



ZX5 Installation Procedure

Correct procedure for ZX5 Installation

 Difficulty **Very Hard**

 Duration **5 day(s)**

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Step 1 - Ensure the area is clear

Step 2 - Mark floor area out roughly with marker pen

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Step 6 - Fine positioning of Machining Centre Outfeed

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Step 11 - Fit Transfer Gate (between MH and Saw)

Step 12 - Position M/C Infeed and level up

Step 13 - Position Sawing Module and level up


Step 14 - Position Saw Outfeed and level up

Step 15 - Fit Conveyor

Step 16 - Fit Extraction Piping and Extraction Gates

Comments

Introduction

 ...Read the risk assessment and method statements before proceeding.



Use protective footwear



Use protective clothing



Use protective headgear



Use reflective vest



For maintenance disconnect from...

Step 1 - Ensure the area is clear

Step 2 - Mark floor area out roughly with marker pen

Step 3 - Position M/C and level up

Step 4 - Position transfer tables in relation to floor plan

Step 5 - Level machining centre outfeed frame

- Add air temporarily to the lift rollers to create datum in their up position.
 - Use laser to level and set height so that the M/C Outfeed rollers are parallel to M/C Rollers, but 0.5-1.0mm lower than the M/C Rollers.
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Step 6 - Fine positioning of Machining Centre Outfeed

- Use the aluminium setting jig with the gripper holes.
- Clamp the jig with the clamps (manually, as air is not switched on yet)
- Move the frame and use the gripper as the guide to drop into the holes.
- Use laser to align the frame in parallel with the backfence, taking care not to lose the gripper position relative to the gripper holes.



...DO NOT USE THE GRIPPER ADJUSTMENT TO MOVE THE GRIPPER IN RELATION TO THE HOLES.

- With the outfeed beam in its fully extended position, and the gripper at the end of travel, there gripper should not be able to clash with the infeed top clamp. This should leave the end of the beam 40-60mm from the MH Cross Bar
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Step 7 - Position Extraction Unit

Step 8 - Square up and level Saw infeed

- Measure up diagonals to get the two transfer frames fully parallel.
 - Measure the gap between the frames, ensuring the male posts on the stub arms (on frames) are same distance as the hole centres on the transfer beams.
 - Level the frame.
 - Position Transfer Arms 1 and 9 to fine tune the frame positions.
 - Place a level on these two transfer arms.
 - Level the frame again using the two transfer arms to indicate if the Saw Infeed frame needs to be raised or lowered.
 - Recheck level and squareness of Saw Infeed.
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Step 9 - Position remaining transfer arms

Step 10 - Adjust height of Saw Infeed to be level with M/C Outfeed

Step 11 - Fit Transfer Gate (between MH and Saw)

Step 12 - Position M/C Infeed and level up

Step 13 - Position Sawing Module and level up

Step 14 - Position Saw Outfeed and level up

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Step 16 - Fit Extraction Piping and Extraction Gates

No hard pipe under the Saw.
