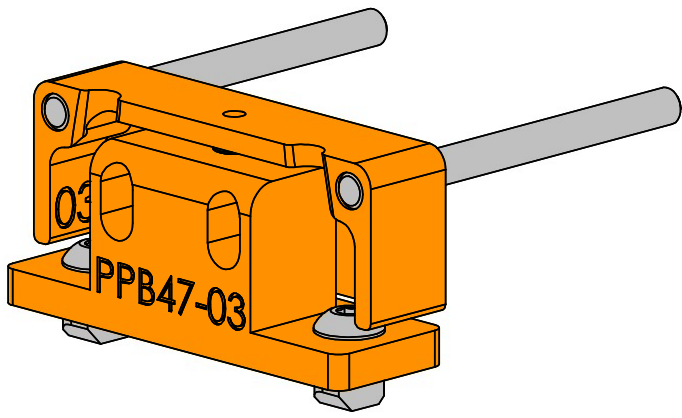


2

1

B

B



A

A

2

1

13 Adjustable Parking Post Assembly



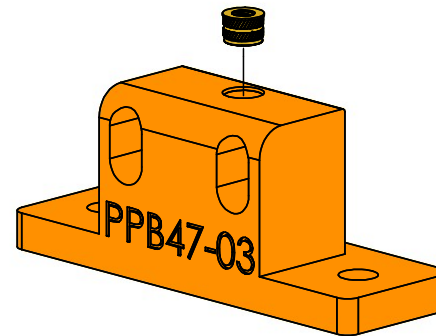
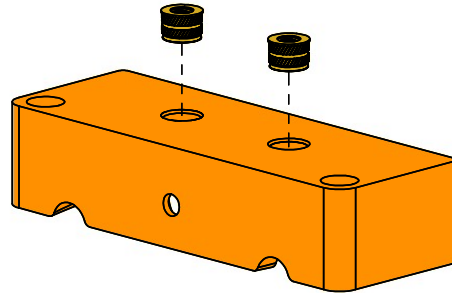
Created by:
Joshua Vasquez

last edited:
2/16/2020

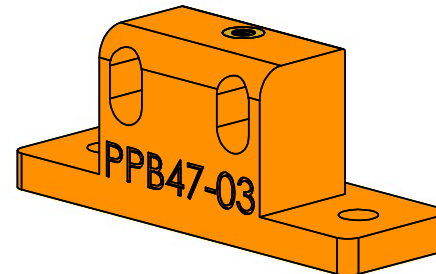
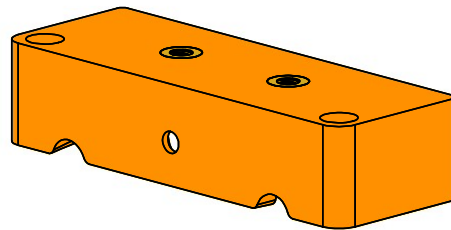
SCALE: 1:1

SHEET 1 OF 5

Install the following three M3 Heat Set Inserts in their respective locations using the Plate Press technique.




Exploded View



Assembled View

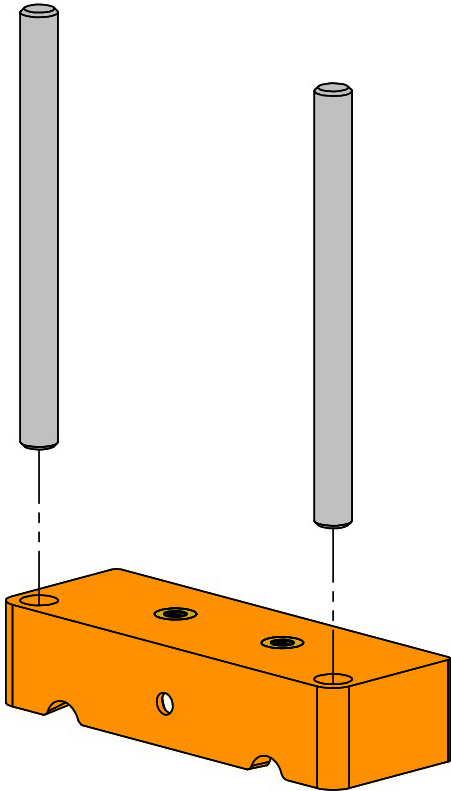
ITEM NO.	DESCRIPTION	QTY.
1	M3 Tapered Heat Set Insert	3
2	47mm Tool Holder	1
3	47mm Parking Post Base	1

Heat Set Insert Installation		
	Created by: Joshua Vasquez	last edited: 2/16/2020
	SCALE: 1:1	SHEET 2 OF 5

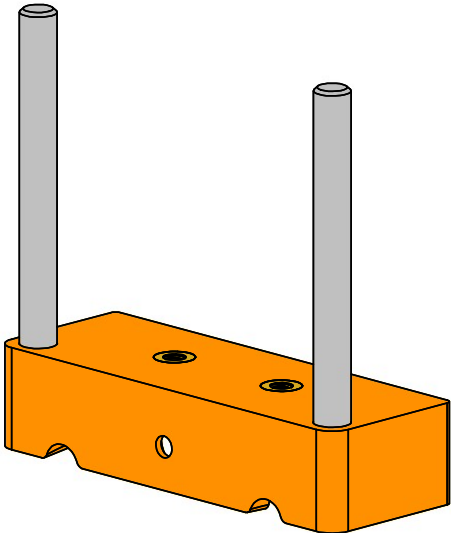
2

1

Carefully press fit the two dowel pins into the Tool Holder (with an arbor press) until they are flush with the bottom of the part.




Exploded View



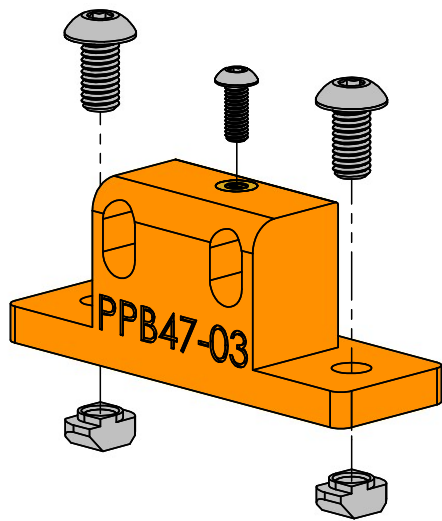
Assembled View

ITEM NO.	DESCRIPTION	QTY.
1	M5 Dowel Pin, 60mm len	2
2	Tool Holder with Inserts	1

Dowel Pin Installation		
	Created by:	last edited:
	Joshua Vasquez	2/16/2020
	SCALE: 1:1	SHEET 3 OF 5

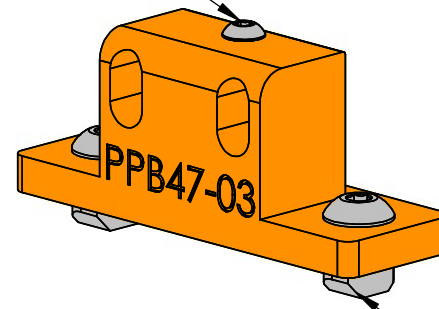
2

1



Exploded View


Install this screw all the way,
but do not tighten it.



Assembled View

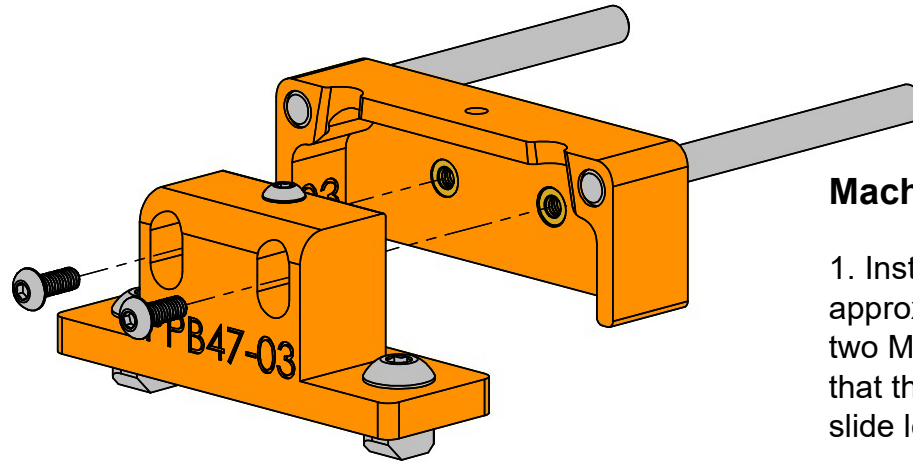
Keep these nuts loose (about 2-3 turns).

ITEM NO.	DESCRIPTION	QTY.
1	Parking Post Base with Inserts	1
2	M5 Buttonhead Screw, 10mm long	2
3	M5 Drop-In T-Nut for 20x20 Extrusion	2
4	M3 Buttonhead Screw, 8mm long	1

Parking Post Base Screw Prep		
	Created by:	last edited:
	Joshua Vasquez	2/16/2020
	SCALE: 1:1	SHEET 4 OF 5

B

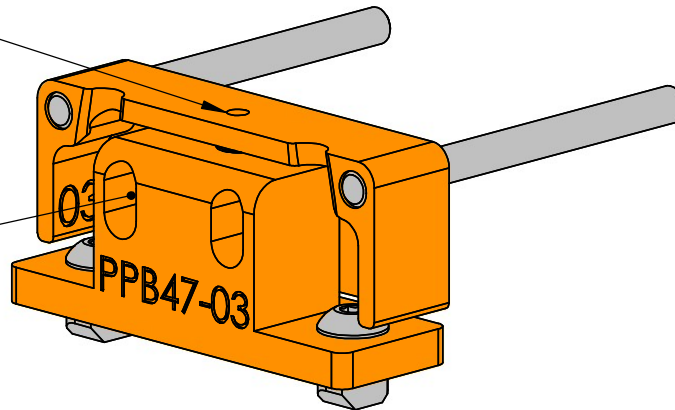
B



Exploded View

When the post is installed on the machine, use the top screw to fine-tune the height at the parking location.

Use the two screws in the pockets to set the parking position.



Assembled View

Machine Installation Tips:

1. Install the parking post on the frame in approximately the right position. Loosen both the two M5 screws and the back two M3 screws such that the parking post can wiggle up-and-down and slide left-and-right.
2. Load the corresponding tool into the carriage by hand. Lock the tool with the tool-change macro.
3. Gradually step the carriage (with the tool loaded) into the parking post at the pre-defined "tool release" position set in the macro file for the corresponding tool. Move the parking post location by hand such that the tool slides smoothly onto the guide pins. (The middle M3 screw can help fine-adjust the parking post height.)
4. With the location set, fully tighten all screws (except the middle M3 screw).

Note: when the tool is picked up and dropped off, the tool should **not** noticeably jiggle in and out of the parking post.

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ITEM NO.	DESCRIPTION	QTY.
1	Parking Post Base Subassembly	1
2	Tool Holder Subassembly	1
3	M3 Buttonhead Screw, 8mm long	2

Final Assembly



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SCALE: 1:1

SHEET 5 OF 5