


# R0015343 Waste Guidance Installation

Installation details of waste guidance

 Difficulty **Medium**

 Duration **2 hour(s)**

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## Introduction

### Tools Required

Standard hex key set

Standard spanner set

Standard HSS drill set

Standard tap set

### Parts Required

D0001967 Conveyor End Plate x 1

D0001970 Swarf Funnel Support x 2

D0005616 Conveyor Swarf Funnel x 1

D0010843 Conveyor Deflector Plate x 1

M0000031 Panel Edging Strip; 9 x 6mm (consumable stock)

R0015344 Bench Assemble Conveyor Parts

## 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



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## Step 2 - Please note

Drive motor must be removed to allow access to fit side sheets

1 locking grub screw must be slackened to allow drive motor to be removed.

Ensure drive motor is refitted after installation of waste guidance sheets



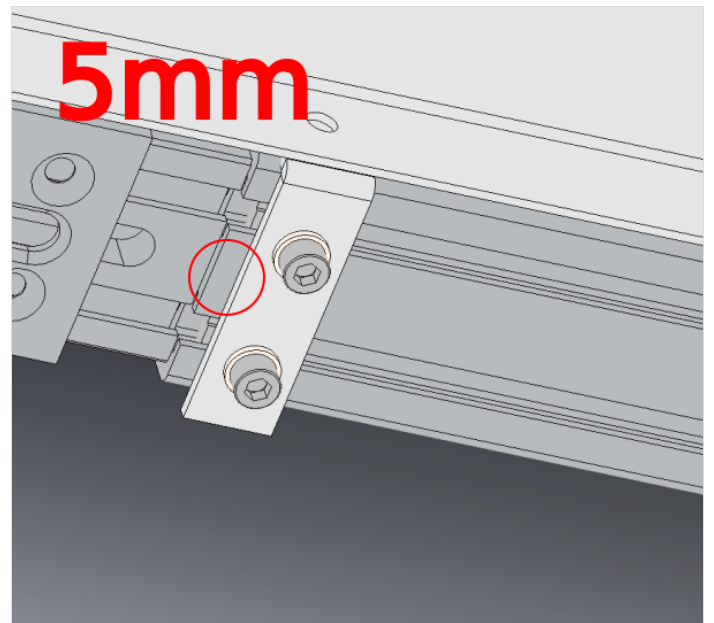
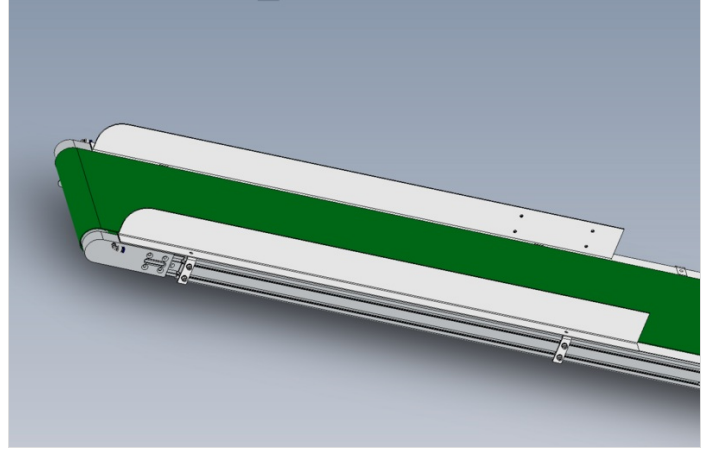
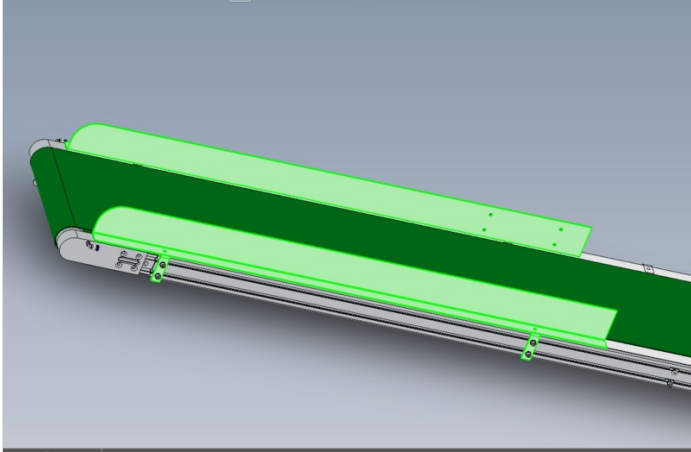
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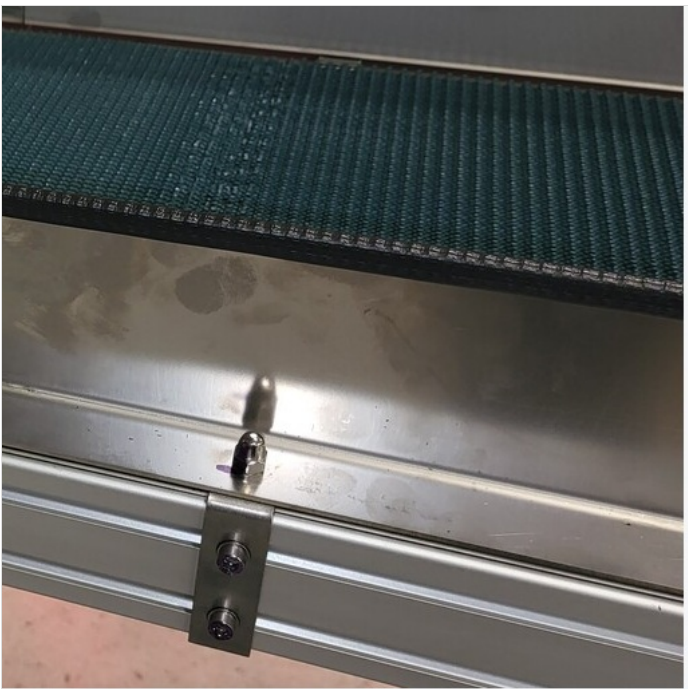
## Step 3 - Fit Radius side sheets

fit 2 off radius side sheets as shown

Secure using m5 slim D nuts , M5 x 10 socket caps and M5 A form washers

Position as shown 5mm from edge frame



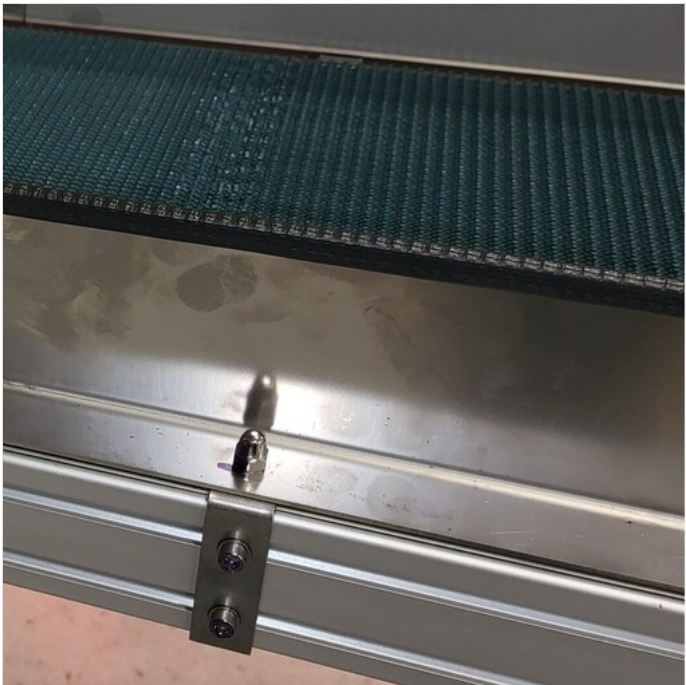
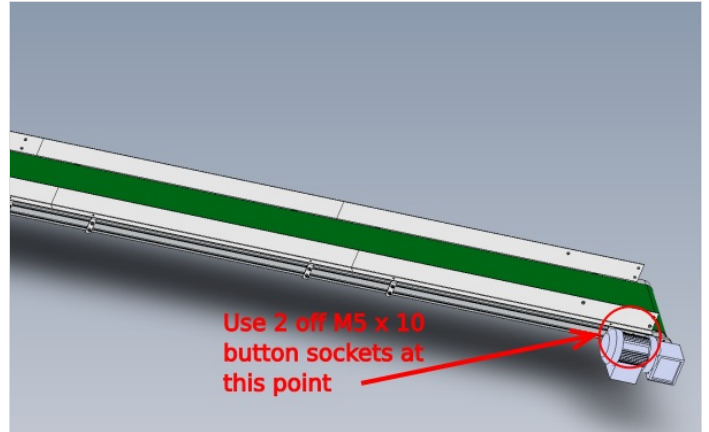
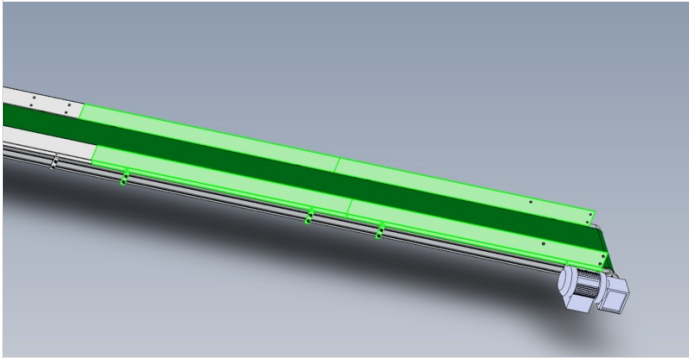


## Step 4 - Fit side sheets


Fit 4 off side sheet as shown

Secure using m5 slim D nuts , M5 x 10 socket caps and M5 A form washers

At position shown, Use 2 off M5 x 10 button heads for clearance when motor fitted



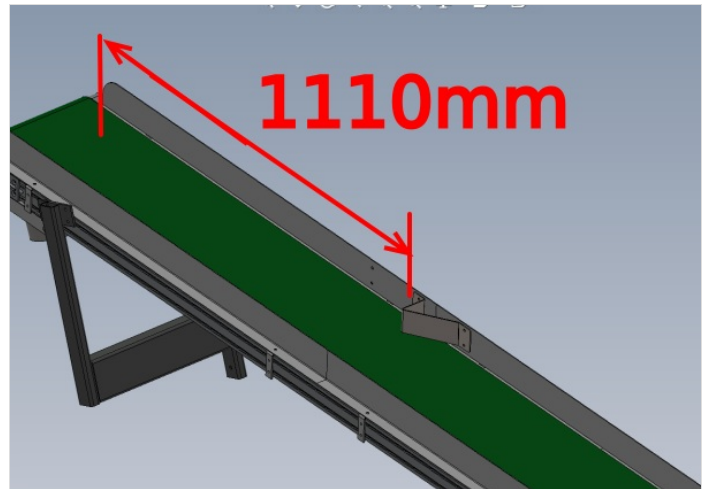
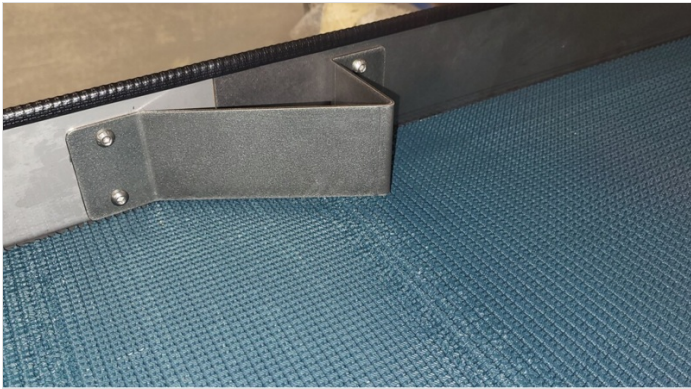
## Step 5 - Fit deflector

 ...Ensure holes if drilled by hand are sufficiently deburred and free of sharp edges on both sides

Drill and fit deflector as shown

Ensure deflector is mounted at a height that clearance is present between conveyor belt and deflector

Provide details to enable ecr to be raised to add mounting holes

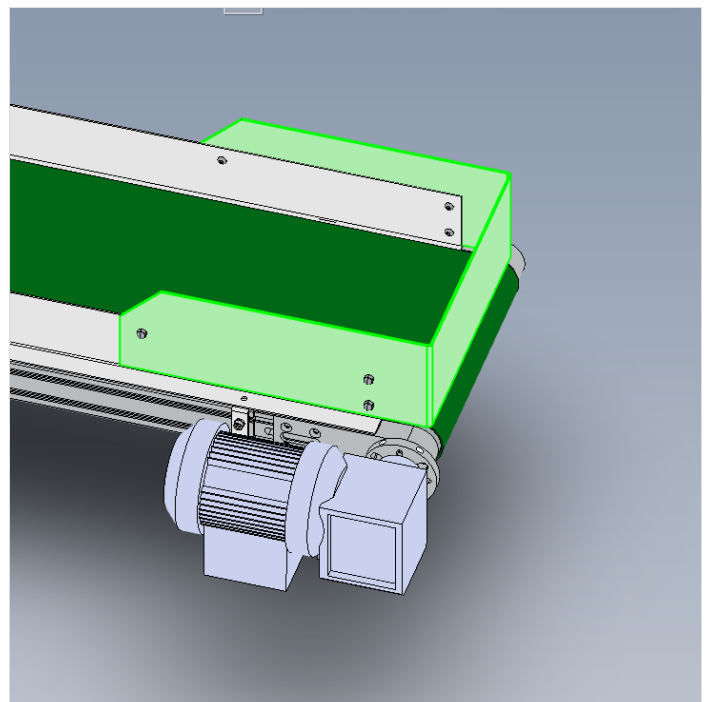


## Step 6 - Position end plate

Position conveyor end plate as shown

Ensure end plate does not touch belt. Needs to be 3mm higher than belt face

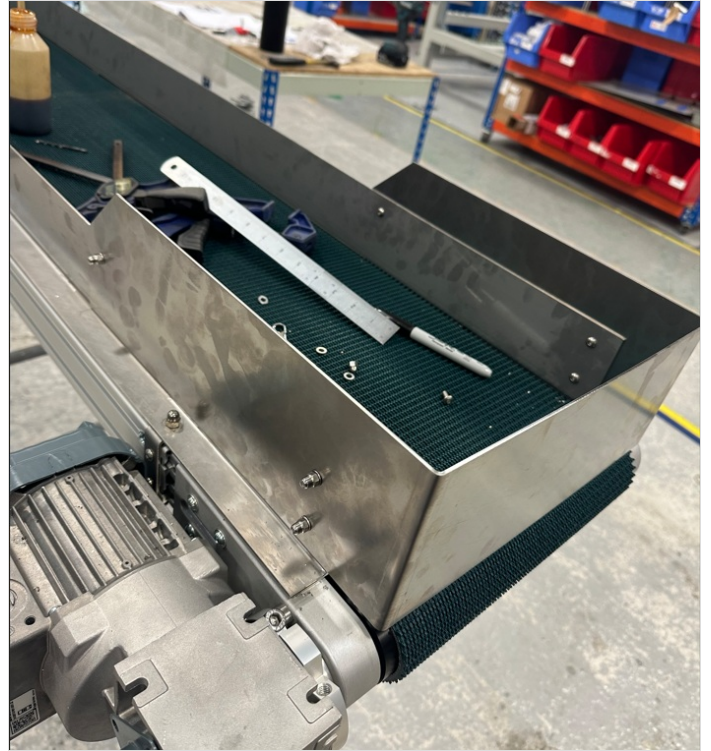
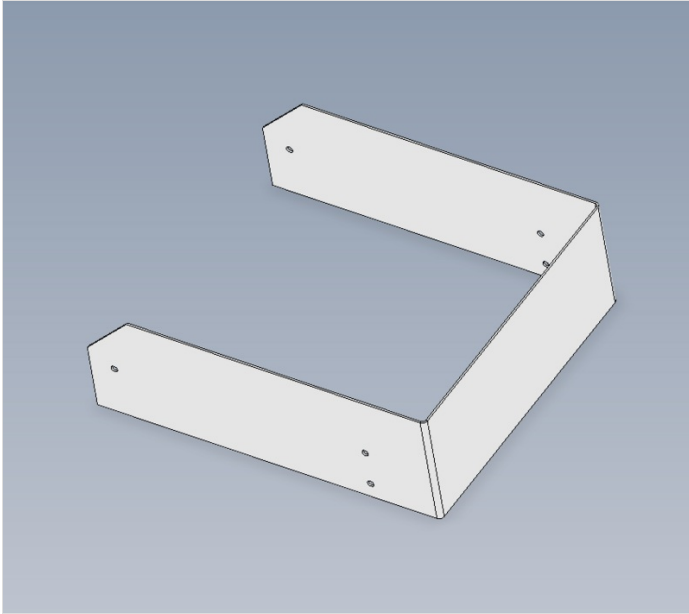
Mark positions for mounting holes and remove end plate



## Step 7 - Drill end plate

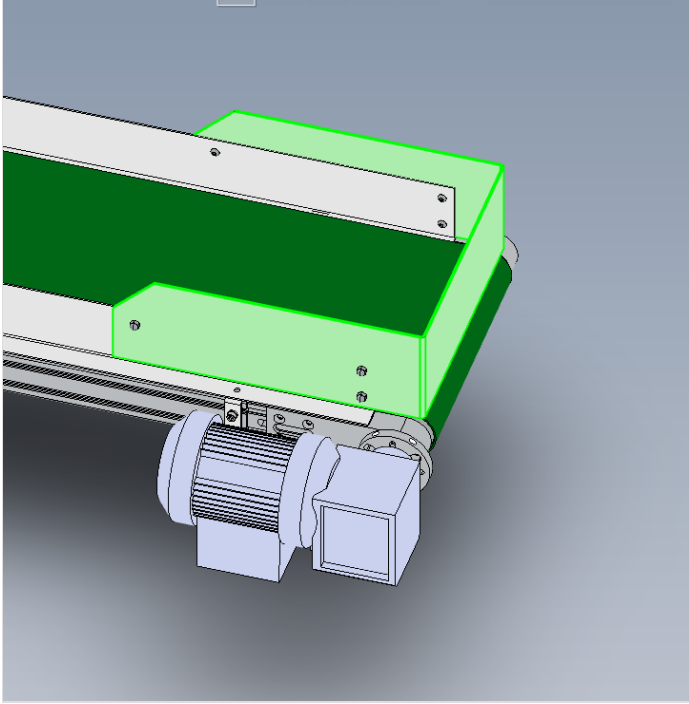
Drill M6 clearance holes at marked points

Photos and details of this please Drill off cable tie bases for motor cable



## Step 8 - Fit end plate

Ensure button head M6 fasteners are used backed with M6 dome nuts

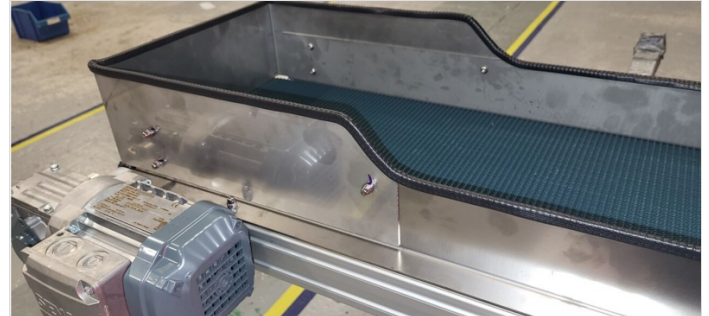
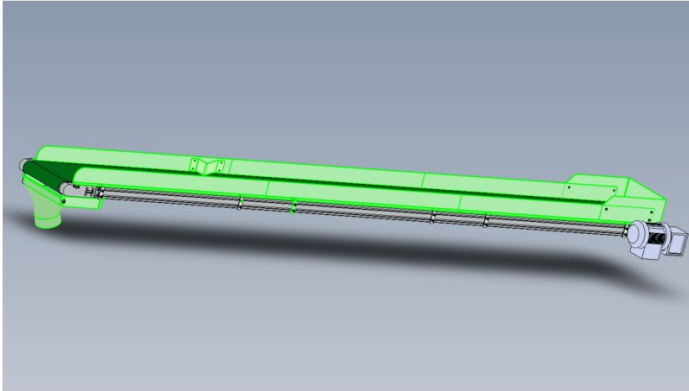


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## Step 9 - Fit edging strip

Fit edging strip to top faces

please detail

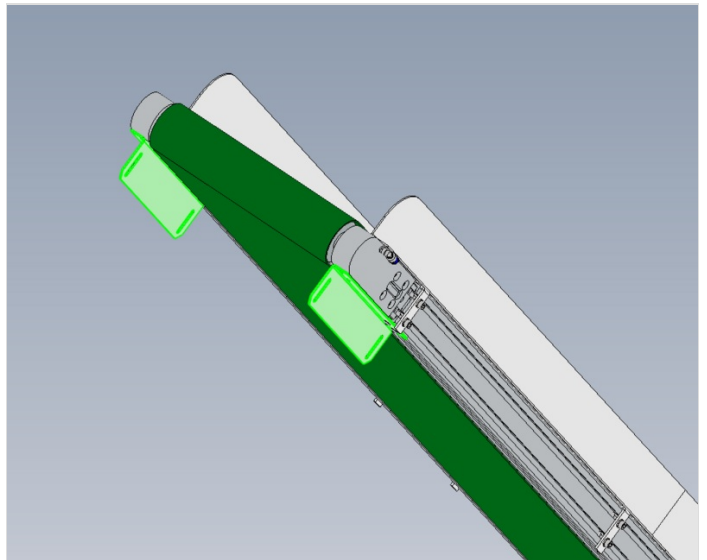
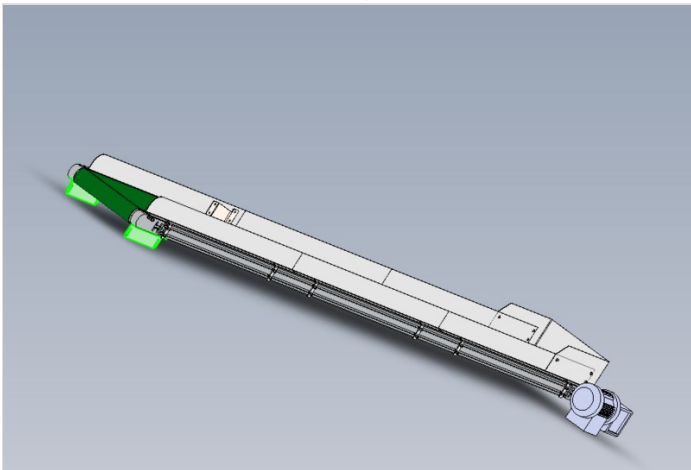




## Step 10 - Fit lower swarf funnel brackets

### Pictures Required

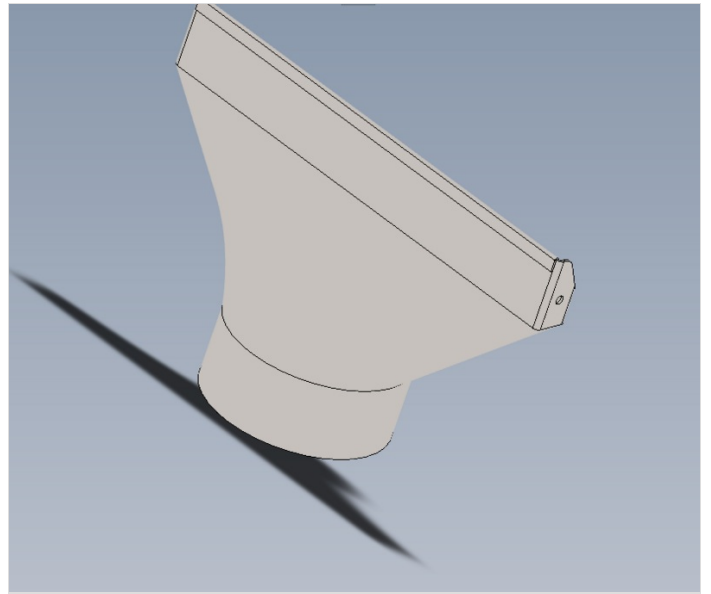
Secure with 4 off M5 x 10 socket caps and M5 A form washers



## Step 11 - Add riv nuts

Add 2 off m6 rivnuts to swarf funnel pre drilled holes

Ecr raised to add rivnut to drawing 18/12/23



## Step 12 - Important

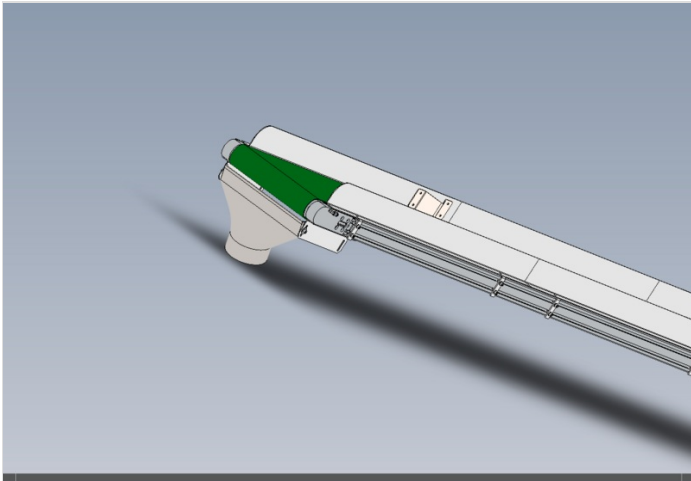
When positioning swarf funnel, it is vital that it does not contact the conveyor belt . Please ensure it is set so there is no contact between the two



## Step 13 - Fit swarf funnel

Fit swarf funnel to conveyor brackets

Secure with M6 cap heads and washers



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## Step 14 - Drill and pin

Details and pictures Required

Drill and pin funnel in position with 2 off 3 mm spiral pins

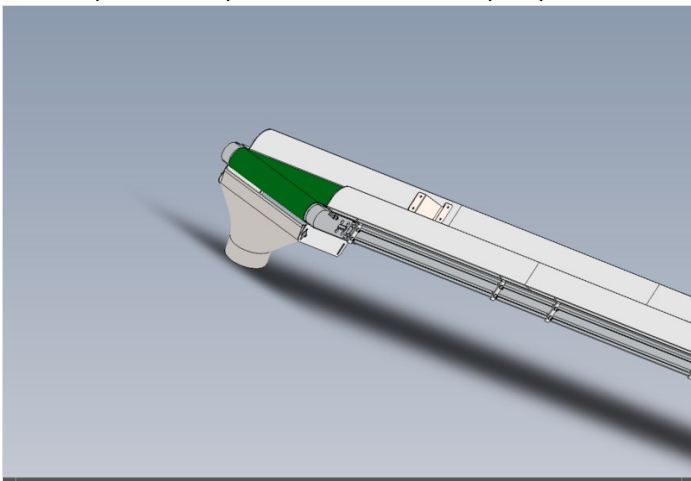


Photo  
Required

## Step 15 - Check all fasteners

Check all fasteners are finalised and marked

Ensure all settings have been finalised

