

Mounting instructions for assembly groups

- **Grease**

- All screws shall be covered with graphite grease on the thread prior to assembly.
- The HV sets must not be greased at the thread.
- Conical tube screw connections with union nuts must be greased at the thread and the cone (normal grease).
- Lubrication points with lubricating nipple must be greased and then sealed with an adhesive sticker. This serves for checking purposes and later marking for maintenance (sticker blue, round, diameter 35 mm, white symbol).
- Shaft to collar fitting surfaces must be provided with a non-conductive grease to avoid fretting corrosion.



- **Torque**


- High-tensile bolts of grade 10.8 and 12.9 are tightened with a torque as specified in literature (unless already specified by design) with middle friction factor

- **Screwed connections**

- A Schnorr tooth lock washer shall be placed under each screw head even if this is not listed in the BOM.
- For high-tensile bolts tightened with a specified torque, **NO** Schnorr washers must be used.
- For soft surfaces such as aluminium, washers shall be used even if they are not listed in the BOM (on both sides). The minimum screw-in depth is 2 x screw diameter.

- **Lacquer coating**

- Screw heads shall be covered for varnishing, and the adhesive tape shall be removed immediately afterwards.
Alternatively, varnished screws must be replaced by unpainted screws, which must then be replaced individually one to secure the alignment.
- Free surfaces serving for assembly must be repainted (machines assembly surfaces).
- Free metal surfaces shall be painted with a brush after assembly (e.g. roller tappet).
- Labels must be removable without residue.
- No adhesive tape shall be placed onto varnished surfaces.

Mounting instructions for assembly groups	 KROENERT GmbH & Co. KG Schützenstraße 105, 22761 Hamburg
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Seals

- When using metal seals, a liquid surface seal is used additionally (serves for filling). Threads must not be sealed.
- For stainless steel threads, the thread seal and a Teflon strip shall be used.

• **Rotary joints**

- The rotary joints as flange version shall be aligned according to manufacturer's specifications.

• **Roller**

- Rollers shall have a parallelism of 0.05mm/m working width to the alignment bar(s) in each plane, unless otherwise specified in the module or assembly drawing. If there is no hole for an alignment crosshead, align the guide and measuring rollers among each other with the above mentioned tolerance.
- If it is not possible to align the guide rollers (for example at operating platforms without alignment bars or the associated module / module), these must be marked "not aligned" on the packaging of the installed roller.
- Adjustable and swiveling rollers must be aligned in every position and position as mentioned above.
- Flange bearing housings must be pinned only after special notice on the drawing.

• **Retainer for guide roller**

- Retainer for guide rollers must be pinned after aligning the rollers if no fitting sleeves are used.

• **Aligning for support frames and machine frames**

- The specified tolerances in the assembly drawing must be observed
- Crossbars with flange plates must first be centred by using countersunk screws in accordance to ISO 10642 (the through borings for screws in the traverse to the tap hole in the frame walls). Subsequently, the countersunk screws must be replaced one after the other by the screws in the parts list.

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- **Pneumatic system**

- Warning notices according to the pneumatic plan are to be observed.
- Pneumatic hoses from Festo are to be used in the corresponding nominal widths according to the pneumatic plan. Special features are indicated in the pneumatic plan.
- There are generally as least as possible connectors to use.
- Each component must be labeled with its equipment label (BMK).
- Hoses are to be labeled according to the pneumatic plan at each intersection point. The inscription must be made with Weidmüller terminal markings.



- Connectors and components from Festo are to be used.
- Elbow fittings should be avoided if possible.
- When pre-hosing the modules, the hoses must always be laid to the drive side (if possible using existing crossbars) and 2 m pneumatic hose must be left over. The end is to be provided with a coupling and the particular hose designation.
- Pneumatic cabinets are to be provided with bulkhead fittings, at the outer end of a piece of tubing with the appropriate label to attach.
- As a reserve, 4 bulkhead fittings $d = 8\text{mm}$ and 3 bulkhead fittings $d = 10\text{mm}$ are to be provided in the pneumatic cabinet.
- The position of the bulkhead fittings must be agreed with KROENERT before installation.

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- For the valve terminals use all mounting brackets for the assembly.



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