

ZX5 Production R0000548E Module G to R0015040 Module F alignment

Details for alignment of module G to F inclusive of additional safety tray fitting

 Difficulty **Medium**

 Duration **3 hour(s)**

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Comments

Introduction

Details for correct alignment of module G to module H

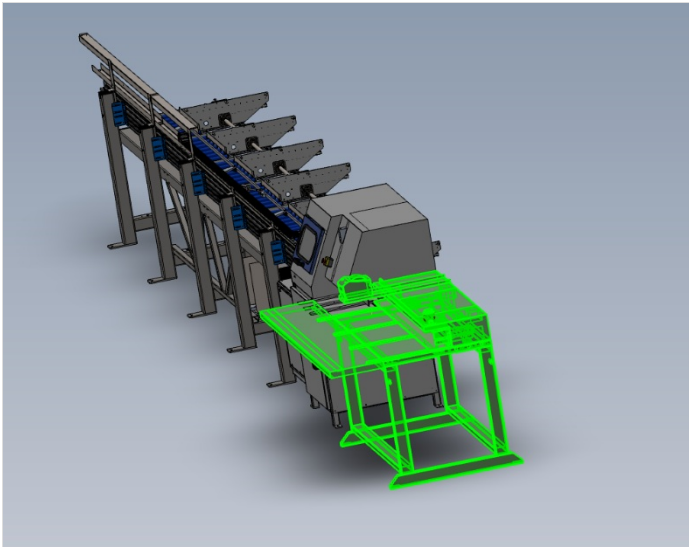
To include fitting of front safety tray once module G is installed

Step 1 - Position saw outfeed table

Approximately position saw out feed table against saw module Leave a 10mm gap between frames until levelling has been completed

Use black floor pads 4 off under adjustment bolts, ensuring copper slip is used on bolts

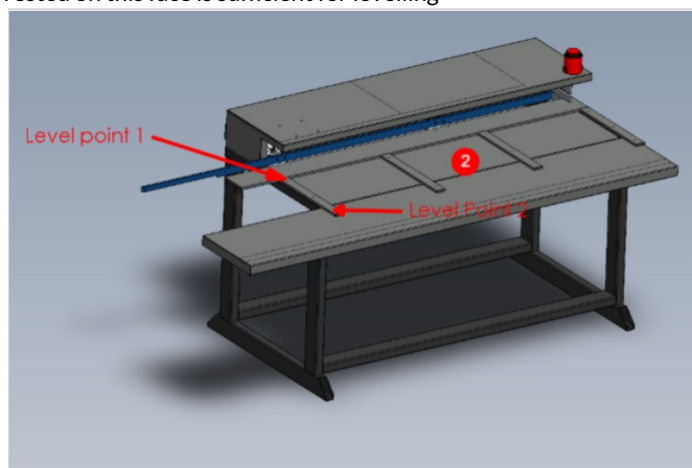
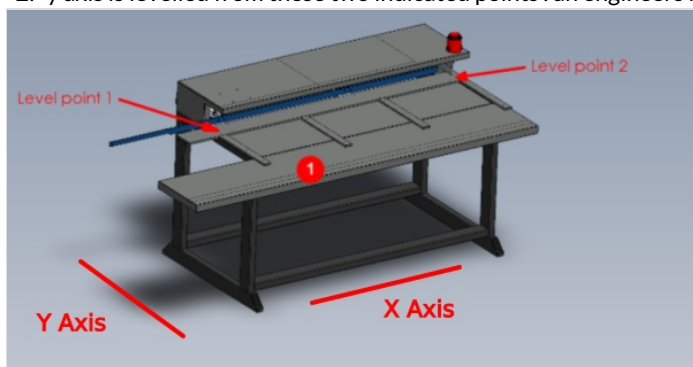
(please note image shows safety tray fitted, this is an error and will not be fitted until later steps)





Step 2 - Saw Outfeed table levelling

1. X axis of module is levelled from the two indicated points . Use a 2 meter straight edge between these points and an engineers level on top
2. y axis is levelled from these two indicated points . an engineers level rested on this face is sufficient for levelling



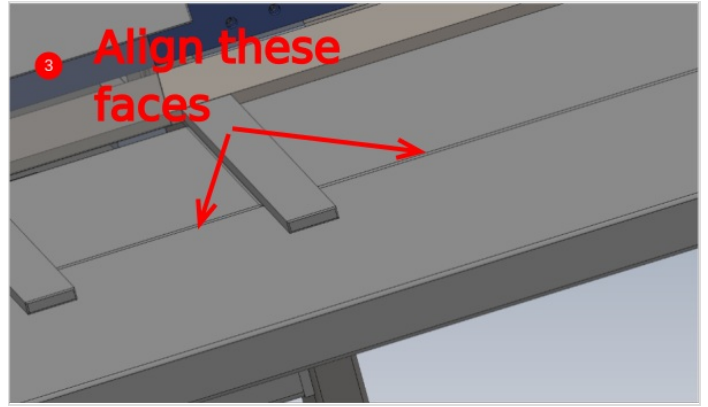
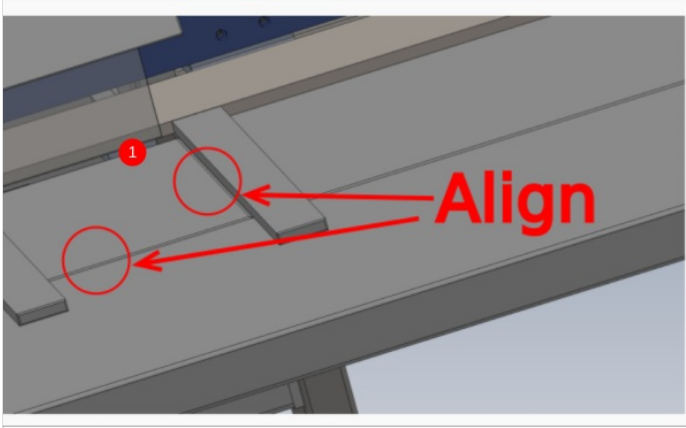
Step 3 - Saw outfeed height adjustment and Y axis position

1 Adjust height of saw outfeed table to align faces shown

2 Check that eject table cylinder can freely move beneath frame on full range of travel

3 Align front faces of saw and outfeed frame to be inline

Check that Blue push bar is behind Saw rear fence rollers by at least 5mm(Adjustment is possible if not via slots on push bar assemblies)



Step 4 - Fix frames together with M10 set bolts and washers

1 Fix frames together with M10 x 100 set bolts, 3 off Large M10 washers stacked on each bolt and a M10 nut on each bolt. Use copper slip as shown

2 Connect 8mm Blue airpipe from saw module F to valve bank on outfeed (photo required)



Step 5 - Quality check

Vital check required on fixing points for saw conveyor mounting

2 off M8 rivnuts must be installed correctly

1 Face of frame must be countersunk to allow flush fitment and full contact of rivnut shoulder.

2 Rivnuts must be tensioned correctly when installed. If in doubt, please request information from supervisor for the correct fitting of rivnuts.

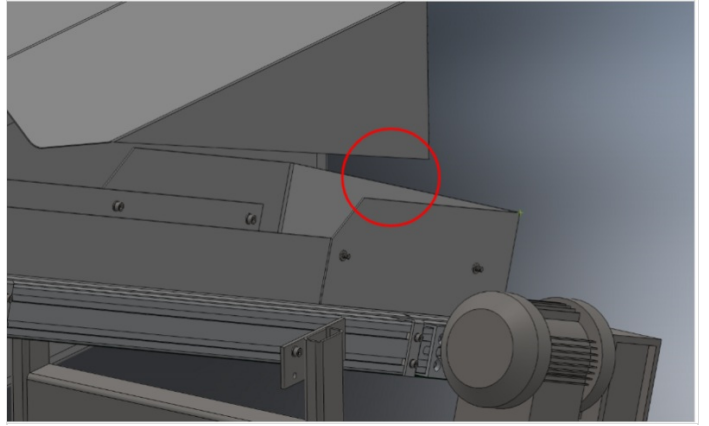
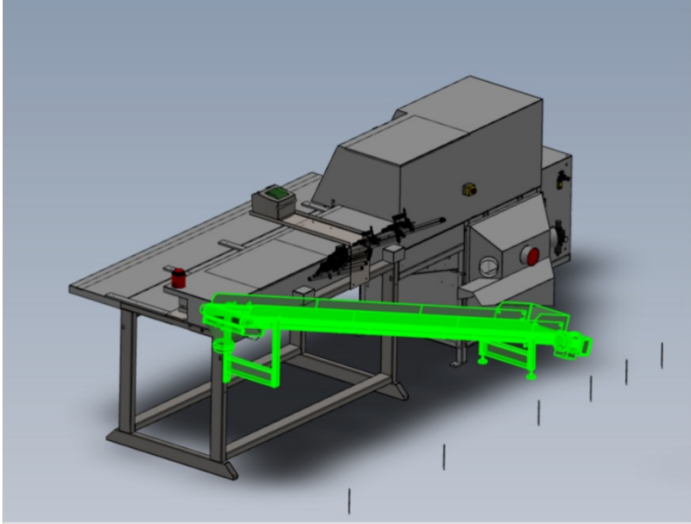
3 Rivnuts should have a solid fixed into frame and not be able to rotate. To check this, bolt a component to the rivnut and tighten. Then undo fastener and remove component. Rivnut should not move during this process and remain solid



Step 6 - Fit Swarf conveyor

Fit waste conveyor to out feed frame using 2 off M8 socket caps

Adjust waste conveyor feet to minimise gap shown between saw module rear panel and waste guide on conveyor





Step 7 - Swarf conveyor blower connection

Connect swarf conveyor blower feed to saw module bulk head

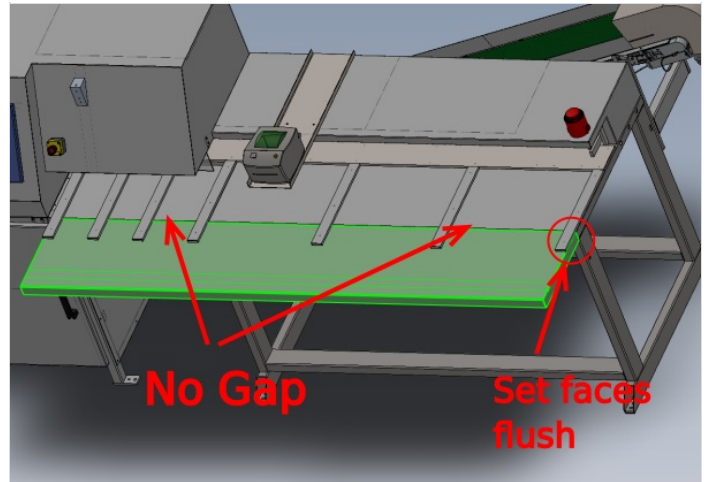
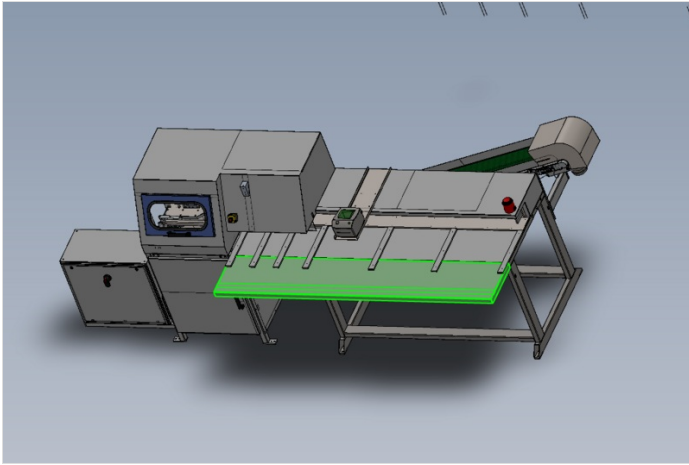


Step 8 - Prepare front tray

Use red pump trolley to lift tray into position

Set end indicated flush

Ensure tray is pushed up against both saw and outfeed frame

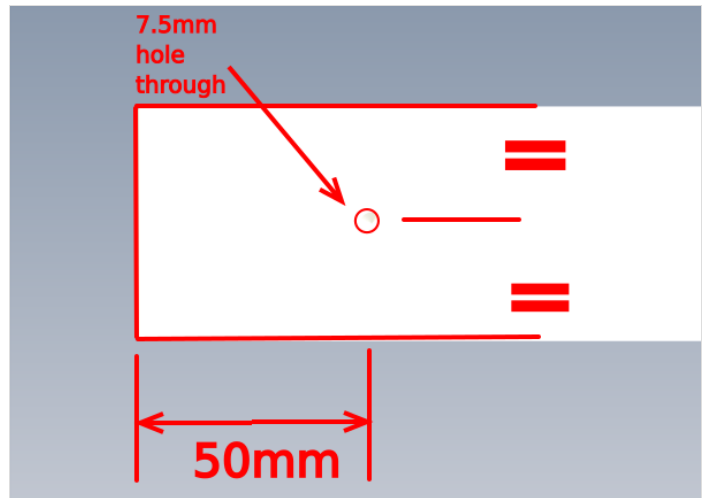
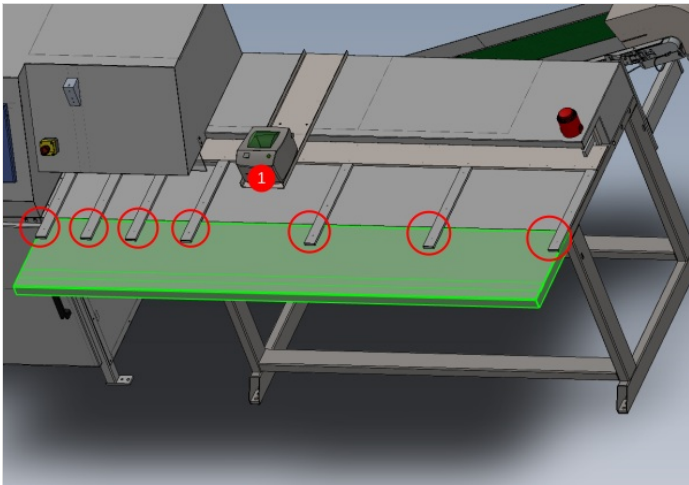


Step 9 - Mark Tray and drill

1 Pencil mark around 7 off arms

2 Remove tray and mark hole position as shown on each mark point on tray

3 Pilot and open to 7.5mm at each marked position



Step 10 - Attach tray

1 Reposition tray with red trolley

2 Fit tray with 7 off M6 socket caps and heavy M6 washers

