

R0015011 Bench assemble Gripper

Bench assembly of Material Gripper

 Difficulty **Medium**

 Duration **2 hour(s)**

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Comments

Introduction

Introduction

Tools Required

External circlip pliers

Standard Hex key set

Standard spanner set

Reed switch setting box

Hammer

Standard screwdriver set

Rule

Parts Required

B0001106 x 20

D0015095 x 8
D0015096 x 2
D0015086 x 1
B0000034 x 2
D0015084 x 2
D0015083 x 1
D0015082 x 1
E0000366L x 1
B0001182 x 2
M0001182 x 2
D0015756 x 1
P0001013 x 1
P0001041 x 1
P0001128 x 1
P0001198 x 2
P0001120 x 1
D0015431 x 1
B0000437 x 1
D0015430 x 1
D0015090 x 2
D0015085 x 1
D0015102 x 2
D0015103 x 2
D0015104 x 2
D0015170 x 2
P0000049 x 1
D0015097 x 2
D0015101 x 2
D0015292 x 1
E0001069 x 1
A0001044 x 4

Step 1 - Unless otherwise stated

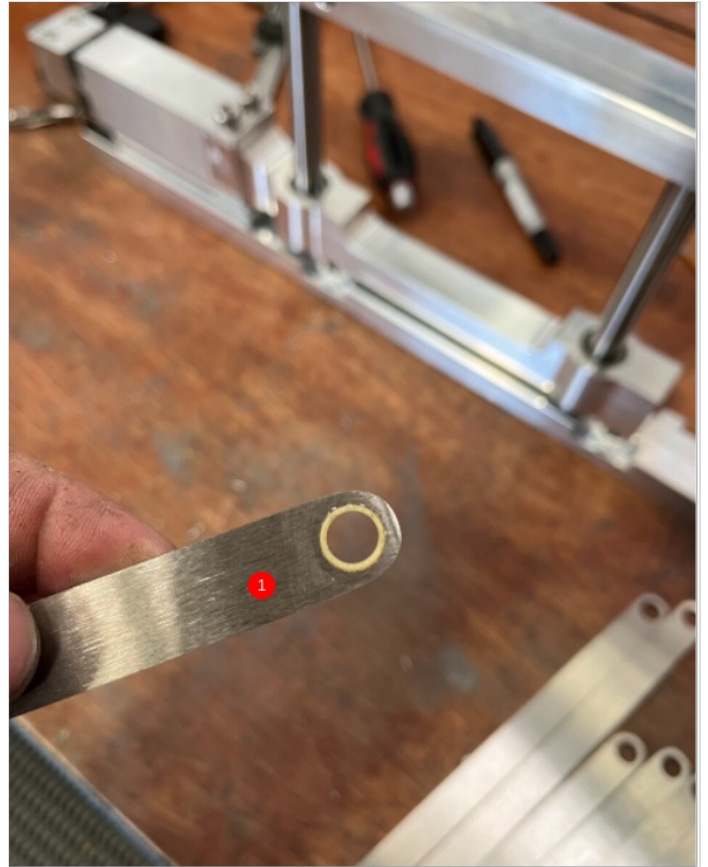
Use Loctite 243 on all fasteners
Pen mark all bolts once finalised



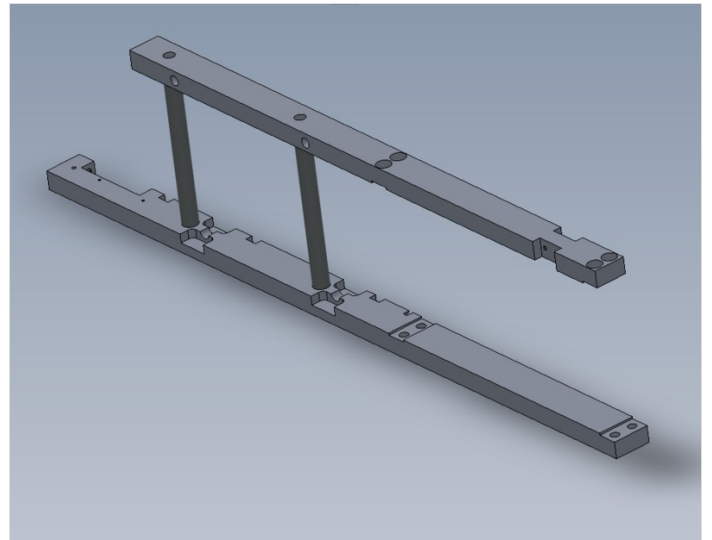
Step 2 - Fit bushes and bearings

1 Fit bushes B0001106 (20 off) to
8 off D0015095 link bars
2 off D0015096 link bars

2 Fit bearings B0000034 x 2 into D00015086 grip slide body. Use grease to lubricate bearing before assembly

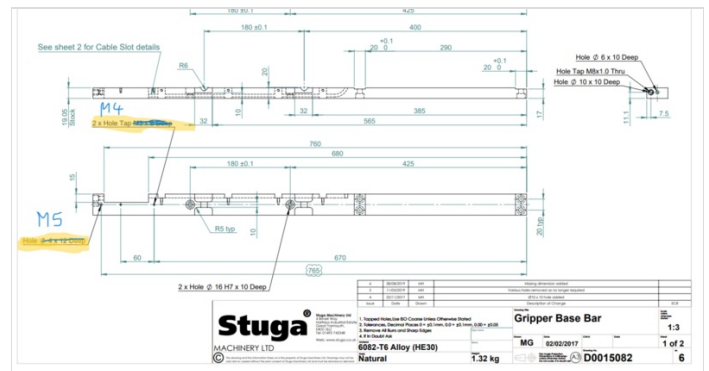


check shafts fit correctly into bores of D0015082 gripper bottom bar and D0015083 gripper upper bar



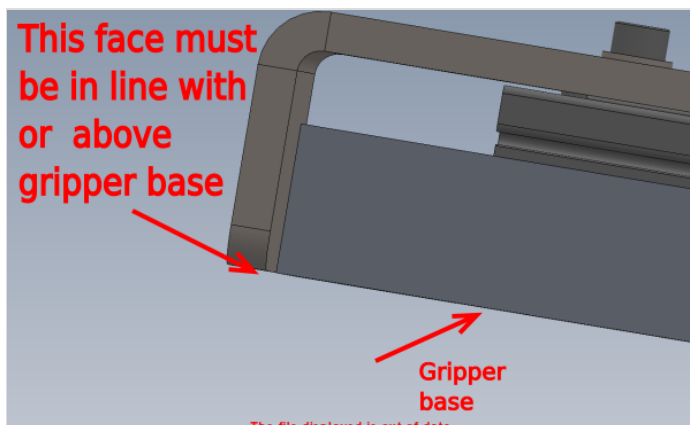
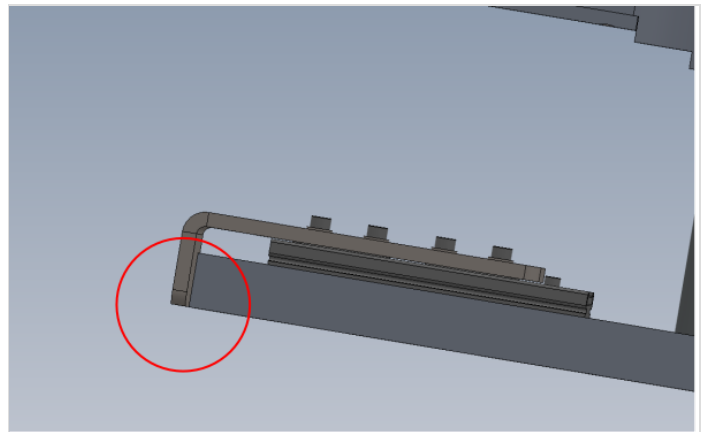
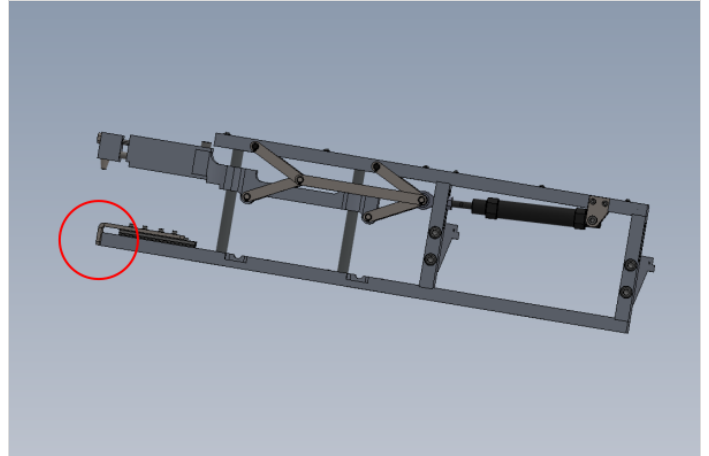
Step 4 - check for rework

Check that part D0015082 has been manufactured to the listed details highlighted in drawing attached to this step. If M4 and M5 holes are not present, rework and record time



Step 5 - Check strike plate position

When assembling next step, check position of strike plate at indicated point.
No overhang below bottom face of gripper base should be present.



Step 6 - Quality check !!

Several instances of the following step have been encountered.
Please ensure all fixings are sufficiently tight and adequate Loctite 243 is used on ALL fasteners



Step 7 - Caution

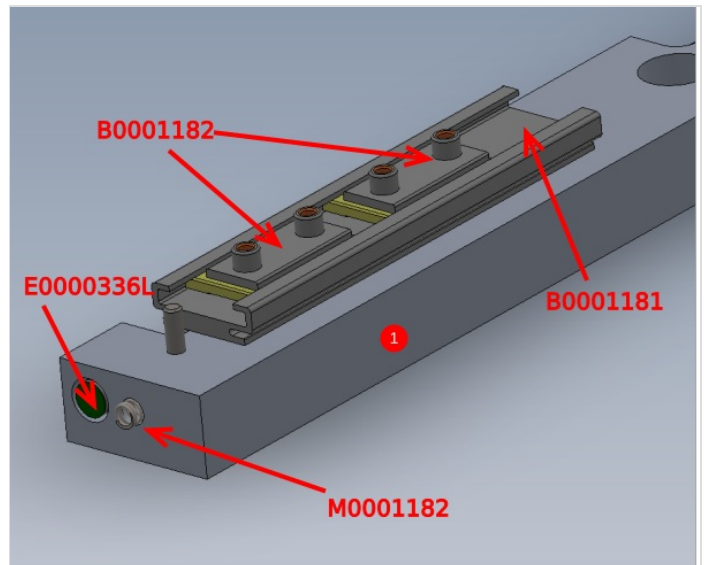
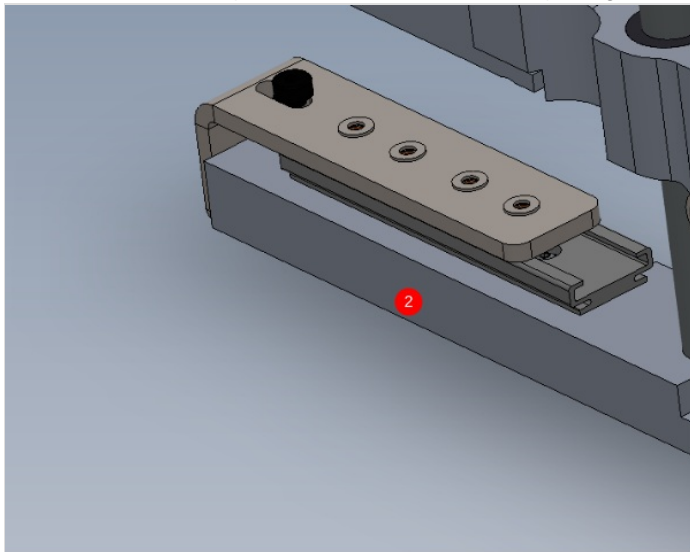
The load switch must be assembled that enables free running and not tight spots to be encountered when operated. Please ensure assembly guidance is followed and adhered to. If any issues arise please advise supervisor for correct action

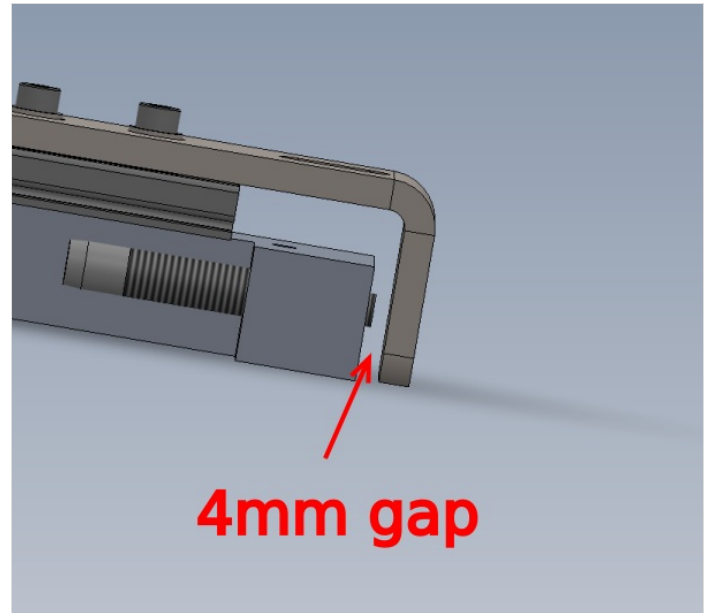
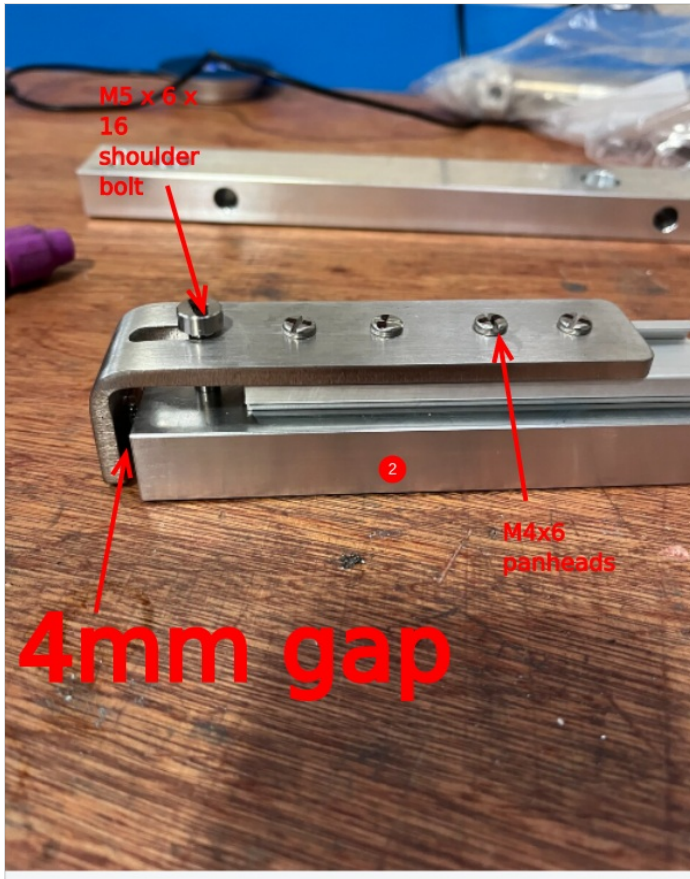


Step 8 - Assemble load switch plate

1 Use M4 x 6 panhead to attach B0001181 rail to gripper base
Fit M0001182 spring to main base

2 Use M5x 6 x 16 shoulder bolt and M4 x 6 pan heads to attach D0015756 lever to assembly
3 Check lever assembly is free and moves consistently along entire length of travel





Step 9 - Fit Sensor

1 Add cable markers to E0001069 cable , Mark as X294 both ends

2 Attach above cable to E0000336L and fit as shown with 1 off supplied lock nut and shakeproof washer on the indicated face

3 Set Sensor position as follows

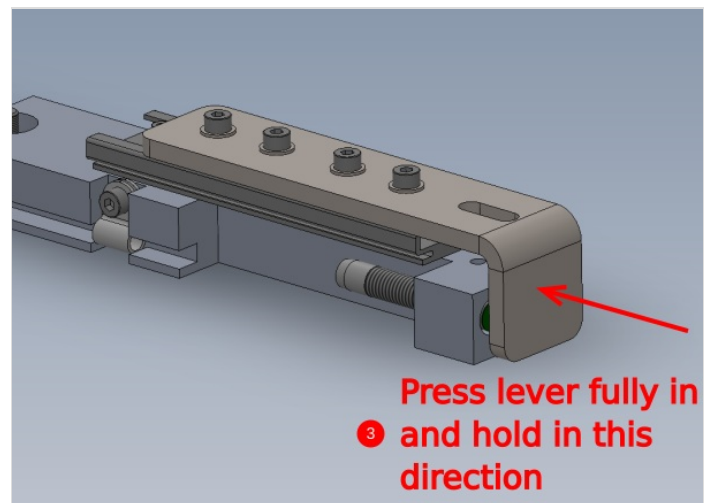
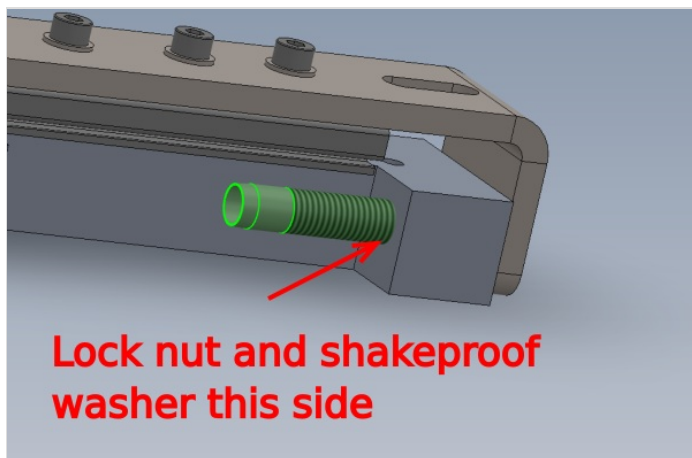
Press lever fully in direction shown

Adjust sensor to touch rear of profile present lever

Adjust sensor back half a turn

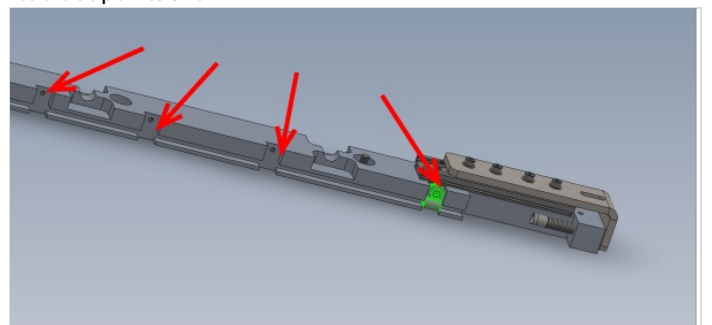
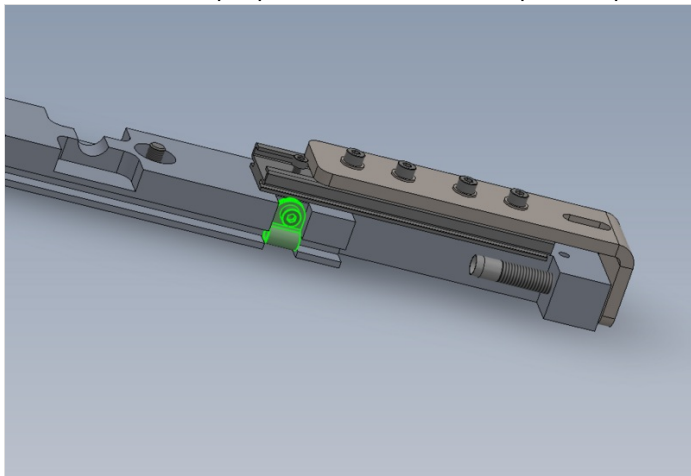
Lock of lock nut to hold position (Do not over tension)

Check, when lever is pressed fully back, the sensor should be close to the profile present lever but not touching



Step 10 - Fix X294 cable

Use 4 off A0001044 p clips 4 off M4 x 12 socket caps and captivate X294 cable at points shown



Step 11 - Assemble cylinder P0001120



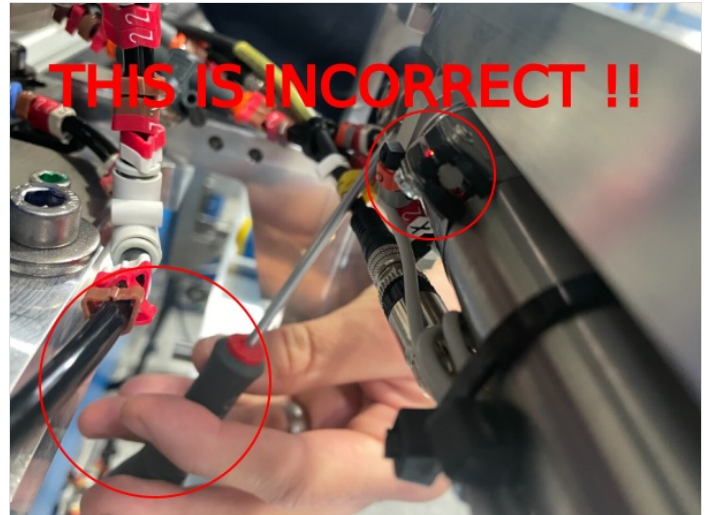
...When fitting reed switch, ensure grub screw is removed before fitting location clip

Fit air fitting P0001198 to cylinder

Remove 32mm nut from cylinder and discard

Mount reed switch and band (P0001041 x 1 P0001013 x 1 P0001128 x 1) to cylinder in piston retracted position , mark as X291

Ensure sensor is orientated the correct way, so adjustment screw can be accessed if needed. Sensor should be at 90 degrees position to top of cylinder , not as shown in example of wrong mounting



Step 12 - Quality

Please ensure the following gap of 13mm is set with verniers, as accuracy is crucial

Tolerance $\pm 0.1\text{mm}$



Step 13 - Caution



Step 14 - Assemble grip pin assembly

1 Fit bushes B0000437 x2 to body D0015431

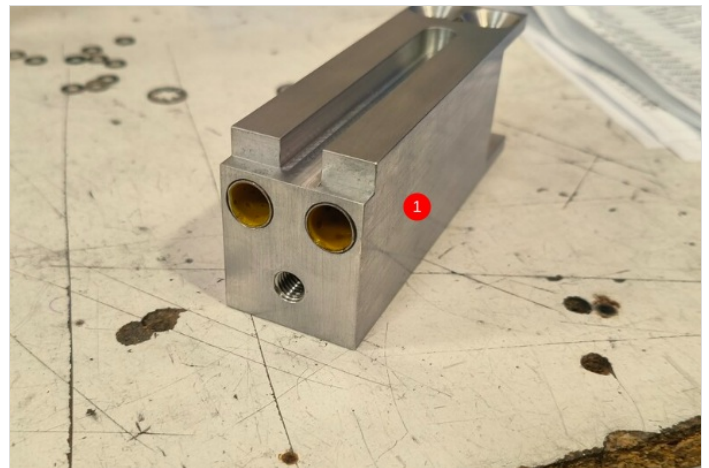
2 Use 2 off 10mm x 40mm dowel. Ensure dowels fit correctly in nose D0015430. Check dowels have pushed all the way to the bottom of the bore . Secure with 2 off M4 x 5 grubscrew

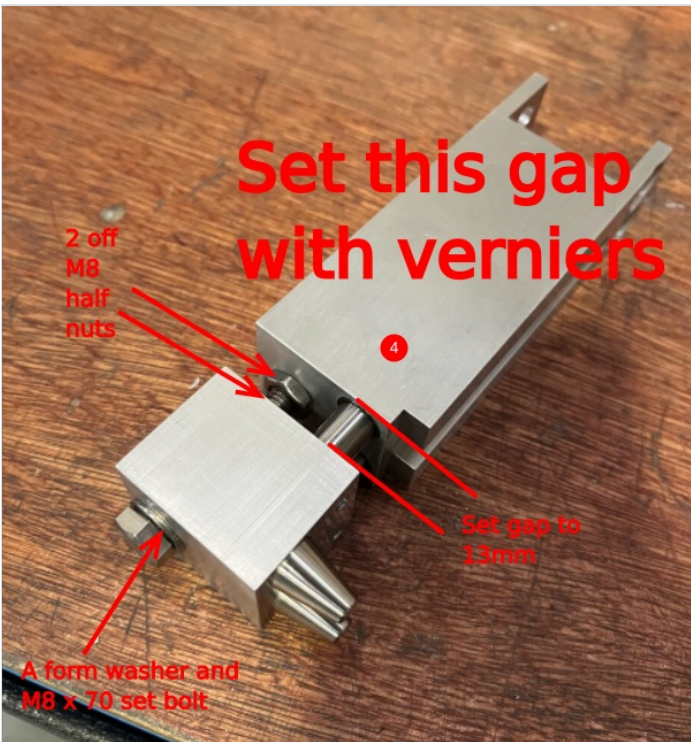
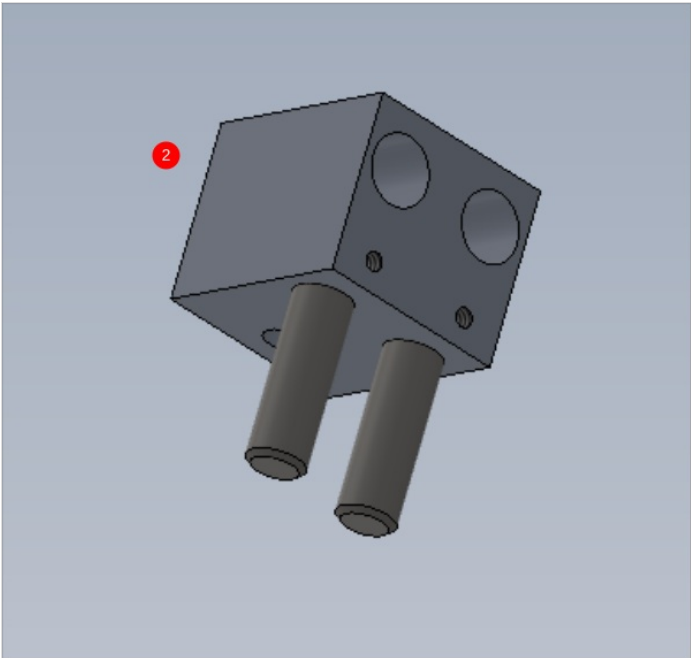
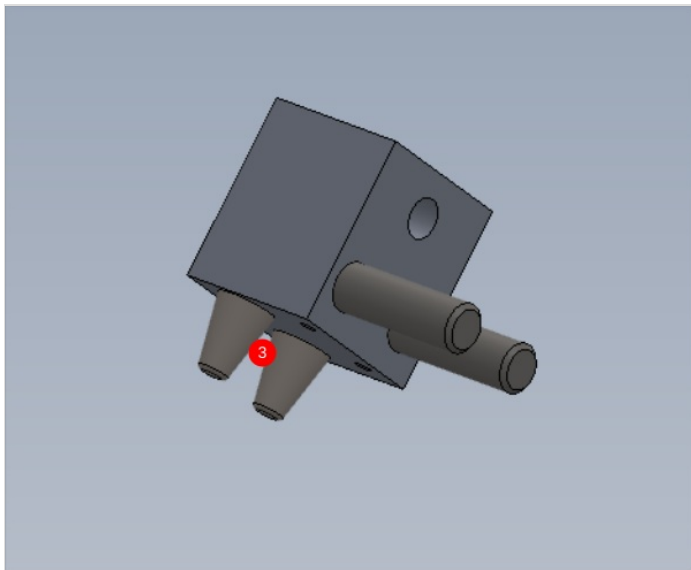
3 Fit D0015090 Grip pin x 2 and secure with M5x 16 socket cap

4 Combine together and use m8 x 70 set bolt, a form washer and 2 x m8 half nuts to secure. Set gap to 13mm with verniers and lock all fasteners. Recheck measurement tolerance +- 0.1mm



.....Ensure loctite 243 and final tension is added to 2 off locking nuts indicated when setting grip nose gap





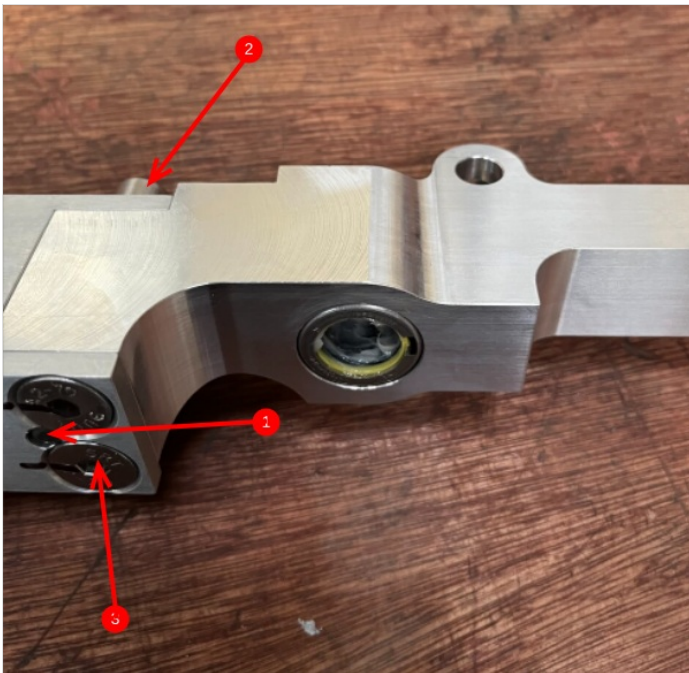
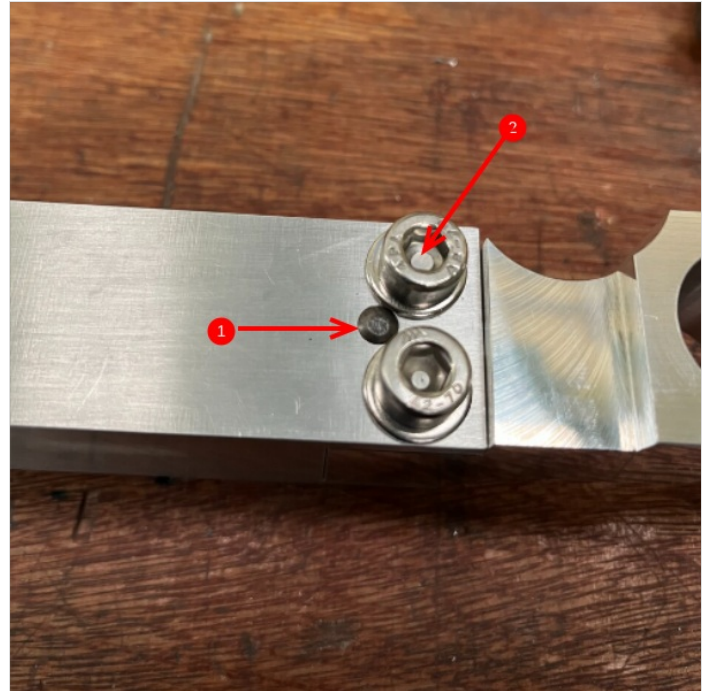
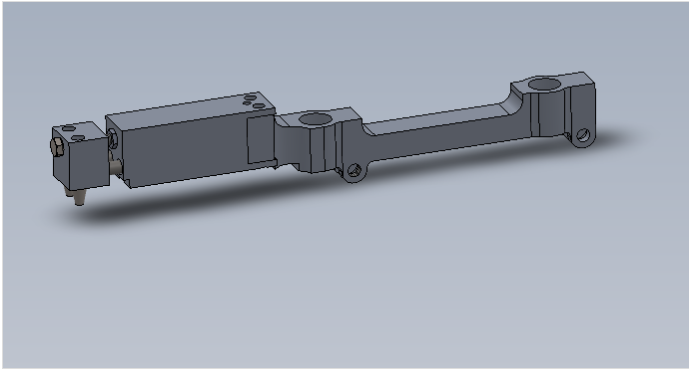
Step 15 - Mount grip pin assembly to grip slide

Combine parts

1 Use 2 off 6mm x 20mm dowels to align (1 top and 1 bottom)

2 M8 x 16 socket cap and A form washer

3 M8 x 20 countersink



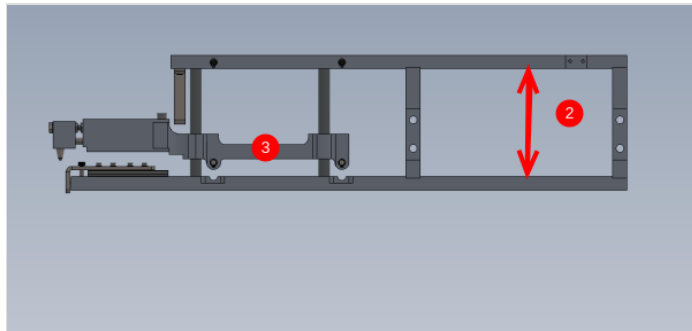
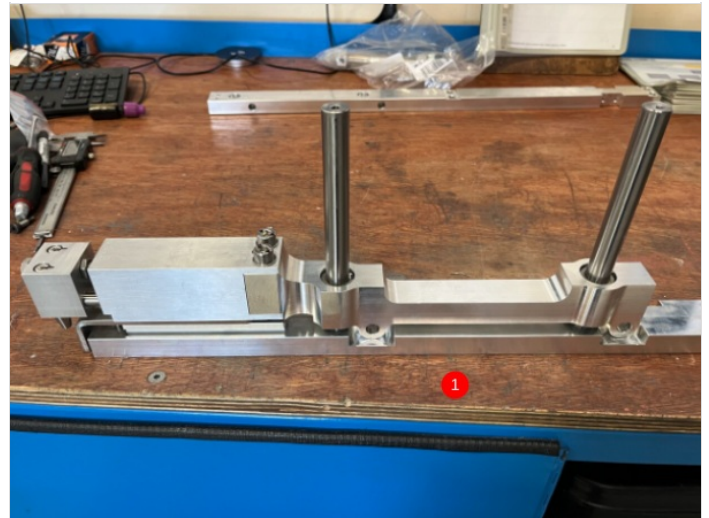
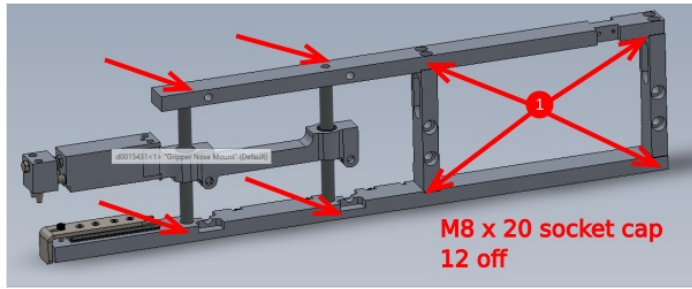
Step 16 - Assemble main frame of gripper assembly

Use 2 off D0015085

1 Assemble as shown using 8 off M8 x 20 socket caps

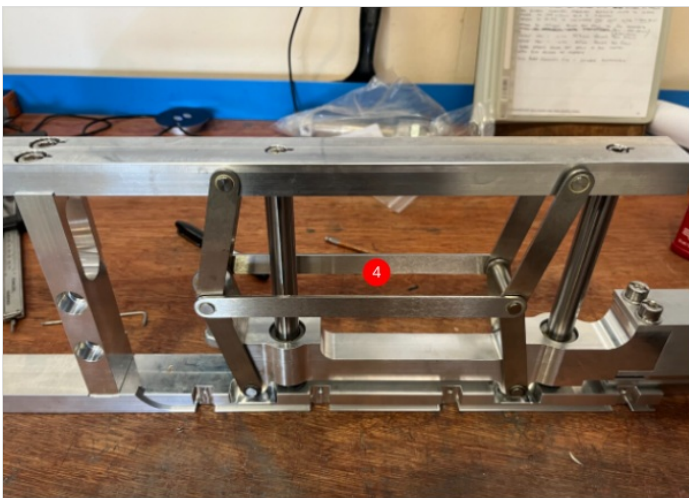
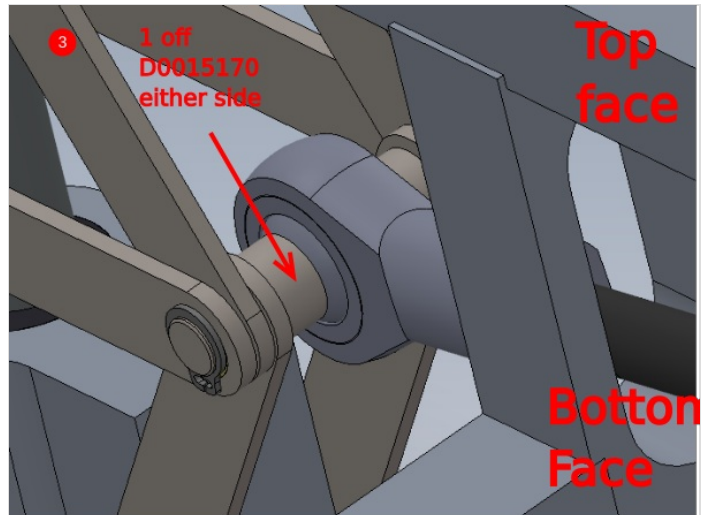
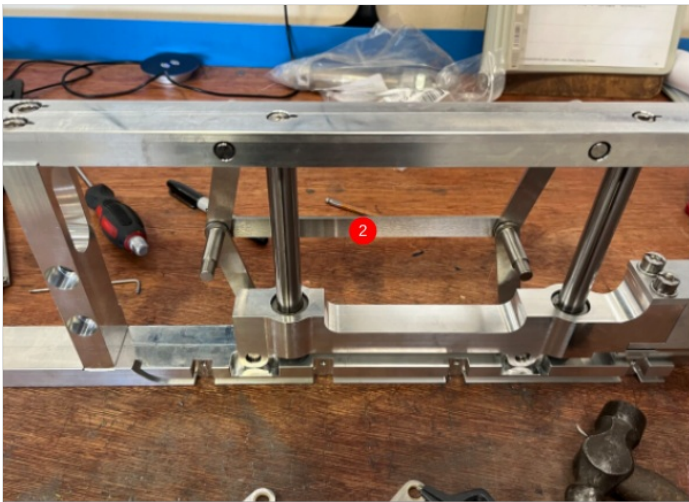
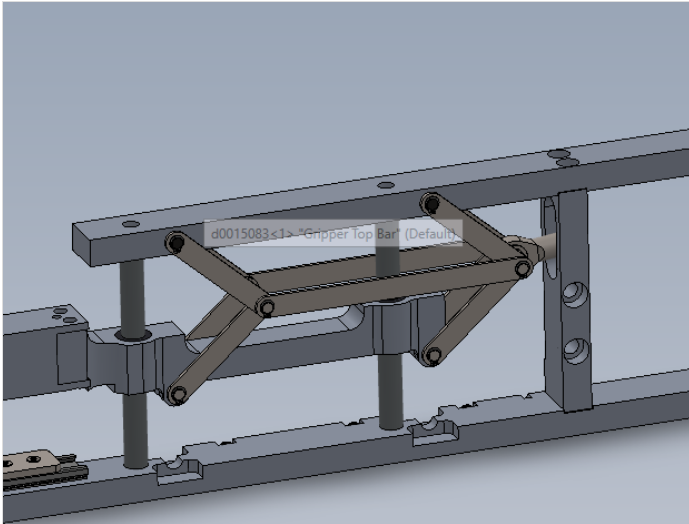
2 Check top and bottom bars are parallel

3 Check grip slide moves freely up and down



Step 17 - Fit link bars to assembly

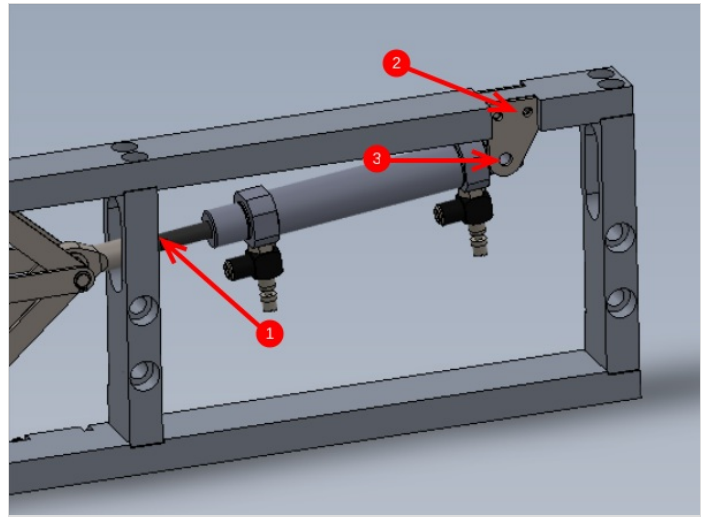
- 1 Use 2 off D0015103 and 8mm external circlips (B0000200) and assemble two off as shown
- 2 Use 2 off D0015102, 2 off D0015104 and assemble as shown with 8mm circlips
- 3 Use 2 off D0015170 gripper spacers and P0000049 spherical end and add as shown
- 4 Add remaining link shafts and circlips



Step 18 - Fit Cylinder assembly

Fit assembled cylinder unit to gripper frame

- 1 Wind cylinder thread into spherical bearing lock cylinder nut off with 1 thread of cylinder piston exposed behind lock nut
- 2 Use M5 x 10 with a form washer to secure D0015097 2 off mounting plates
- 3 Use M8 x 30 with M8 nyloc nut to secure cylinder to brackets



Step 19 - Add mounting brackets

Fix as shown 2 off D0015101 brackets with 4 off M10 x 40 socket caps

Do not apply adhesive or final tension to these fasteners

