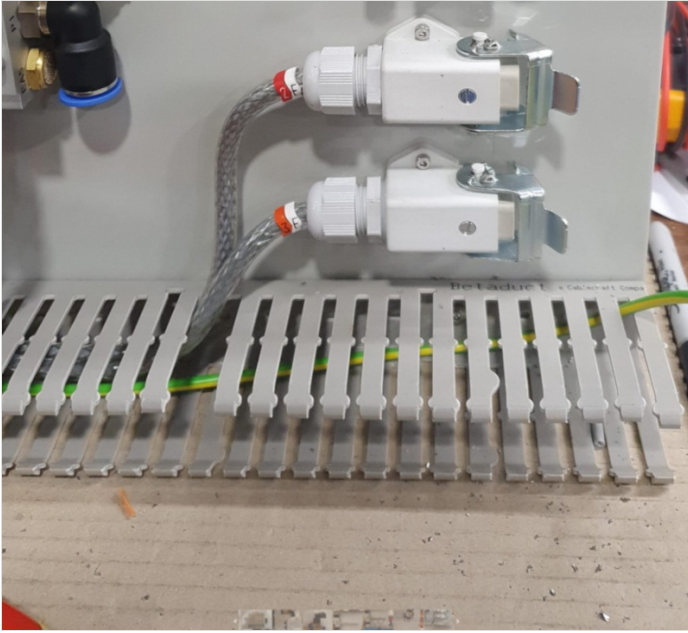




## Step 8 - Mount connection points

Drill and mount connection points as shown

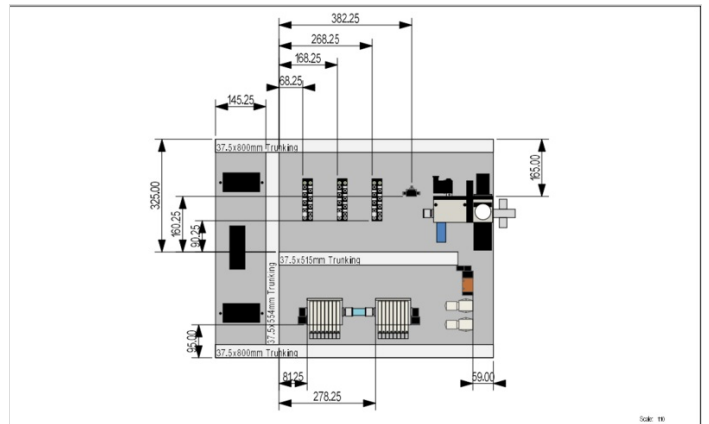
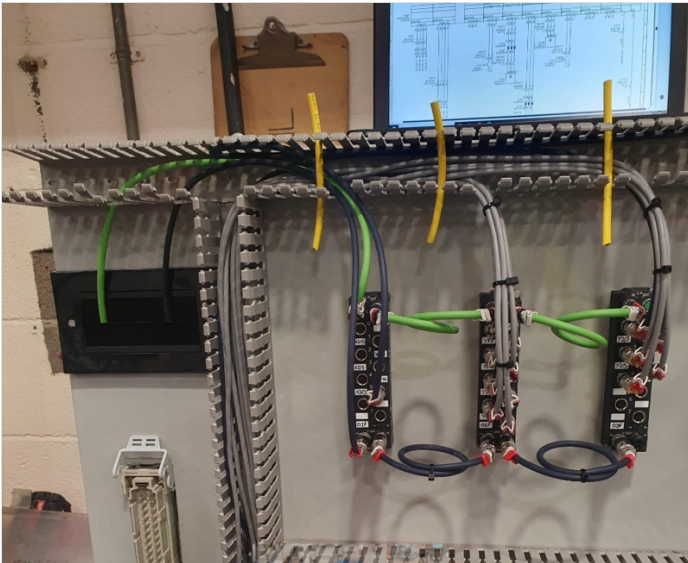
Fix with M3 x 10 socket caps



## Step 9 - Attach beckhoff Boxes

Drill cabinet and Attach ethercat boxes as shown

Use M3 x 25 pan head screws and M3 a form washers to mount





## Step 12 - Mount air service unit

Mount air service unit in position shown

Use M5 x 12 socket caps with heavy M5 washers to fix bracket to cabinet

Use M5? x ? to secure air service unit to bracket

