



VB DOCKLOCK

Assembling Indexing Pallets 751 601 / 753 601

1. Assemble plugs nos 751 500 or 753 502
2. Clean indexing bolts and indexing threads with petrolether
3. Assemble indexing bolts protruding by approx. 1,6 – 1,7mm
4. Adapt Air pressure amplifier no 758 801 to *Dock-Lock* cylinder
5. Unlock *Dock-Lock* – cylinder with air pressure amplifier, adjust pallet with protruding bolts on indexing grooves, lock *Dock-Lock* cylinder
6. Screwing back the indexing bolts until no torsion can be felt
Then screw in all 4 bolts right to the stop
Caution: only right to the stop, without torsion, as otherwise the pallet would get lifted
7. Now turn back the indexing bolts one by one, apply Loctite 262 or 270 as indicated as well as on the bolts as on the indexing threads. Then screw them back in till limit stop.
Note: only unscrew and treat one bolt at the time
8. Loosen pallet with air pressure amplifier and remove carefully, put aside and let dry according to Loctite instructions.
9. When dry remove all surplus Loctite
10. Check index repeating accuracy with lateral set dial gauge : < 0,01mm
11. If necessary, give light surface finish