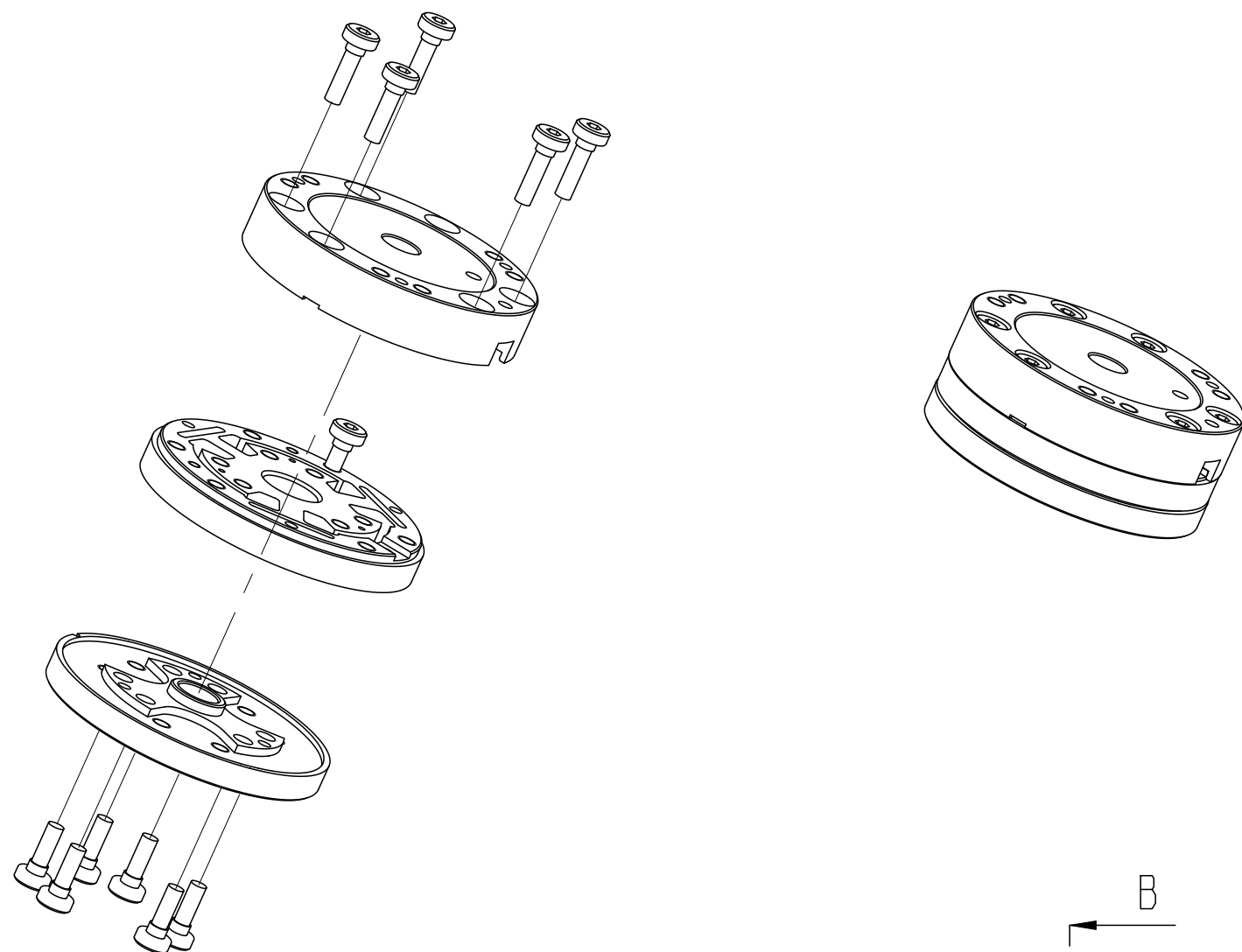


A

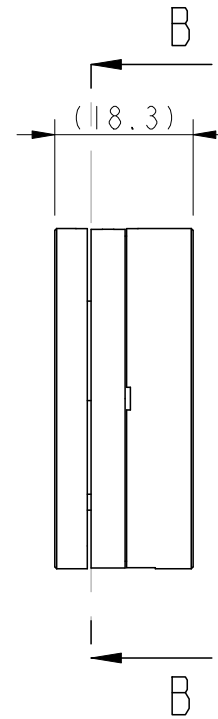
B

C

D



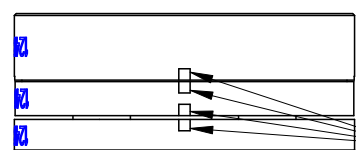
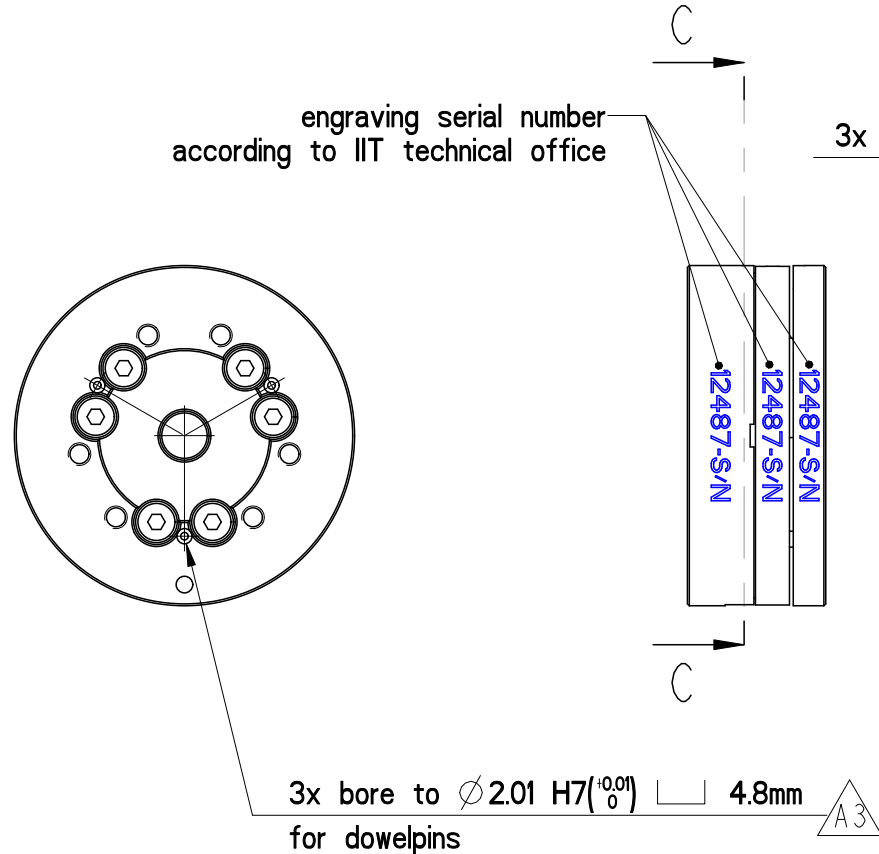
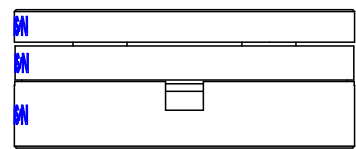
SECTION B-B



STEP 1
(see specifications 151245)
SCALE 1:1

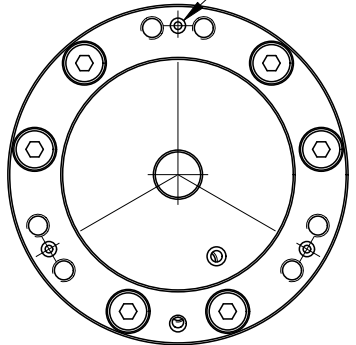
NOTES:

- Steps to be taken before assembling and calibrating the FT sensor. Contact technical office for any information about this procedure.
- You need to pre-assemble the FT sensor with the top and bottom covers, central sensor and screws (as shown in Fig.Step1).
- Align the holes for dowel pins before tightening the screws of the bottom and top covers.
- Drill holes of $\varnothing 1.9\text{mm}$ for the dowel pins on IC.008.P.002 and IC.001.P.003 and increase them to $\varnothing 2.01\text{ H7}(\frac{+0.01}{0})$. Test the holes using a Dowel pin of size: ISO 2338B n3.
- Drill holes of $\varnothing 1.9\text{mm}$ for the dowel pins on IC.008.P.001 and increase them to $\varnothing 2\text{ M6}(\frac{+0.002}{-0.008})$. The pins will be interference fit on this component.
- VERY IMPORTANT: You have to engrave a "part number" - "serial number" on the three parts which were just assembled with the same denominations used in the production department of IIT before you can disassemble it.
The part number for this assembly is 12487 , about the S/N ask to IIT Production department. Typically, the format is the following: "00000 - S/N000" where the zeroes stand for a 5-digit and a 3-digit numerical code.
- Send the part IC.008.P.001 for gluing on the strain gauge. (Refer to Fig.STEP 2)
- Assemble the FT sensor (as shown in Fig.STEP 3) and calibrate it according to IIT specifications

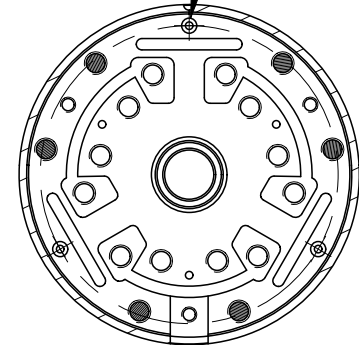


Align the cuts as shown

3x bore to $\varnothing 2.01\text{ H7}(\frac{+0.01}{0})$ 7.5mm for dowelpins

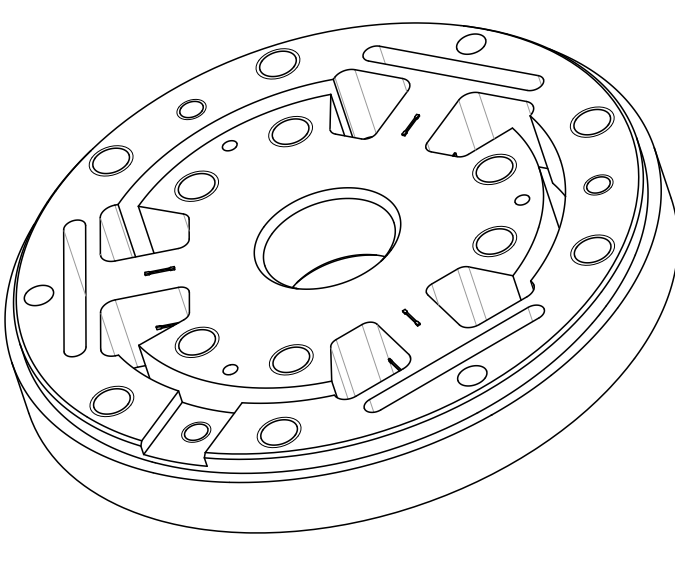
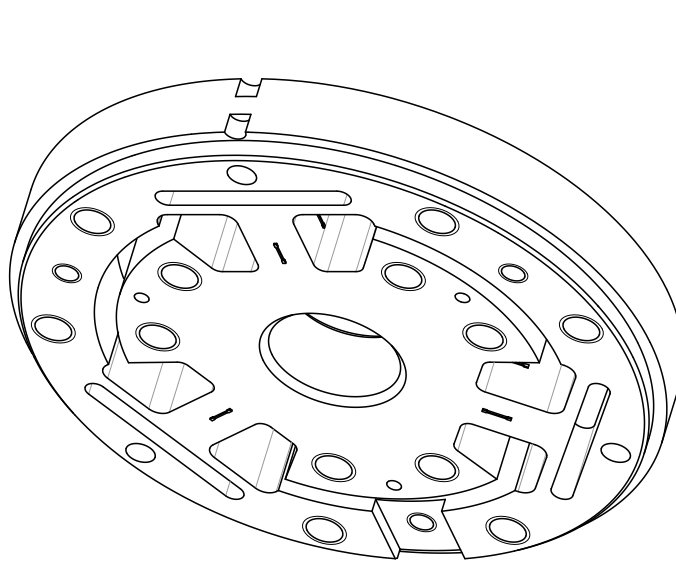


3x bore to $\varnothing 2\text{ M6}(\frac{+0.002}{-0.008})$ for dowelpins



SECTION C-C

STEP 2
(see specifications 151245 for strain gauge assembly)
SCALE 2:1

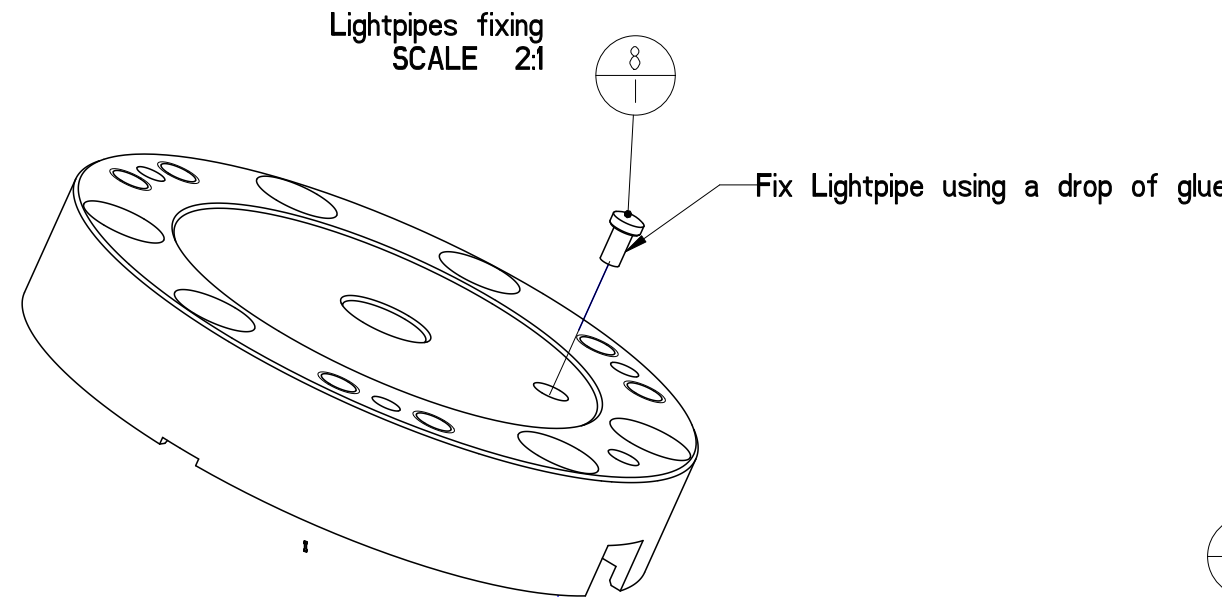


E

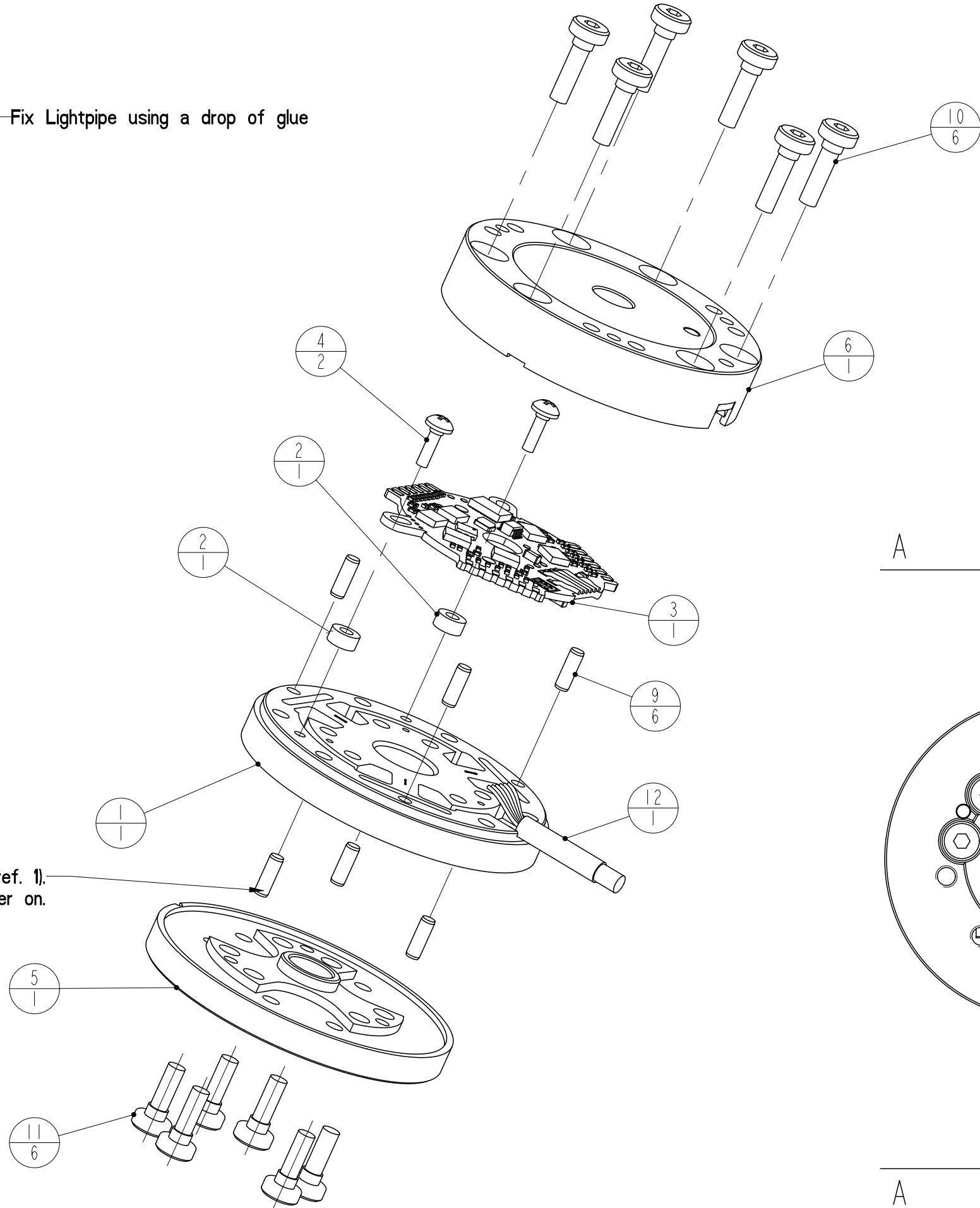
F

G

H



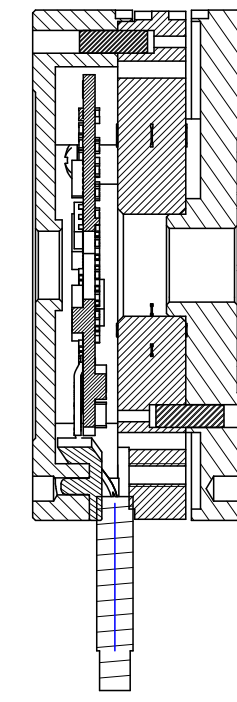
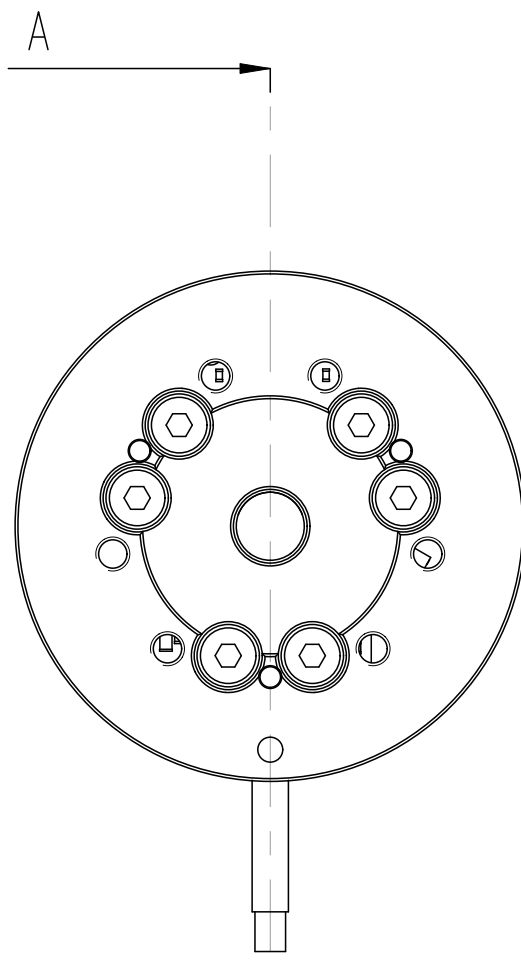
Fix the lightpipe by press-fit.
If required use adhesive



Fix all pins on the middle sensor (ref. 1).
After assembly the top and bottom cover on.

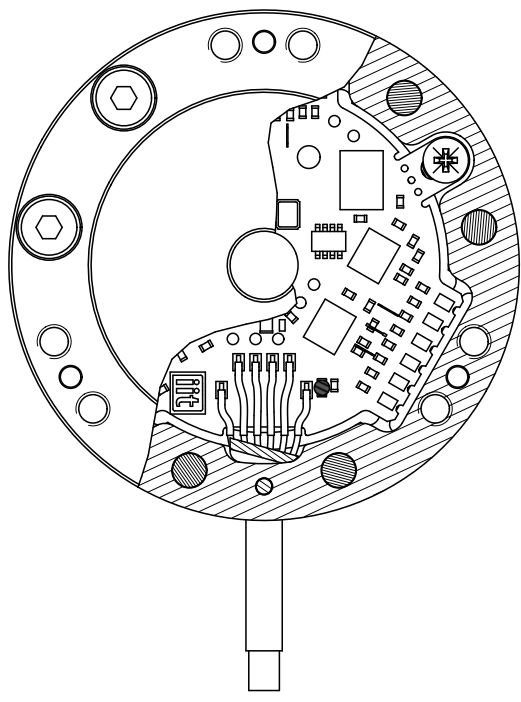
STEP 3
(final assembling)
SCALE 15:1

ATTENTION
Assembled the dowelpin ref.8
only in according to technical office.
Could be required a Sensor without dowelpins

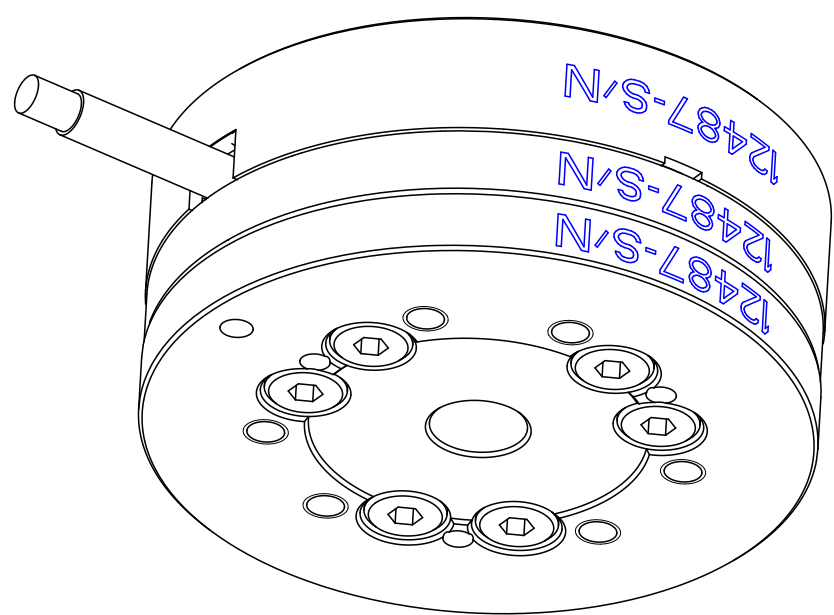


SECTION A-A

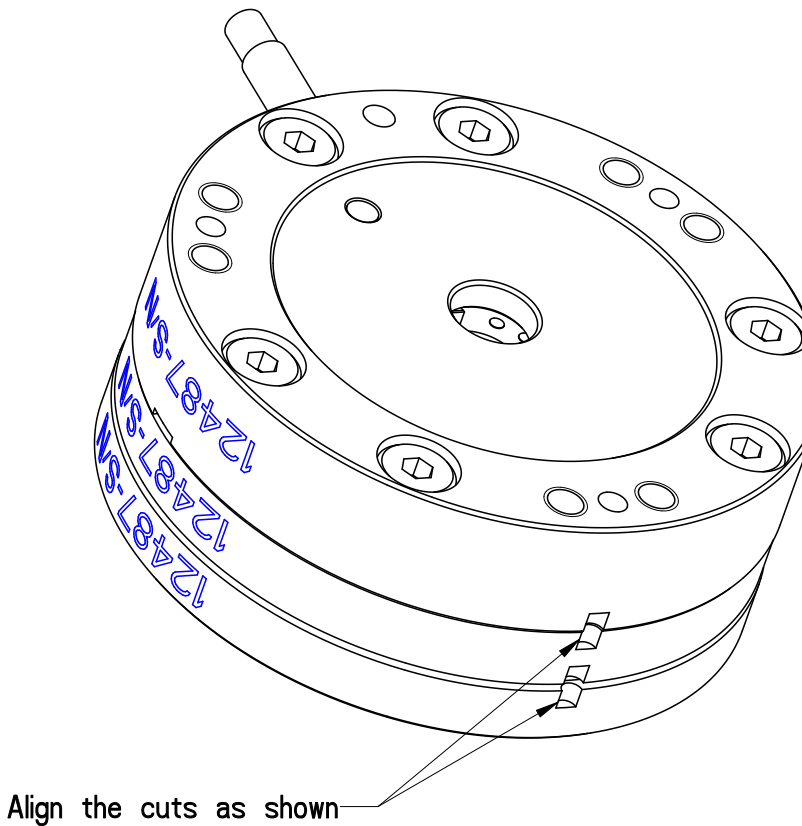
SCALE 15:1



SECTION G-G



3D VIEW
SCALE 2:1



Align the cuts as shown

Rev.	Reviewer	Description	Zone	Date	Drawn	Checked
A3	IIT	changed dowel pin holes tolerances		11/10/19	Gesino	
12	1	IC_008_A_001_CABLE				
11	6	V3-8--_D7984_GC				
10	6	V3-10--_D7984_GC				
9	6	S2-6--_D12338_B				
8	1	IC_005_P_007				
7	1	IC_008_P_006				
6	1	IC_008_P_002				
5	1	IC_001_P_003				
4	2	V2-6--_D1507045_CZ				
3	1	STRAIN2_PCA_HR				
2	2	IC_005_P_013				
1	1	IC_008_R_001				
POS.	QTY	CODE	DESCRIPTION	Mass Kg	Rev.	
	Issued	Drawn	Checked	Approved	0.123	A3
	IIT	Savoldi			Scale	Sheet
		Description	FORCE/TORQUESENSOR Ø45 mm		1:1	1/1
		Drawing code	IC_008_A_001		Date	19-Mar-18