

AS-35197 (Correa gemela 670)



Quitar AS-35197 (Correa gemela 670)

Tiempo estimado de retirada: 15 minutos

Herramientas necesarias:

- Llave hexagonal - 3 mm
- Llave hexagonal - 4 mm
- Destornillador - ranura, 5 mm

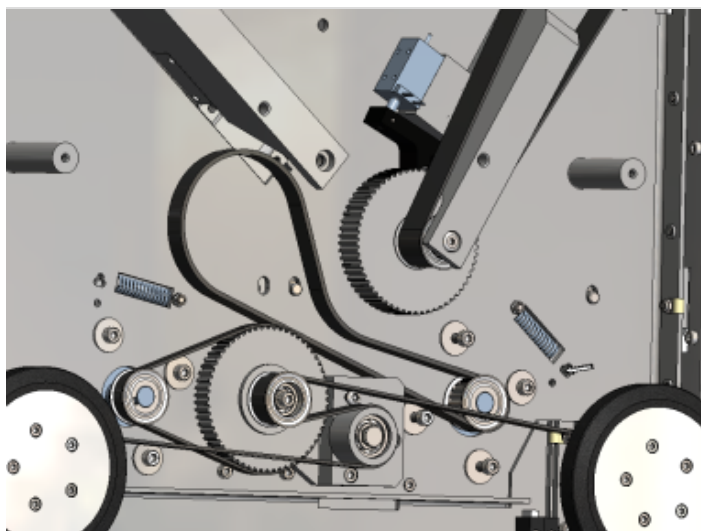
Preparación:

- Retire AS-35205 (SDG de la parte superior de la hoja) / AS-35646 (DDG de la parte superior de la hoja)[as-35205-sheet-top-sdg---as-35646-sheet-top-ddg-.html#UUID-2653ba5f-4e21-b730-9d1e-f6dd04791b3a_UUID-9a96252c-e093-b3f9-9d3b-4de2dade2faf]
- Retire AS-35021/ AS-35945 (frente de hoja)[as-35021-r5---as-35945-r5---sheet-front-.html#UUID-31b10256-172a-aa77-27f3-70611fd2f729_UUID-e830e1e1-7335-76b1-3edd-915246c7f0c6]
- Retire AS-35011 / AS-35942 (Hoja trasera)[as-35011-r5---as-35942-r5---sheet-rear-.html#UUID-3cfa3d6f-2d13-f6a1-bd8c-29067174afcf_UUID-56eb0901-be2b-17b1-005e-ab3076196808]
- Retire el AS-35210 (Conjunto de baterías)[as-35210-battery-assembly-.html#UUID-d12b6509-2362-50e1-afbd-5d8ba4735988_UUID-852734a8-2963-b764-6ec9-926946f929e2]
- Retire el AS-35200 (piso de la batería)[as-35200-battery-floor-.html#UUID-bf9cabd6-ee31-0bef-ac7b-ab738d9b8c25_UUID-d5ae8863-70b4-5227-0eb8-ed569c4e031d]
- Aflojar AS-35197 (Correa gemela 670)[as-35197-belt-twin-670-.html#UUID-1ddb98a2-3186-bc5c-3f47-c2a275ed2263_UUID-40ebee84-2a67-6903-4dbd-8f9f0d7fd758]
- Afloje AS-35195 / AS-35934 (Correa de distribución)[as-35195-r5---as-35934-r5---timing-belt-.html#UUID-f740b189-e796-a67e-51e2-1467cd6ede5e_UUID-fbc4941c-fe2b-64b8-5852-fdc445c1477c] → Solo correa izquierda
- Coloque AS-35194 (Pinza) en posición segura[as-35194-robot-gripper-.html]
- Asegure el AS-35025 (conjunto de eje de tira) para que no se rote innecesariamente[as-35025-strip-shaft-assembly-sdg-.html#UUID-9507207e-08cd-327b-4673-adba8bfba480_UUID-10ffd9dd-941f-74d3-a347-ed3fa4e85ddd]

- Retire AS-35028 (Conjunto de engranaje de elevación) - Engranaje derecho[as-35028-liftgear-assembly-.html#UUID-3727122d-5b7a-ee02-06f8-830196490541_UUID-86e35c56-f53e-69b7-45d6-b3d2d565ef68]

Procedimiento:

Una vez que se haya retirado el mecanismo de elevación derecho, continúe quitando la correa doble.



Instalar AS-35197 (Correa gemela 670)

Tiempo estimado de instalación: 30 minutos

Herramientas necesarias:

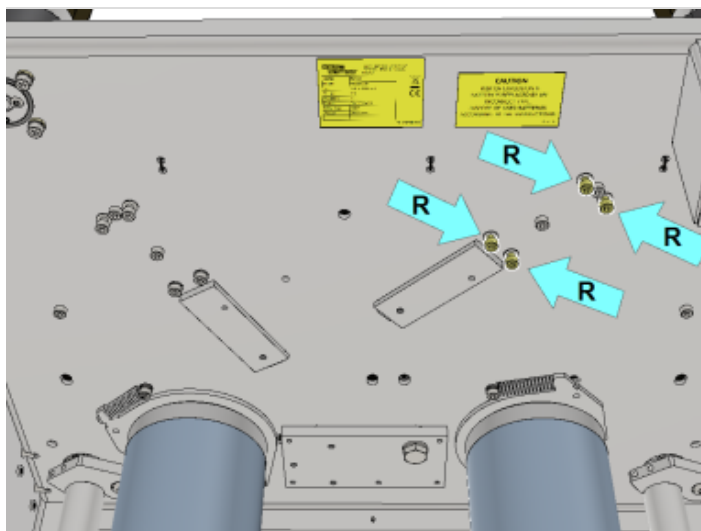
- Llave hexagonal - 3 mm
- Llave hexagonal - 4 mm
- Destornillador - ranura, 5 mm

Preparación:

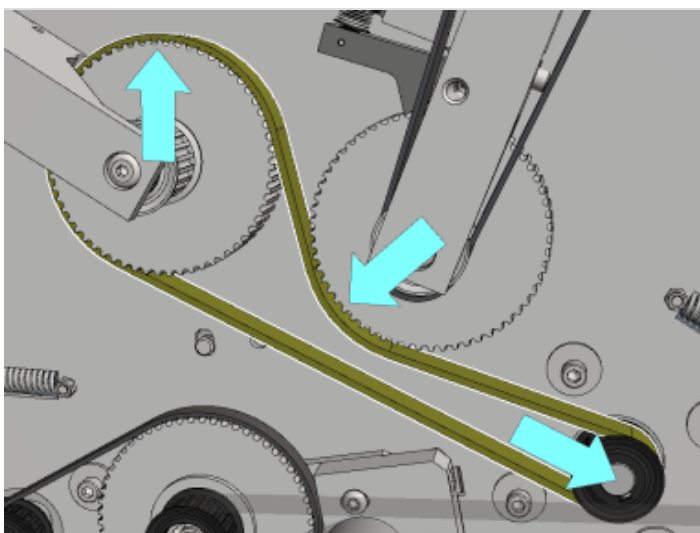
- Afloje cuatro tornillos hexagonales M5x16 mm (llave hexagonal de 4 mm), solo lo suficiente para liberar el tensor derecho.
- No retire los tornillos

Procedimiento:

1. Afloje cuatro tornillos hexagonales M5x16 mm (llave hexagonal de 4 mm), solo lo suficiente para liberar el tensor derecho.
2. No retire los tornillos



3. Coloque la correa doble 670 en cada marcha como se muestra en la imagen.



Finalización:

- Instale AS-35195 / AS-35934 (Correa de distribución) → Correa derecha[as-35195-r5-as-35934-r5-timing-belt.html#UUID-f740b189-e796-a67e-51e2-1467cd6ede5e_UUID-c8a627f5-98f7-d865-fe1e-18c2d656aa75]
- Apriete AS-35195 / AS-35934 (correa de distribución)[as-35195-r5-as-35934-r5-timing-belt.html#UUID-f740b189-e796-a67e-51e2-1467cd6ede5e_UUID-fd9cf96c-c35f-59da-3c41-859743ebb51e] → ambas correas
- Tighten AS-35197 (Belt twin 670)[as-35197-belt-twin-670.html#UUID-1ddb98a2-3186-bc5c-3f47-c2a275ed2263_UUID-2e1dc04f-24a3-32d2-6ea4-2d9de7816264]



Note

Keep this order. This belt must be tensioned after both AS-10740 (Timing Belt), NOT before

- Install AS-35200 (Battery floor)[as-35200-battery-floor.html#UUID-bf9cabd6-ee31-0bef-ac7b-ab738d9b8c25_UUID-e9c1ac70-60bc-7f33-75d1-905621cdfa3e]
- Install AS-35210 (Battery assembly)[as-35210-battery-assembly.html#UUID-d12b6509-2362-50e1-afbd-5d8ba4735988_UUID-a8e83a06-e4f7-0dd6-a877-ad9518033fc8]
- Adjust AS-35194 (Robot Gripper)[as-35194-robot-gripper.html#UUID-615f1cd0-c94d-2caf-556f-d588cec2487d_UUID-d2715e29-d943-ad24-47b3-fa071739f17f]
- Install AS-35021 / AS-35945 (Sheet front)[as-35021-r5-as-35945-r5-sheet-front.html#UUID-31b10256-172a-aa77-27f3-70611fd2f729_UUID-9b92d4e7-aba2-2c22-3c5d-0a94f0ac7d0a]
- Install AS-35011 / AS-35942 (Sheet rear)[as-35011-r5-as-35942-r5-sheet-rear.html#UUID-3cfa3d6f-2d13-f6a1-bd8c-29067174afcf_UUID-770524a6-795b-3ce1-c444-ef2d7880a405]
- Install AS-35205 (Sheet top SDG) / AS-35646 (Sheet Top DDG)[as-35205-sheet-top-sdg-as-35646-sheet-top-ddg.html#UUID-2653ba5f-4e21-b730-9d1e-f6dd04791b3a_UUID-67d6d688-0828-2123-11d3-b92cb6ca4d01]

Loosen AS-35197 (Belt twin 670)

Estimated removal time: < 2 minutes

Tools needed:

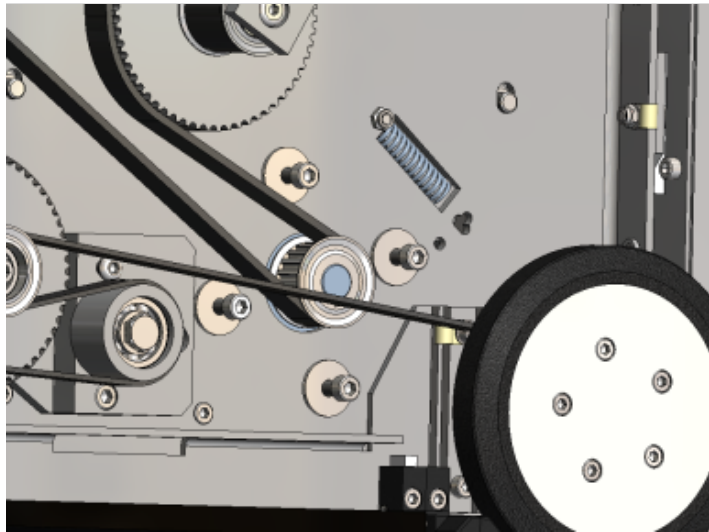
- Hex key - 3 mm
- Hex key - 5 mm
- Screwdriver - slot, 5 mm

Preparation:

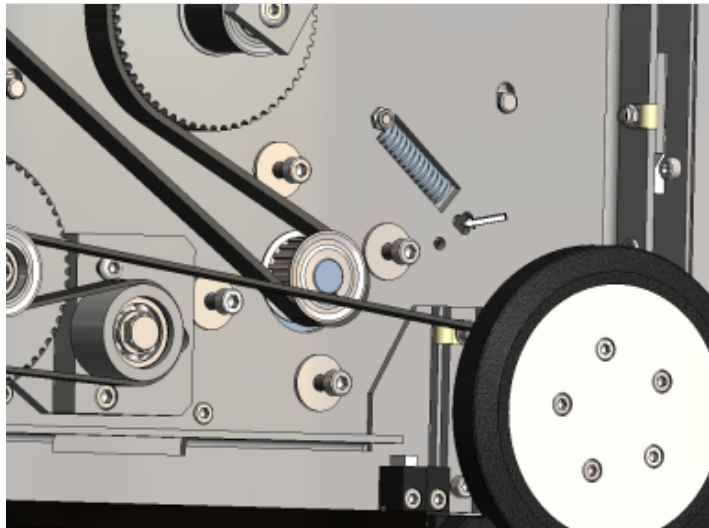
- Remove AS-35021 (Sheet front)[as-35021-r5---as-35945-r5---sheet-front.html#UUID-31b10256-172a-aa77-27f3-70611fd2f729_UUID-e830e1e1-7335-76b1-3edd-915246c7f0c6]

Procedure:

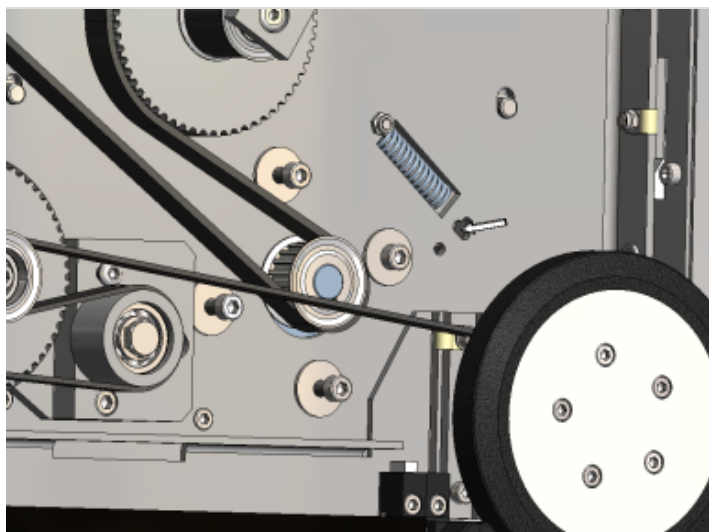
1. Loosen the four M6x20 mm hex socket screws (5mm hex key) on the lift motor but do not remove them.



2. Put a 5 mm flat screwdriver into the notch and compress the spring.



3. Still compressing the spring as much as needed
4. tighten one or two of the M6x20mm hex socket screws (5mm hex key).



Tighten AS-35197 (Belt twin 670)

Estimated installation time: 10 minutes

Tools needed:

- Hex key - 3 mm
- Hex key - 5 mm
- Hz meter

Preparation:

- Remove AS-35205 (Sheet top SDG) / AS-35646 (Sheet Top DDG)[[as-35205-sheet-top-sdg---as-35646-sheet-top-ddg-.html#UUID-2653ba5f-4e21-b730-9d1e-f6dd04791b3a_UUID-9a96252c-e093-b3f9-9d3b-4de2dade2faf](#)]
- Remove AS-35021 (Sheet front)[[as-35021-r5---as-35945-r5---sheet-front-.html#UUID-31b10256-172a-aa77-27f3-70611fd2f729_UUID-e830e1e1-7335-76b1-3edd-915246c7f0c6](#)]

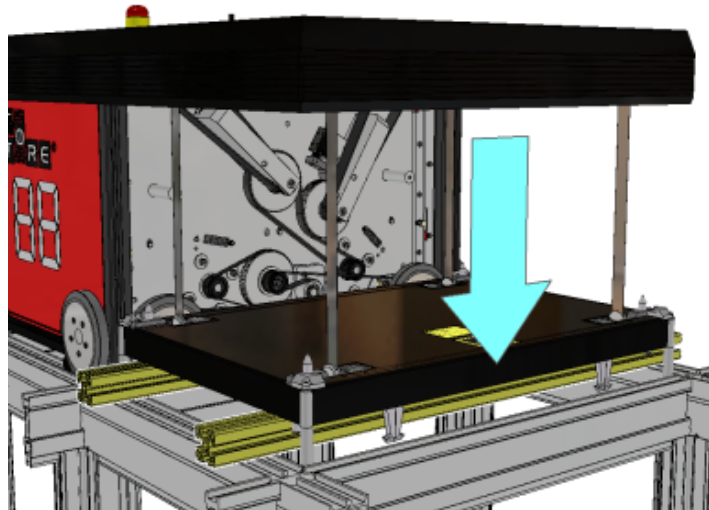
Procedure:

1. Put two bars under the Gripper (you can use the same bars as for Gripper adjustment).
2. Lower the Gripper until it will rest on bars and steel strips will be a little loose.
3. Do this manually → AS-35194 (Robot Gripper) Manual lowering



Note

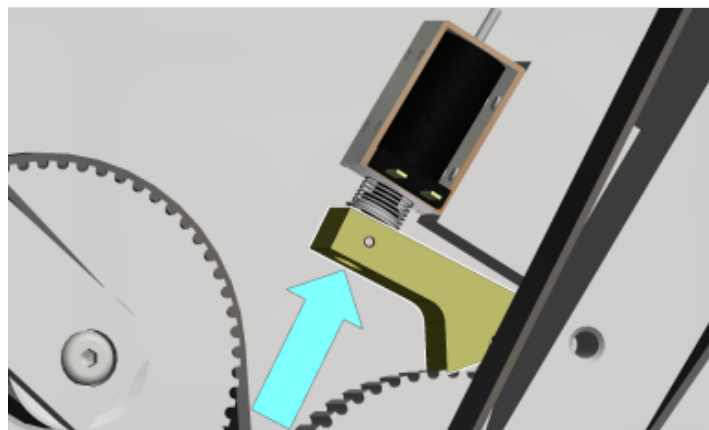
It's not recommended to use the Control panel, to lowering the Gripper in this procedure.



Note

To get reliable belt tension values - the Lift mechanism have to be free to move/revolve.

4. Press a hook to release the Lift Brake.
5. Keep a hook in this position when belt tensioning.
6. The easiest way is to use a duct tape or an insulation tape.
7. Go [here](#) to see an example.

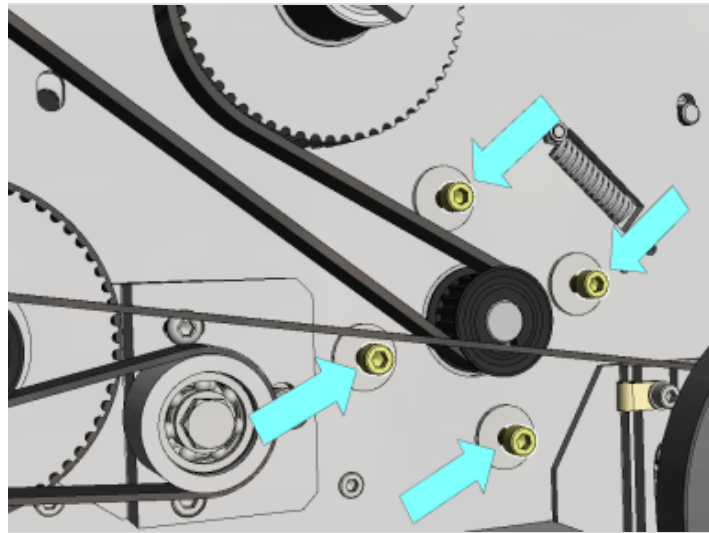


8. Loosen the four M6x20mm hex socket screws (5mm hex key) on the Lift Motor but do not remove them.

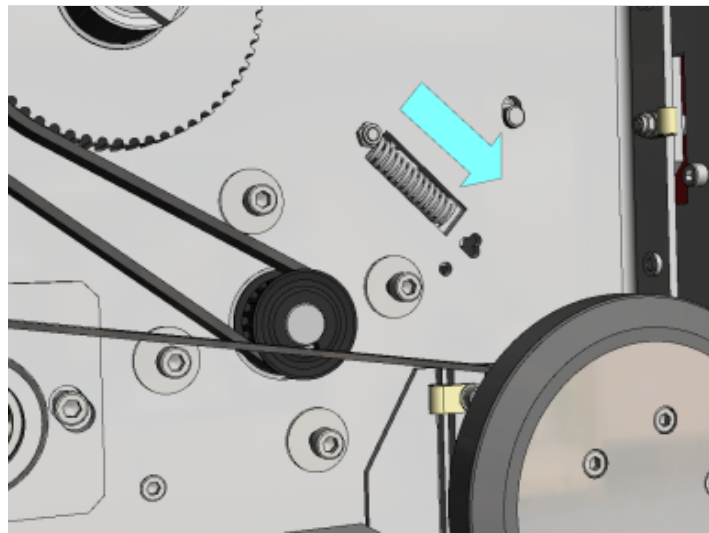


Note

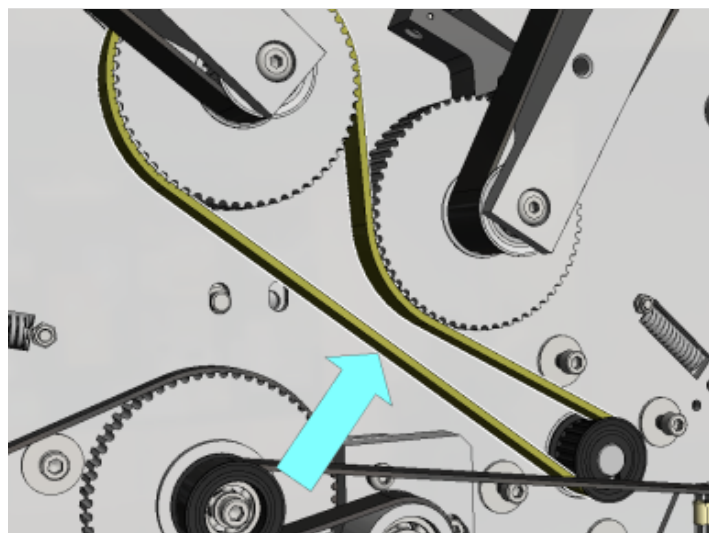
Screws should be loosened only enough to allow the Motor be able to move/slide (because of spring force).



9. If belt is slack – the Motor will slide back in position.



10. If the Motor won't slide back in position - try to push on belt by hand and then release.
11. The Motor should slide (smoothly) between two limit positions.



1. Tighten two M6x20mm hex socket screws (5mm hex key) on the Motor.

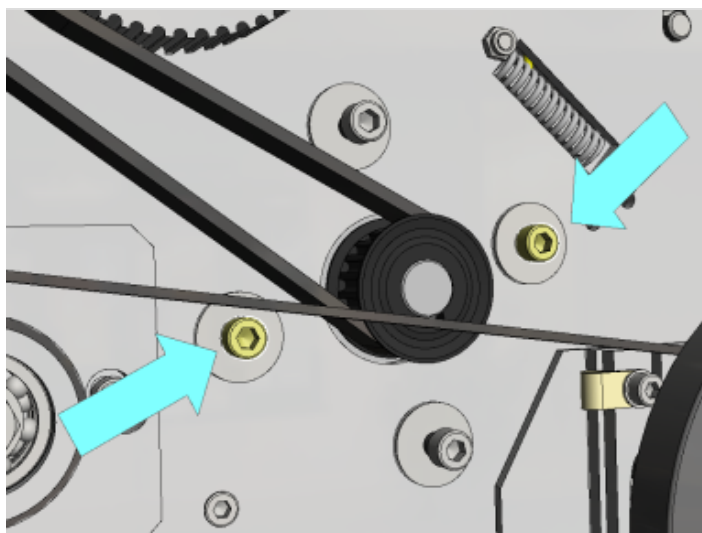
Only tighten enough to keep the motor in position

2. Go to Measurement Belt tension, find proper tension value for AS-10741 belt in the table.
3. Measure the belt.



Note

Make sure to use the correct measuring spot on belt.



If tension is too low:

1. You have to adjust the position of the Motor manually and measure the belt tension again.
2. Use longitudinal piece of wood or hard plastic (hammer handle for example) and hammer.
3. Gently punch in point as arrow shows (picture) to move the Motor in position (punching direction the same as arrow shows).

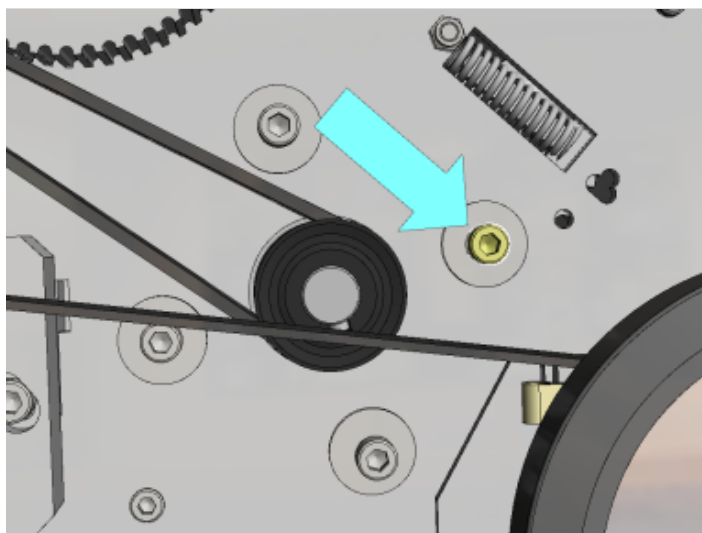
If tension is too high:

1. Do the same thing as above, but punch in the point from from opposite side of the screw head(punching direction also opposite than arrow shows).



Note

Make sure two screws (mentioned in previous step) are tighten only a little bit.



If they are too tight, adjusting by hammer may be not possible.

2. When tension is proper tighten the four M6x20mm hex socket screws (5mm hex key) on the Motor.
3. Measure belt tension again.

**Note**

Four M6x20mm hex socket screws need to be tightened with torque 16 Nm

**Note**

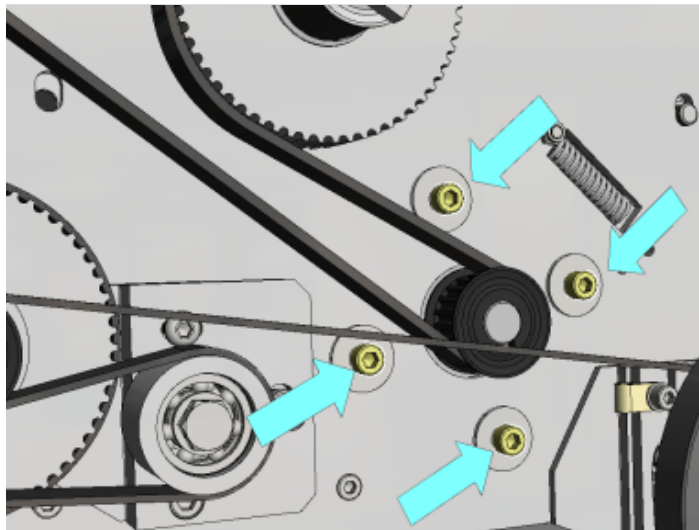
Belt tension value may increase after tightening the screws.

**Caution**

Make sure belt tension does not exceed maximum value.

**Note**

Do not forget to unblock the Lift Brake (mentioned in second step).



4. Pull up the Gripper.

Completion:

- Install AS-35021 (Sheet front)[as-35021--r5---as-35945--r5---sheet-front-.html#UUID-31b10256-172a-aa77-27f3-70611fd2f729_UUID-9b92d4e7-aba2-2c22-3c5d-0a94f0ac7d0a]
- Install AS-35205 (Sheet top SDG) / AS-35646 (Sheet Top DDG)[as-35205--sheet-top-sdg---as-35646--sheet-top-ddg-.html#UUID-2653ba5f-4e21-b730-9d1e-f6dd04791b3a_UUID-67d6d688-0828-2123-11d3-b92cb6ca4d01]