



# R0015352 Mount Buffer Beams

Details for mounting front and rear buffer/support bars

 Difficulty **Medium**

 Duration **4 hour(s)**

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Comments

## Introduction

### Tools Required

Standard hex key set

Standard spanner set

1 meter spirit level

Tape measure

### Parts Required

D0015326 transfer gate upright x 4

D0015334 ZX fence corner post x 2

D0015607 Fence 11 support beam x 4

D0015335 ZX fence cross post x 4

D0010202 Frame joining plate x 2

D0015232 Fence mounting bracket x 2

M0001016 angle bracket x 2

M0000516 adjustable foot x 2

## 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 - Prepare 4 off D0015326 transfer gate upright

Add 2 off 7mm diameter through holes per upright.

Add each hole 100mm from either end, central in chamber, both on the same face



## Step 3 - Assemble corner posts

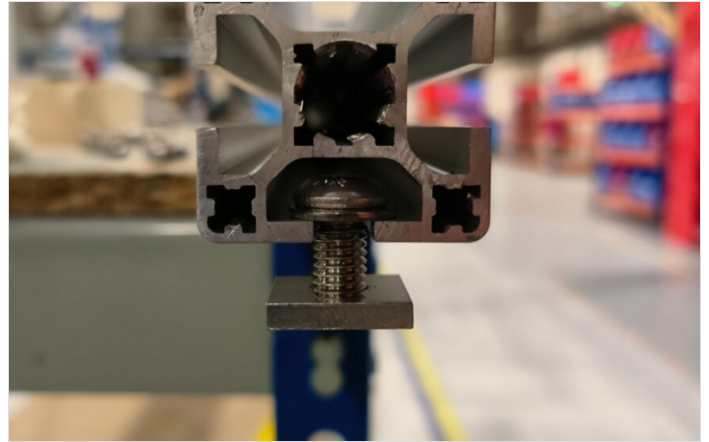
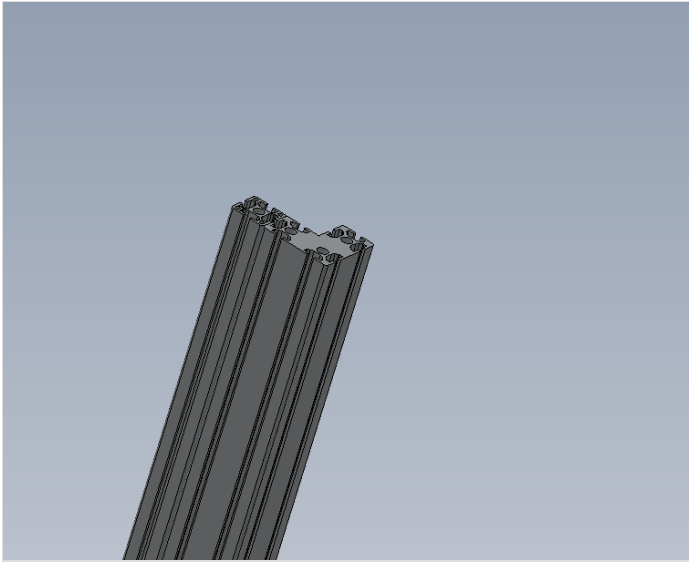
assemble 2 off corner post assemblies

Insert 2 off M8 x 16 button socket into each pre drilled upright

Assemble onto corner post face, centralise parts and tighten button sockets to join parts together

Repeat for all 4 off uprights onto 2 off corner posts

Please provide more detailed pictures please

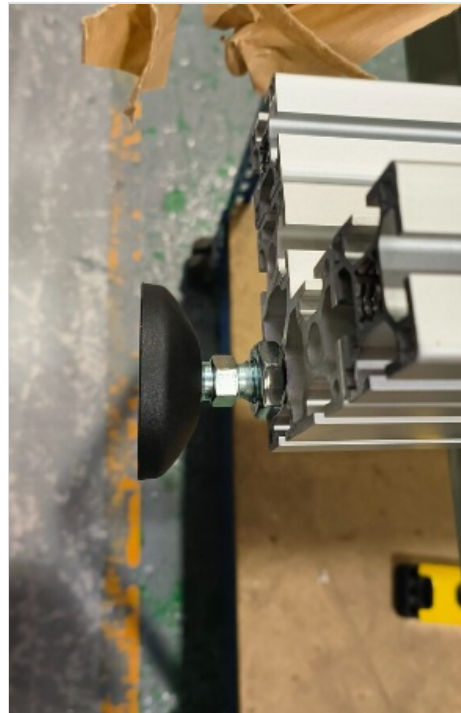


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## Step 4 - Fit adjustable feet

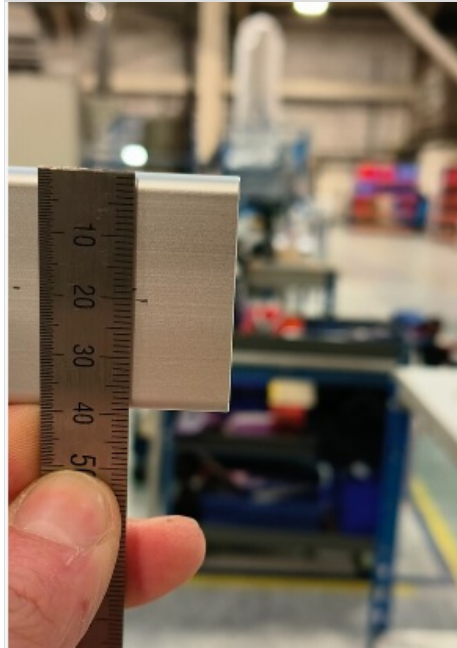
Fit 2 off adjustable feet , 1 per corner post

Please provide more detailed pictures please



## Step 5 - Drill Fence supports

Drill 1 off 7mm clearance hole in each fence support , at opposite end to pre drilled holes.



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## Step 6 - Add tie bases

Add 16 off tie bases (8 off per side) to fence support as shown . Fix using M5 x 10 button hex sockets

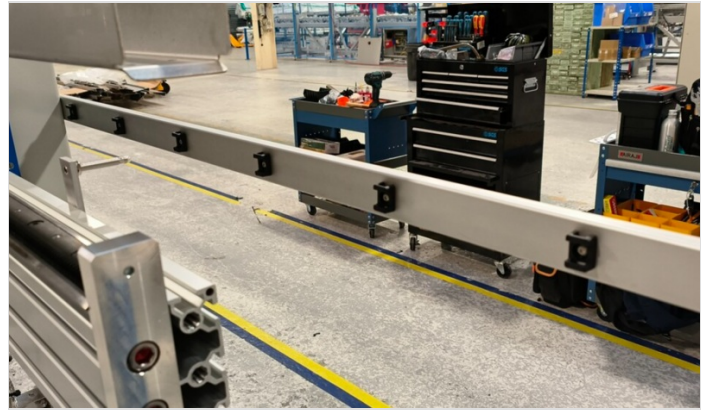
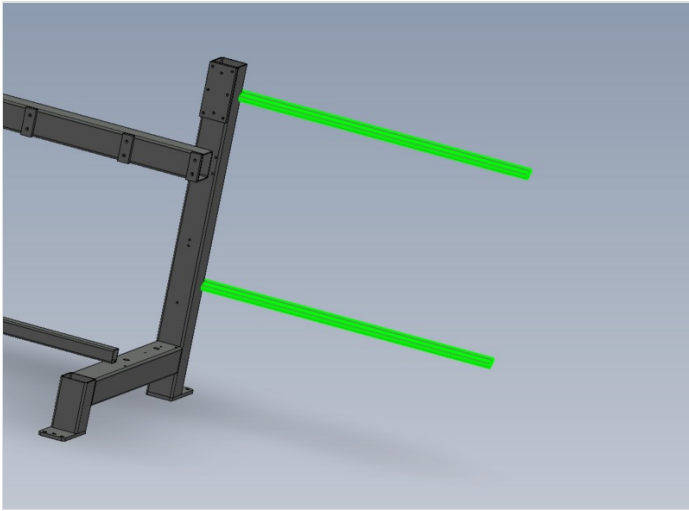
Only add tie bases to 2 off fence supports



## Step 7 - Attach fence supports

Attach 4 off fence supports to module C and E frames

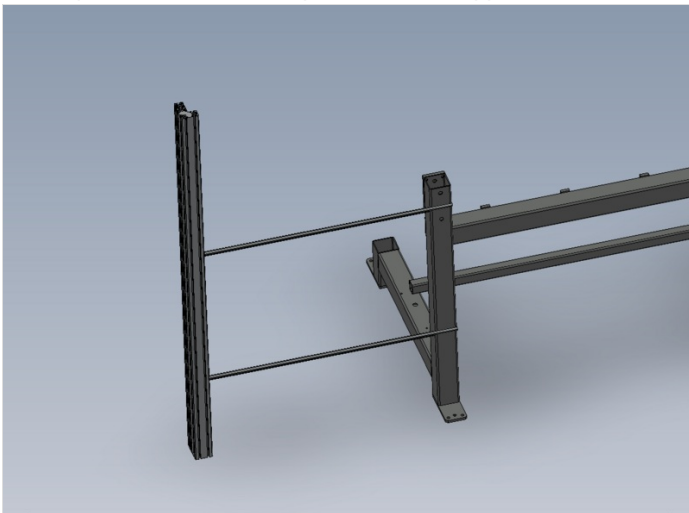
Ensure Fence support with tie bases added is fitted to top positions



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## Step 8 - Attach Corner posts

Attach pre assembled corner posts to fence supports fix with 2 off M6 D nuts ,M6 x 25 socket caps and M6 penny washers per corner post





## Step 9 - Level and adjust

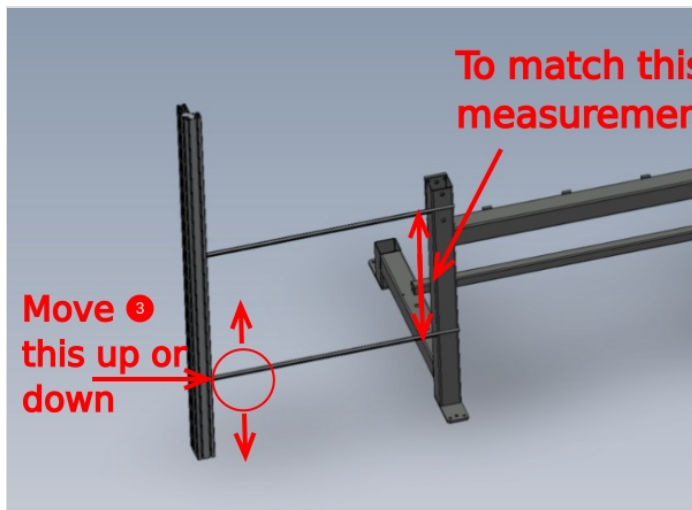
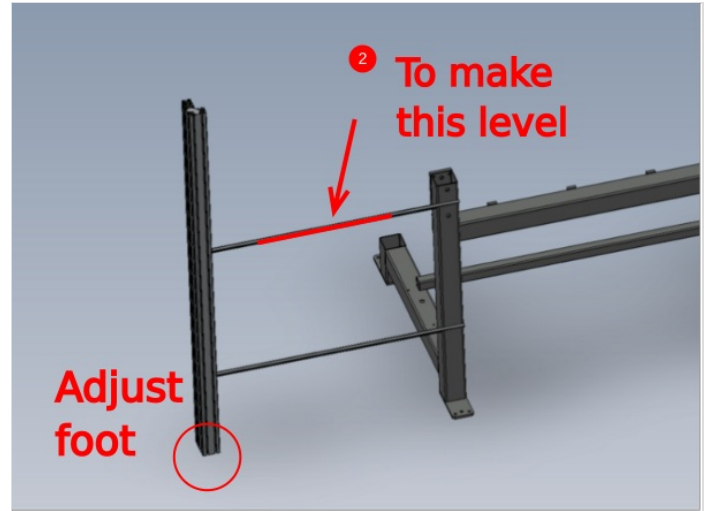
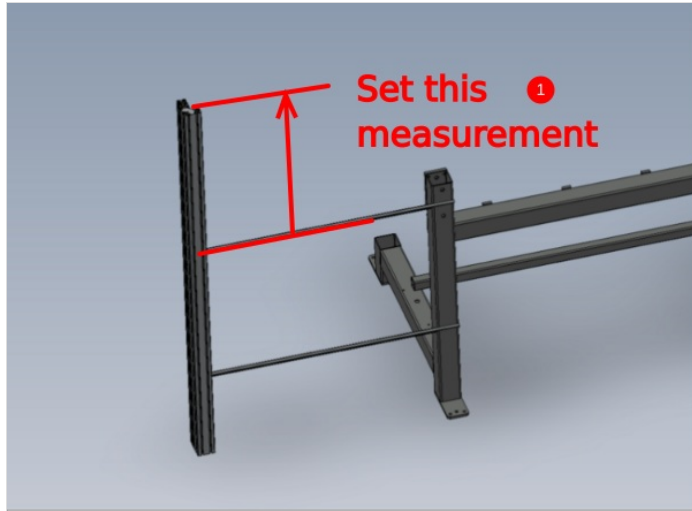
1 Set Measurement shown (what is it)

2 Adjust foot to bring fence support level

3 Set lower pitch of fence support

4 Finalise all fasteners

5 Repeat steps for opposite side



## Step 10 - Caution

Please ensure buffer beams are assembled correctly

Beams must be butted together, and no gaps visible

Please see picture for incorrect assembly



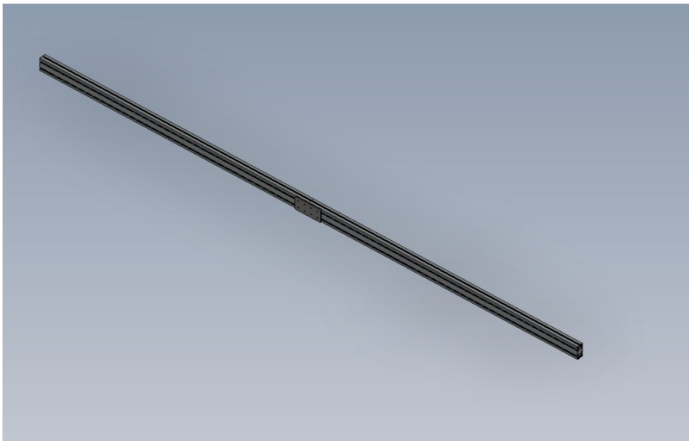
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## Step 11 - Assemble buffer bars

Assemble 2 off buffer bars

Each bar contains 2 off D0015335 with 1 off joining plate D0010202

Use 8 off M6 D nuts, 8 off M6 16 socket caps and 8 off M6 penny washers to join each bar





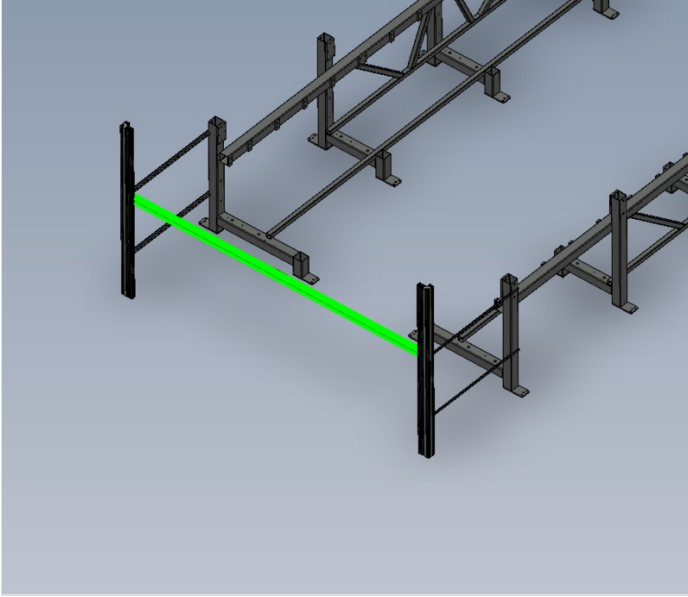


## Step 12 - Attach buffer bar rear

1 Fit 2 of support angle to corner post as shown using 2 off M8 D nuts, 2 off M8 x 16 socket caps and 2 off heavy M8 washers per bracket

2 Add 2 off M8 D nut to assembled buffer bar and position onto brackets . joining plate should face into machine

3 Use 2 off M8 x 16 socket caps and 2 off Heavy M8 washer to fix Buffer bar to brackets



## Step 13 - Set height

Adjust brackets to set height of buffer bar. Top of buffer bar should be level with top of fence support as shown

Finalise all fixings

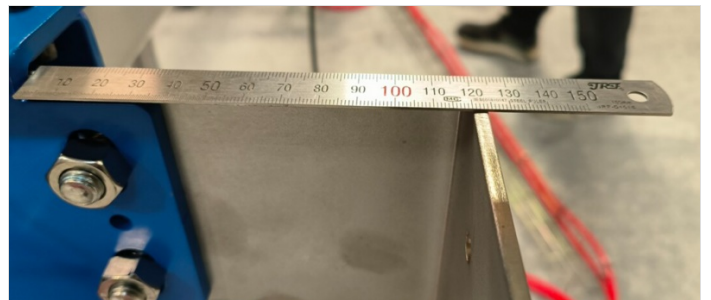
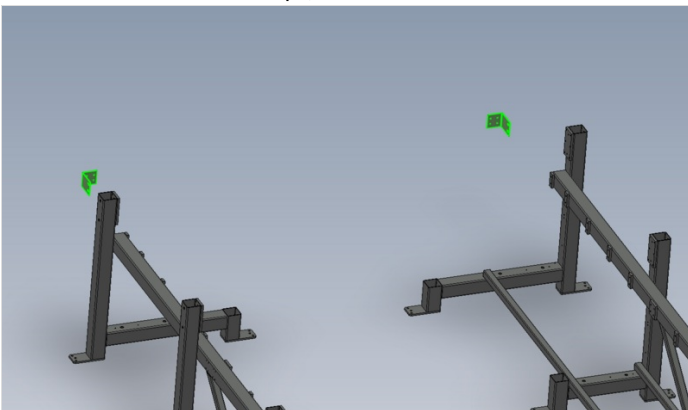


## Step 14 - attach front buffer support brackets

Attach 2 off brackets to blue section on module C and E frames, set distance as shown to 120mm

Ensure brackets are mounted level

Fix with M12 x 25 socket caps, M12 A form washers and M12 nuts



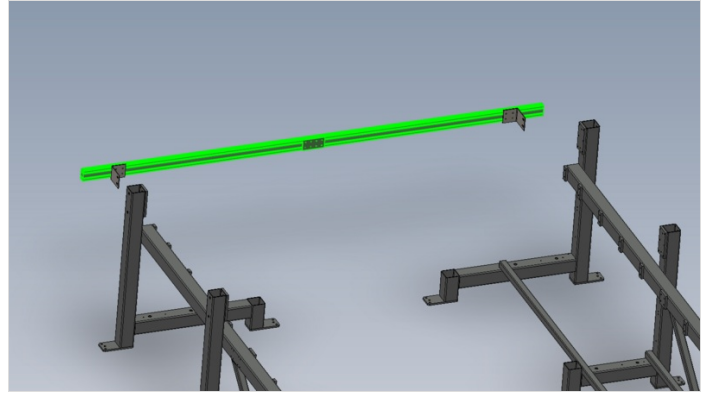
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## Step 15 - attach front buffer bar

Attach front buffer bar to brackets using 8 off M6 D nuts, 8 off M6 x 16 socket caps and 8 off M6 A form washers  
Ensuring joining plate on buffer bar is facing rear buffer bar

Adjust position of buffer bar to be 920mm from edge of buffer bar to saw infeed side mounting bracket

Please provide more detailed pictures please



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## Step 16 - Check Height and parallel

Check that front buffer bar is sitting parallel to transfer beams

Check that front buffer bar is sitting level from infeed side to outfeed side

Please provide more detailed pictures please

