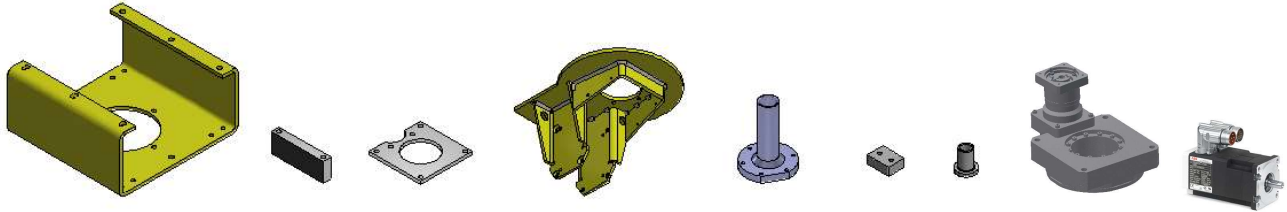


XL-Saw Assembly Left Hand Feed – Shimpo Assembly Notes



F52-01 **MP01-020** **MP01-019** **F54-01** **MP01-018** **MP01-015** **RI-0008** **RH-0009**
& MP01-021

F52-01 – Shimpo Mounting C Plate

RI-0008 – Shimpo Gear Box STHVL70040214CA1100

MP01-020 – Shimpo Riser (2 Ea)

MP01-019 – Shimpo Bearing Plate

Thread bolts facing up from under F52, and locknuts on top of MP01-019

Use with Red Loctite 7/16-20" x 5-1/2" Hex Head Bolt and 7/16-20" Lock Nut (4 Ea) (PIC32)

F54-01 – Pivot Weldment (Spaceship Enterprise)

MP01-018 – Shimpo Flange (Dry fit to MP01-019 bearing first, shaft may need sanding)

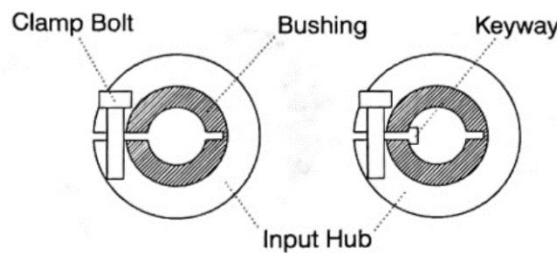
Thread Flange through bottom of F54, insert into MP01-019 Bearing. Flat side of flange faces cylinder.

Secure using Red Loctite with M8-.50 x 40mm SHCS (6 Ea)

Confirm pivots smoothly. Tighten setscrews on MP01-019 bearing. Confirm free pivot again.

MP01-015 – Hard Stop Block – Bolt to F52 with 3/8-16" x 2" Hex Head Bolts with 3/8-16" Lock Nuts (2 Ea) (30)

NOTE: Configuration is reverse for Right Hand Feed machines.



RH-0009 - Remove Key – **CRITICAL: Align shaft bushing split with the collar bushing split.**

Turn clamp bolt with access hole on housing. Insert motor with empty keyway aligned with collar splits.

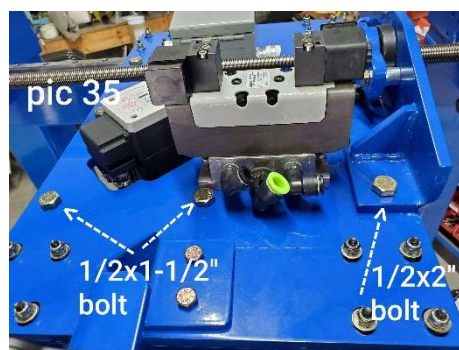
Tighten 4 motor bolts M5 x 25mm SHCS, then tighten set screw, super tight! Do not use ball end allen key.

Install F52 and Shimpo Assembly in machine to underside of F51 Slide Plate – See (30) for orientation.

using 1/2-13" x 1-1/2" Hex Head, 1/2" Washer and 1/2-13" Lock Nuts (4 Ea) (35)

and at F53 Acme Nut Mount using 1/2-13" x 2" Hex Head, 1/2" Washer and 1/2-13" Lock Nuts (2 Ea)

Insert support threaded rods on sides 1/2-13" x 9" (2 Ea) Use 1/2-13" Hex Nut (8 Ea) As shown (33)



XL-Saw Assembly Left Hand Feed – Shimpo Assembly Notes

MP01-021 – Shimpo Plug – Insert in top of MP01-019 Bearing for wire and tube strain relief. Free floating.

PC-0012M – Carriage Cylinder MGPM63TN-100AZ (29)

Mount into F54 – Cylinder holes get M10-1.50 x 25MM SHCS (4 Ea) (29)



F55-01 – Foot Weldment – Bolt to PC-0012 with M10-1.50 x 25mm SHCS and M10-1.50 Lock Nuts.

MP01-014 – Saw Head Motor – Bolt to F54 as shown with 3/8-16" x 3/4" Hex Head and 3/8" Washer (4 Ea) (26)

F56-01 – Motor Pivot Shroud – Install shroud on F54 with 1/4-20" x 3/4" Hex Head Bolt and 1/4" Washer (4 Ea) (Picture)

HG-0006 – 16" Blade (26)

MP01-007 – Blade Washer – Sandwich blade and washer to motor. (25)

Secure with 3/8-16" x 1-1/4" Hex Head Bolts and 3/8-16" Flanged Serated Nuts

XL-Saw Assembly Left Hand Feed – Calibration Notes

See calibration guide for in detail instructions. Calibration to be checked and confirmed:

STEP 8: 90 Degree (Cut a 90 on a minimum of a 2x6 and adjust A-Axis homing position as needed)

STEP 9: Blade Center of Pivot (Measure blade at 0 degrees and at 180 degrees. Confirm two values are the same)

STEP 10: Blade Vertical (Measure blade at 0 degrees at base of blade and at top of blade to confirm vertical)

STEP 14: Centerline Test (Cut a double 45 from file in calibration folder, confirm point is at 1.75")

STEP 15: 30-150 Test (Final test to be performed to confirm everything is right, file in calibration folder)