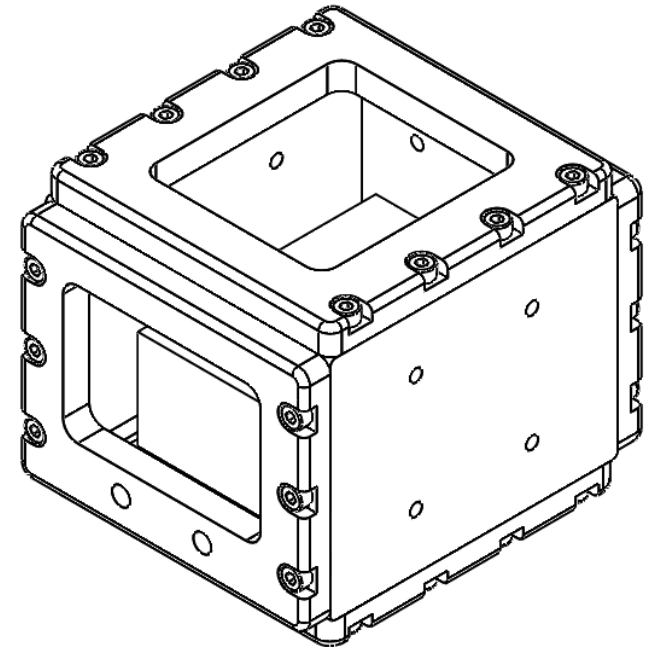


# 1.5P Vibration POD assembly instructions

Andrew Dunn



Version: 2

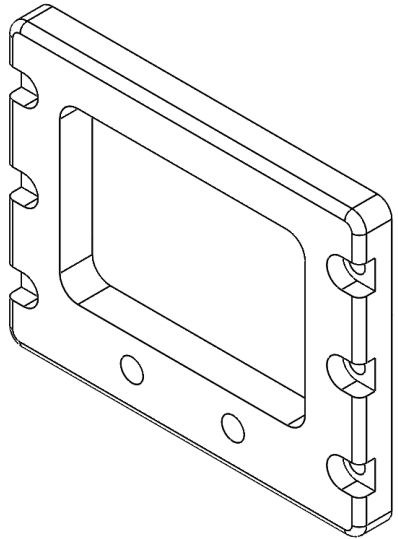
# Version

<b>Version</b>	<b>Date</b>	<b>Description</b>
V1	03/10/20	Document Created
V2	11/04/21	Updated assembly. Less screws required due to the less holes in the new design

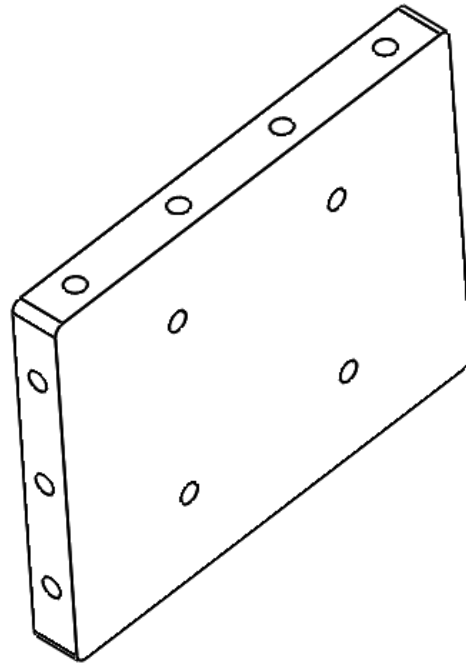
# What you need

- LOCTITE 243 thread locker (apply to each screw)
- Torque wrench
- 2 x M6 Spring plunger
- 28 x DIN912 M4 x 12mm screws
- 4 x DIN912 M4 x 20mm screws
- 8 x DIN125 M8 washers
- 8 x DIN912 M8 x 30mm screws

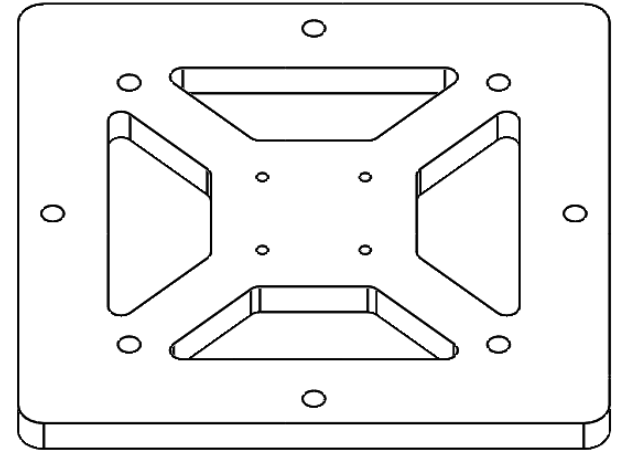
# Parts list



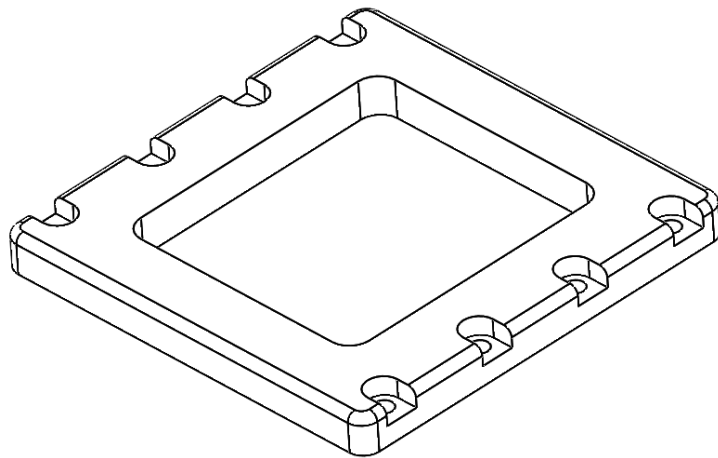
1x T065X006



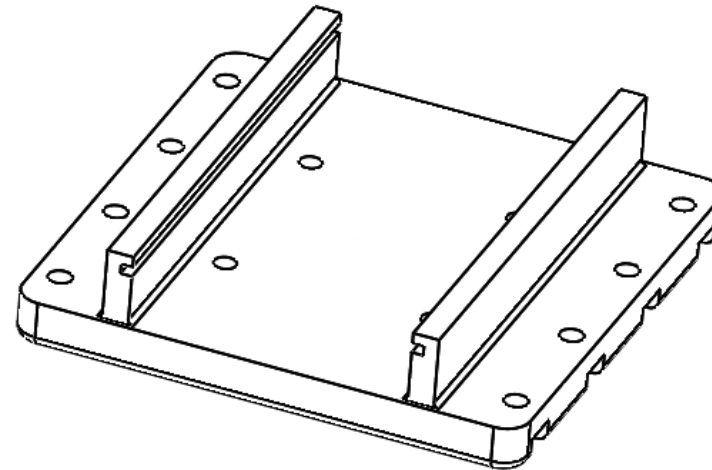
2x T065X002



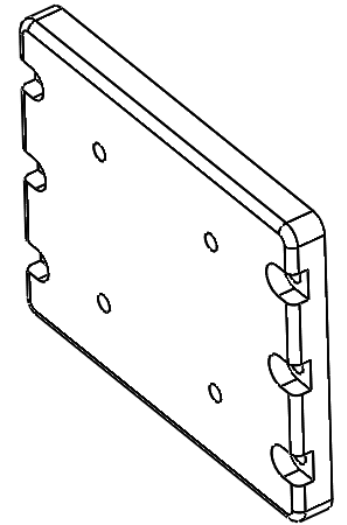
1x T062X001



1x T065X005

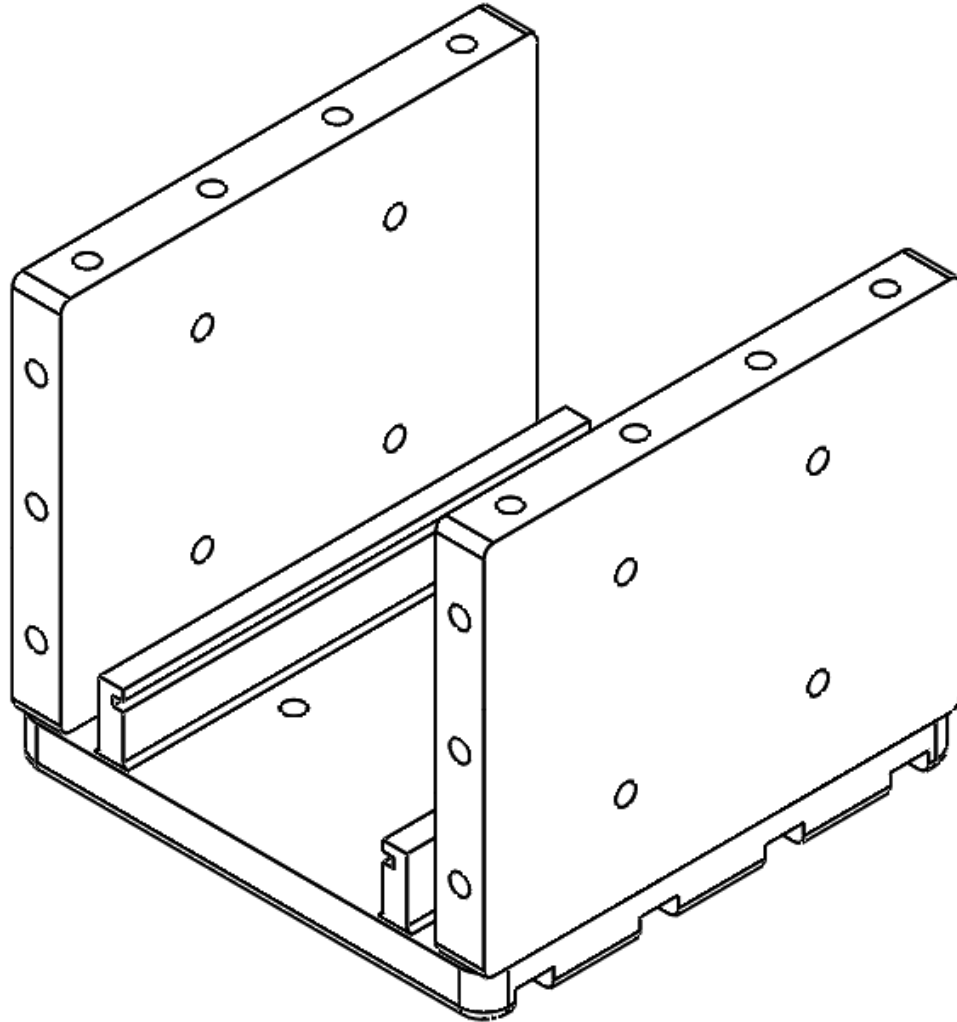


1x T065X003



1x T065X004

STEP 1: Place both T065X002 onto T065X003

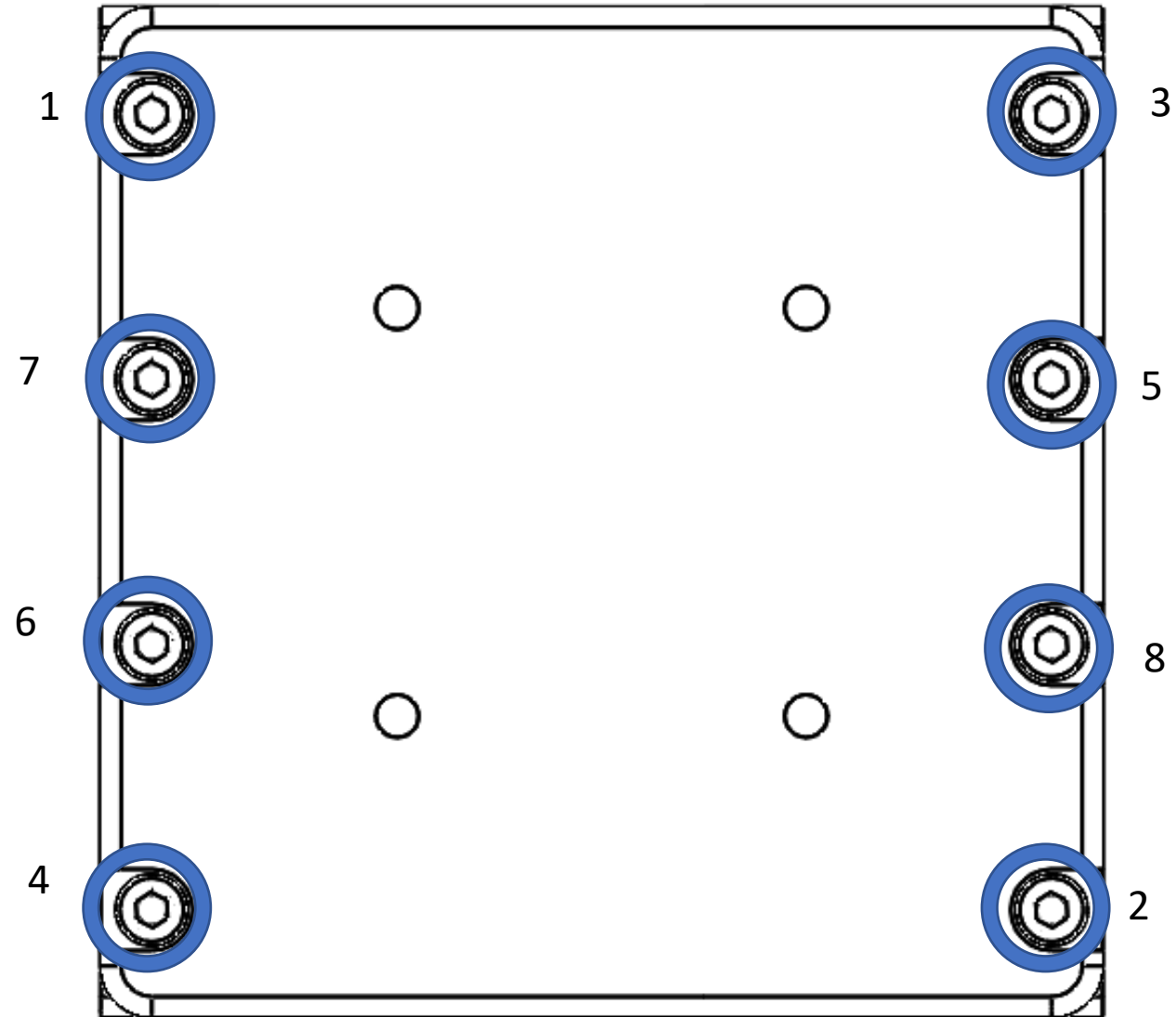


# STEP 2: Place M4 bolts into T065X003

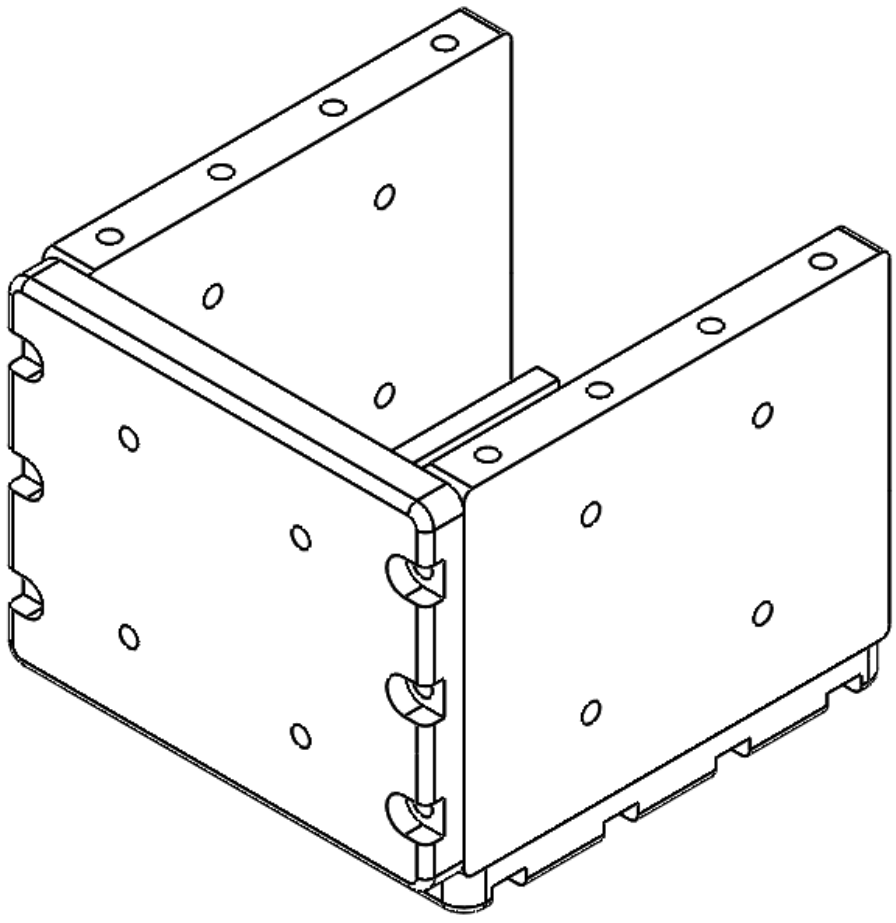
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 8x DIN912 M4 x 12mm screws.



# STEP 3: Attach T065X004

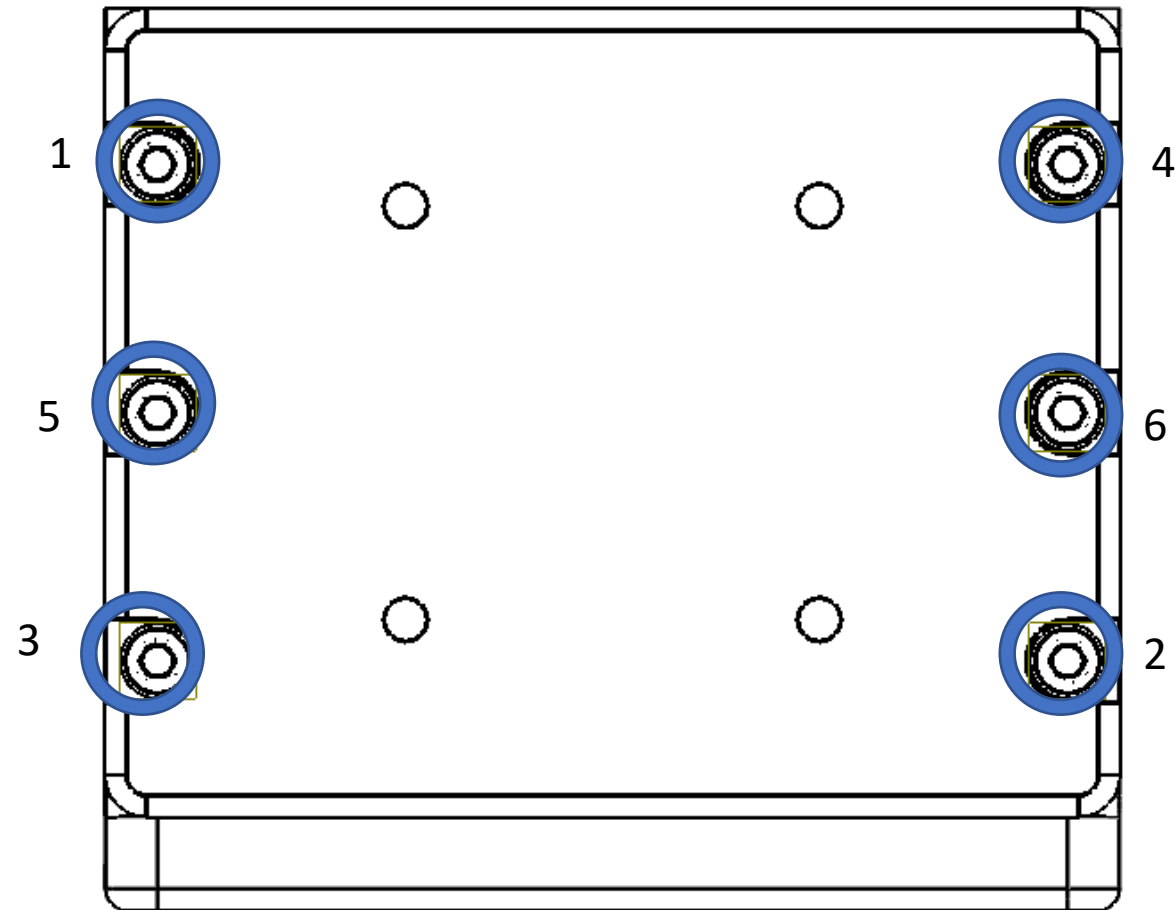


# STEP 4: Place M4 bolts into T065X004

- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

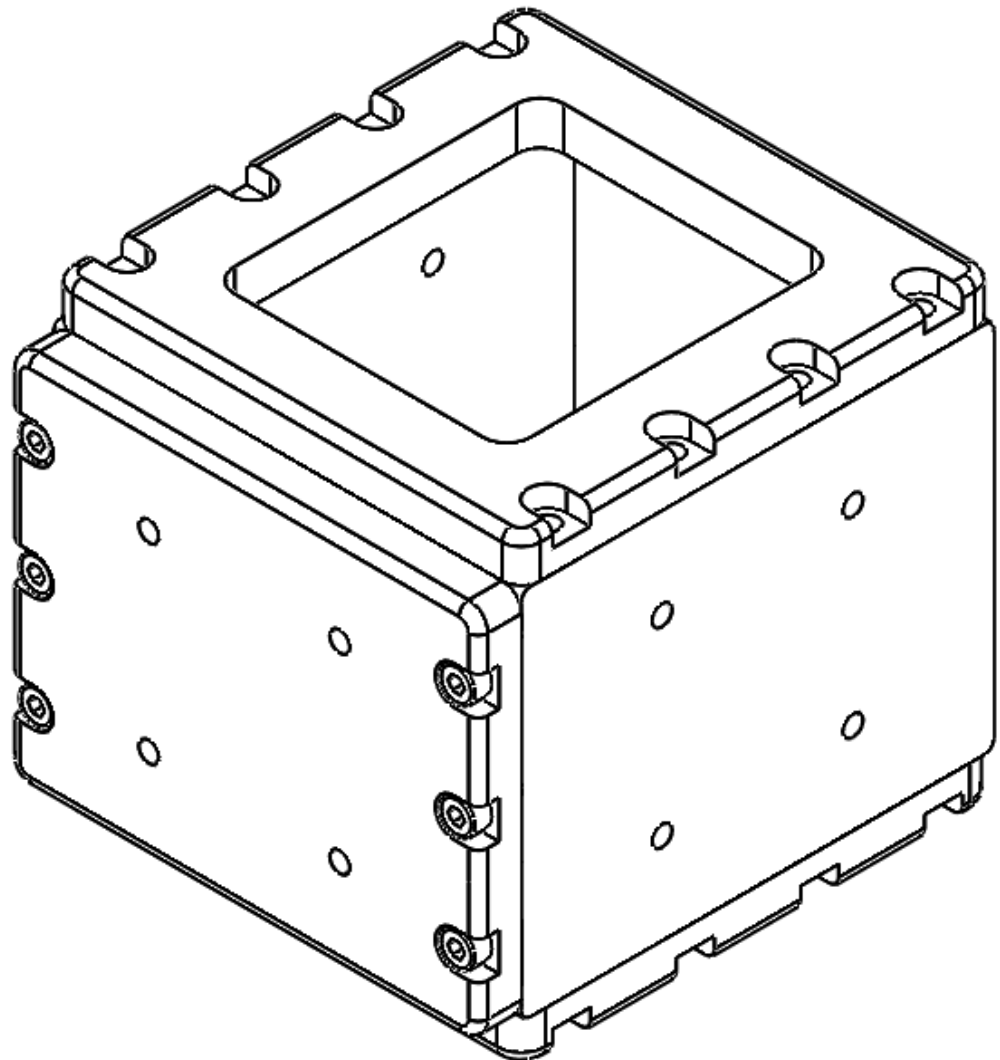
Items needed:

- 6x DIN912 M4 x 12mm screws.





# STEP 5: Attach T065X005

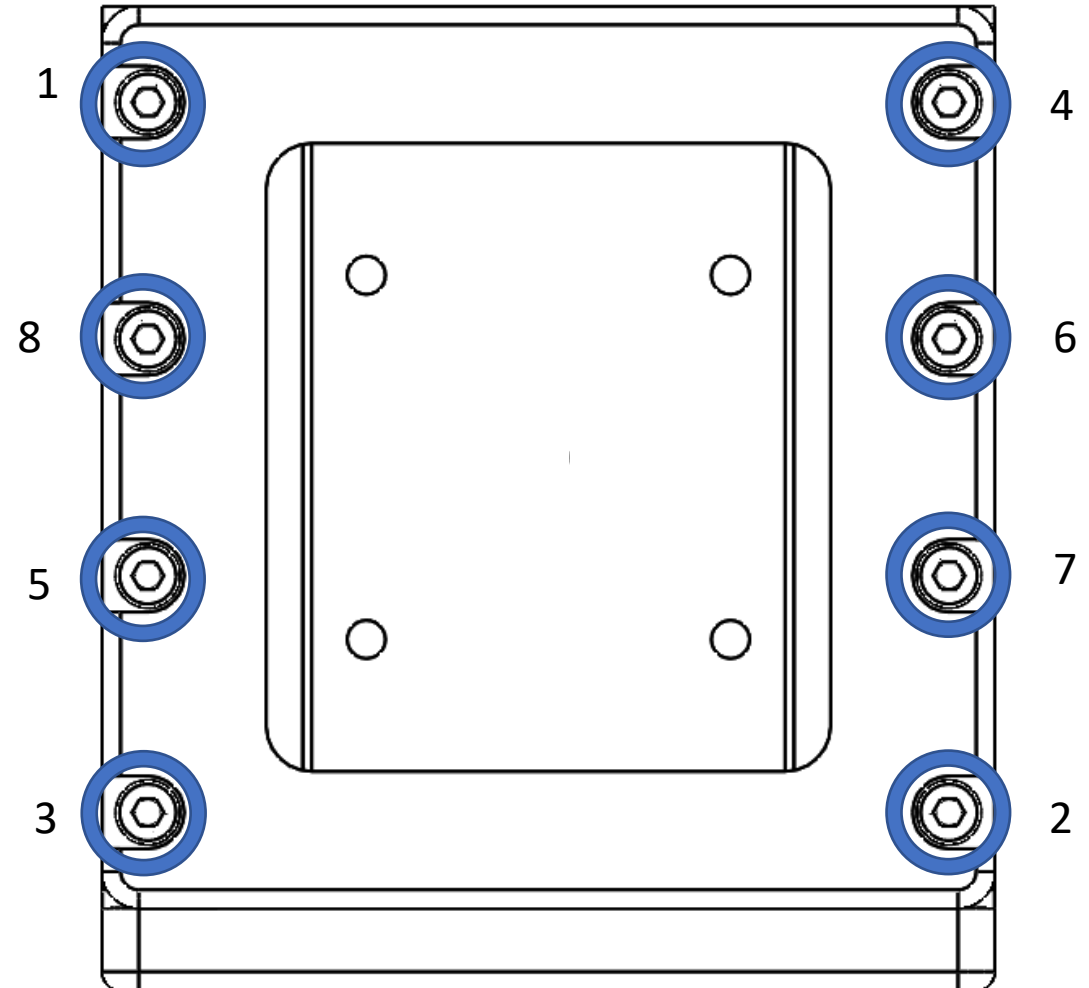


# STEP 6: Place M4 bolts into T065X005

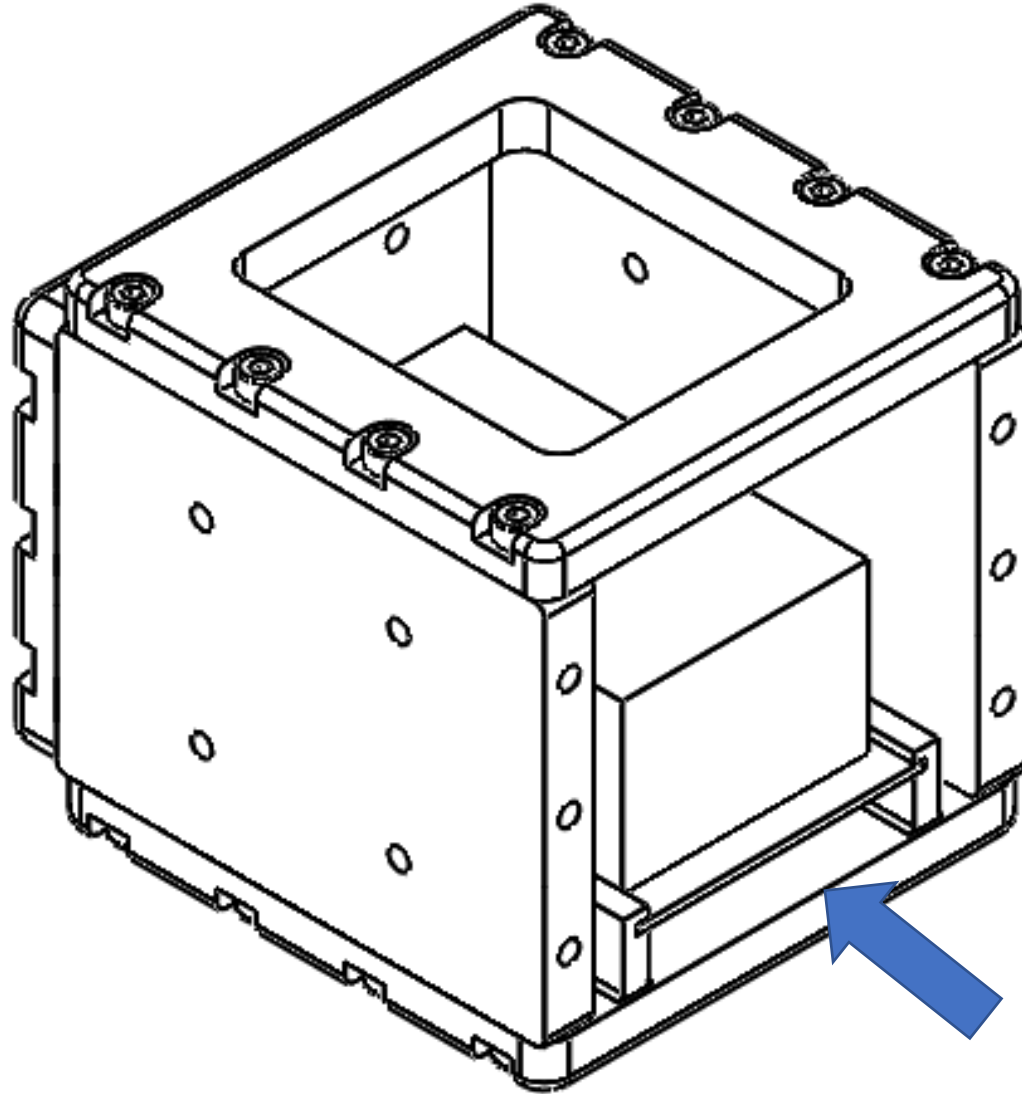
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

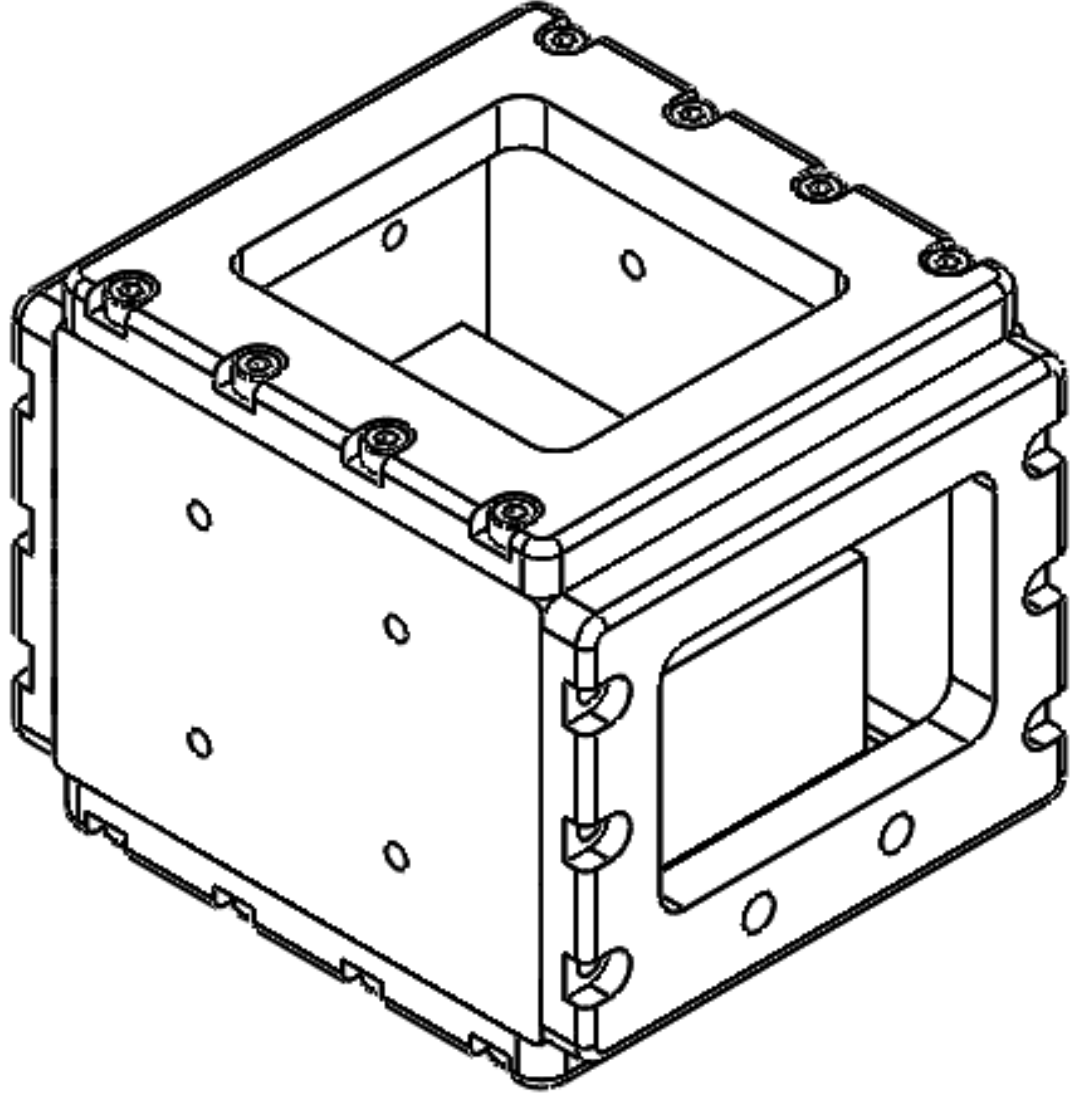
- 8x DIN912 M4 x 12mm screws.



STEP 7: Insert PQ into the POD



STEP 8: Attach T065X006

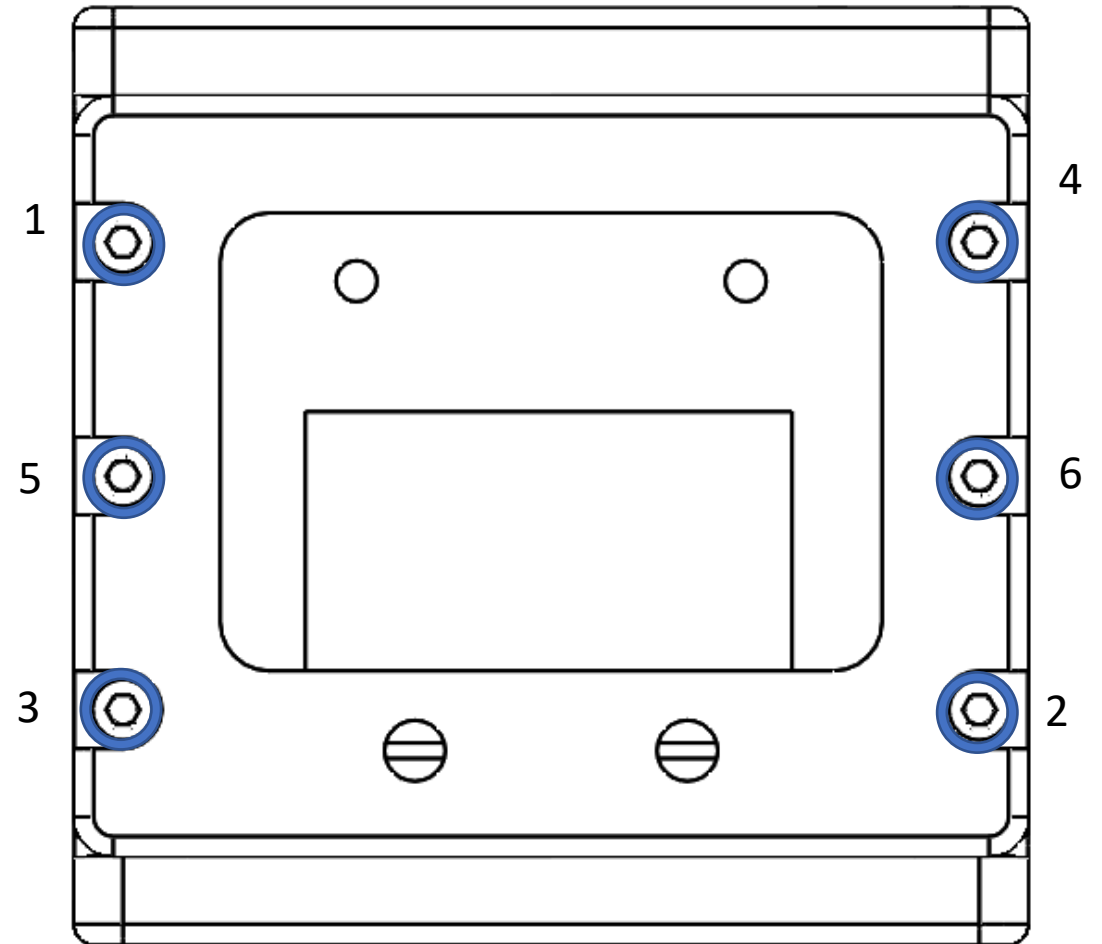


# STEP 9: Place M4 bolts into T065X006

- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 6x DIN912 M4 x 12mm screws.



# STEP 10: Attach Spring plungers

- Insert m6 spring plungers into the M6 holes in the end plate. You can fine tune the preload of the springs by changing the depth of the screws in the hole.

Items needed:

- 2x M6 spring plunger.

Note:

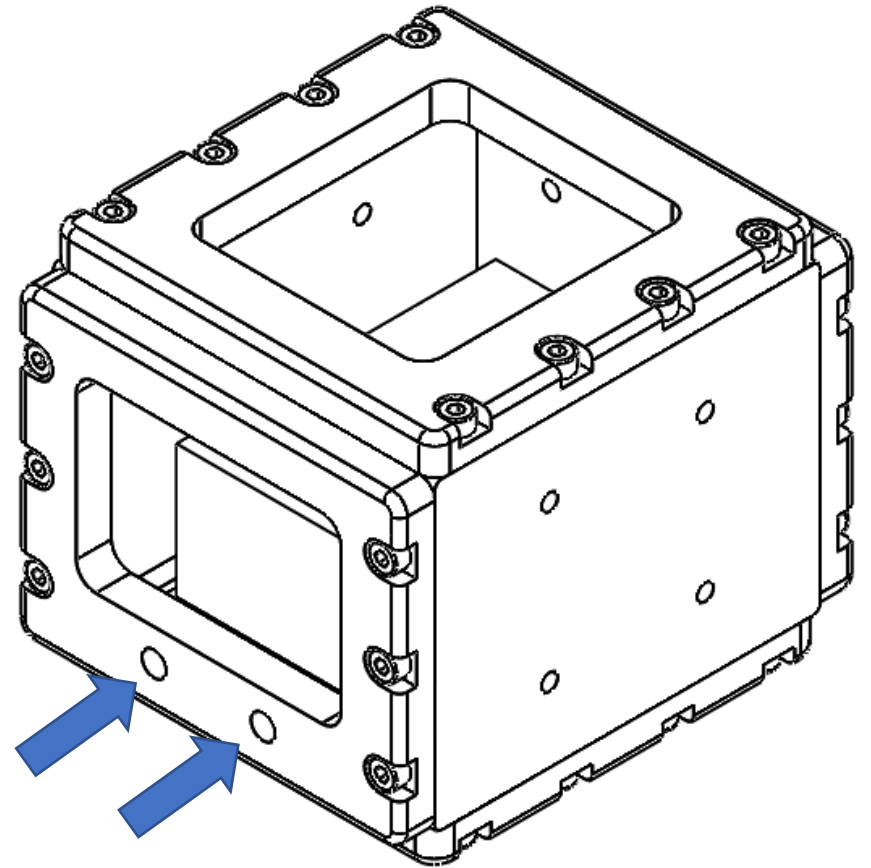
Recommended spring plungers

Misumi: SPRZ6

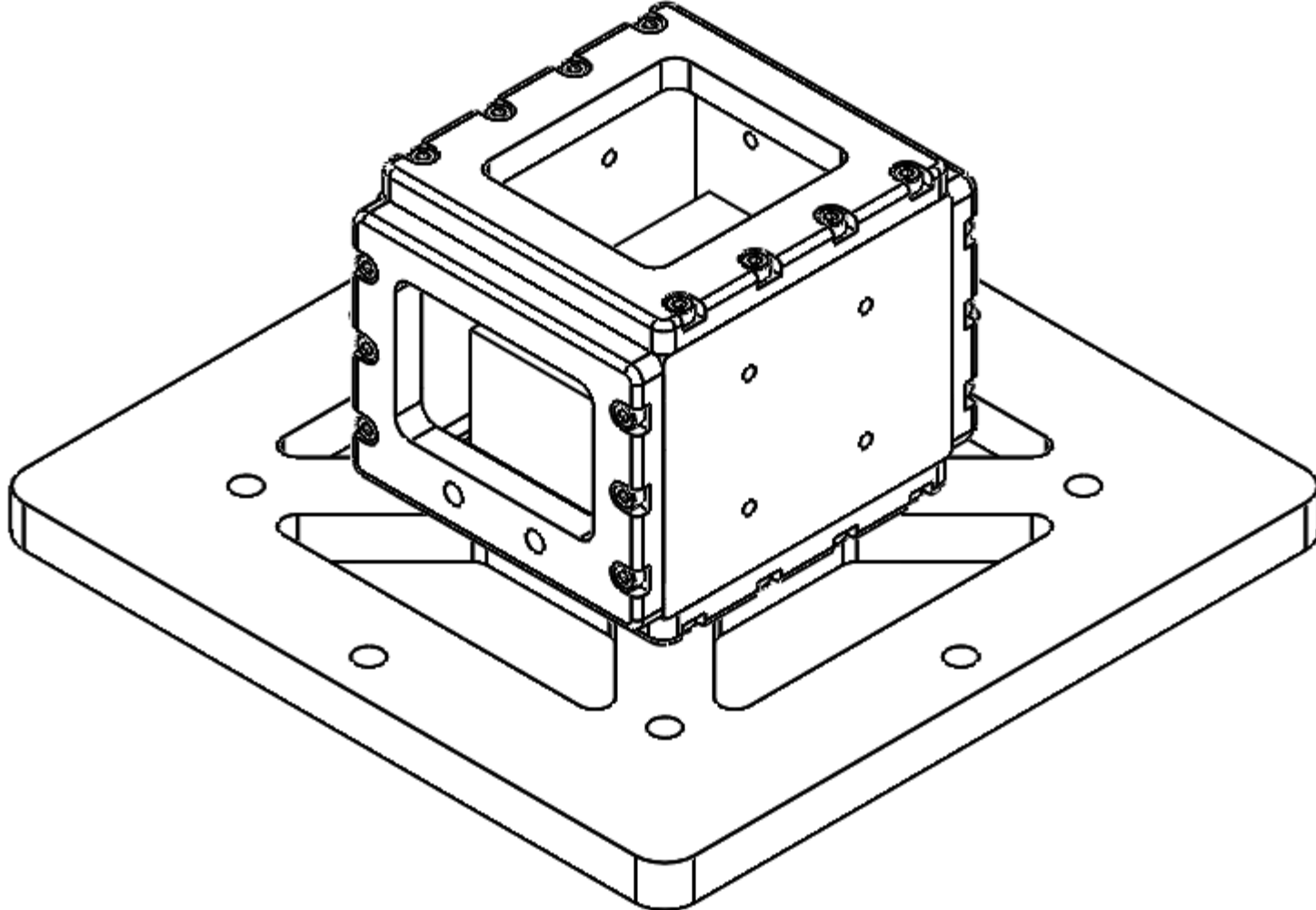
<https://uk.misumi-ec.com/vona2/detail/110300143710/>

RS Components

<https://es.rs-online.com/web/p/products/0478927/>



# STEP 11: Attach T065X008

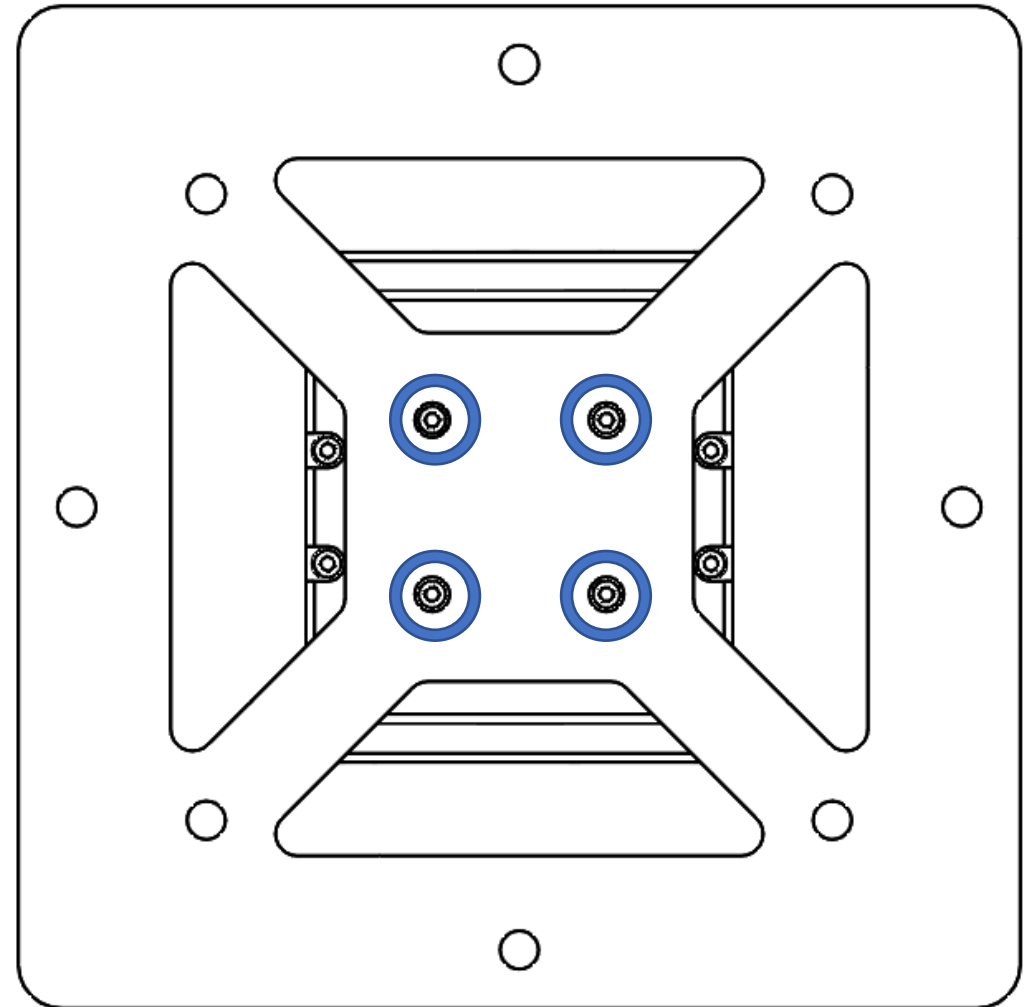


# STEP 12: Place M4 bolts into T065X008

- Insert and hand tighten torque each M4 x 20mm.
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 4x DIN912 M4 x 20mm screws.



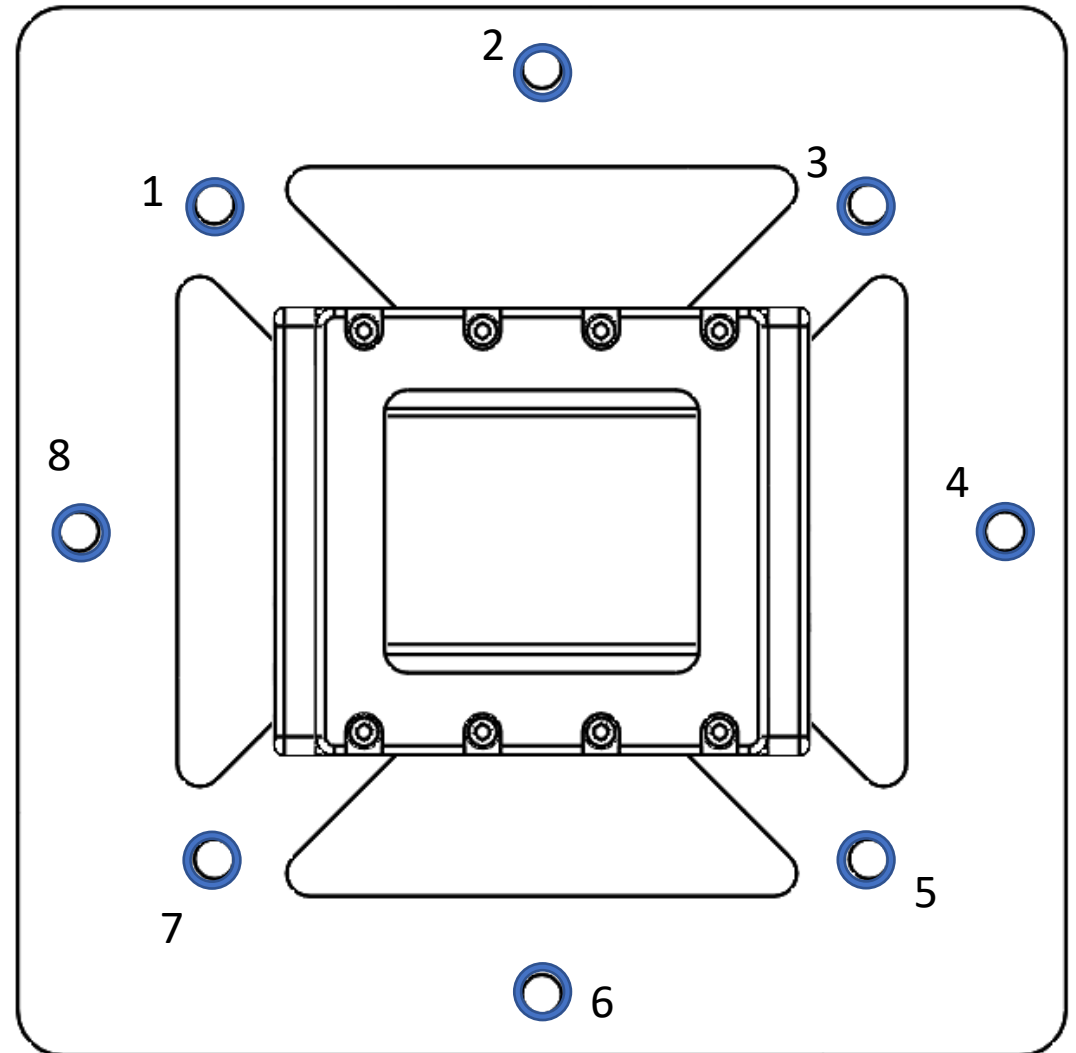


# STEP 13: Secure 1.5P VibePOD to vibrating table

- Insert and hand tighten torque each M8 x 30m.
- Once each screw is inserted tighten each screw to 35.6Nm

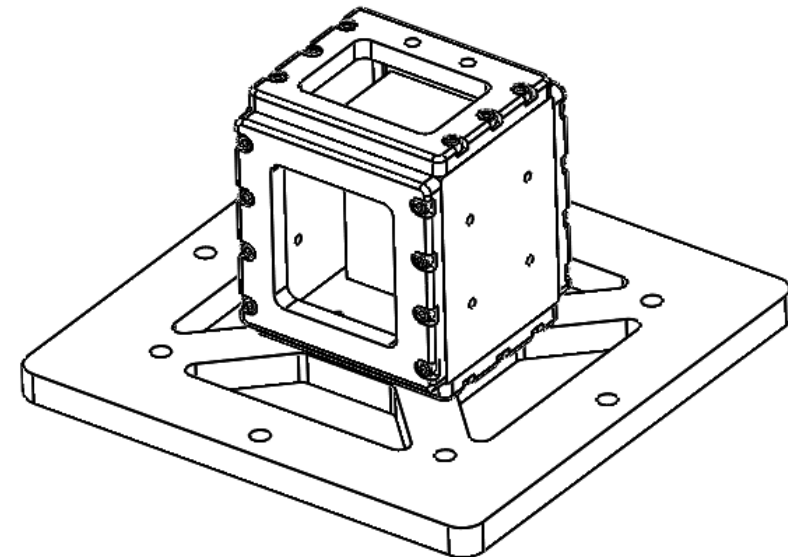
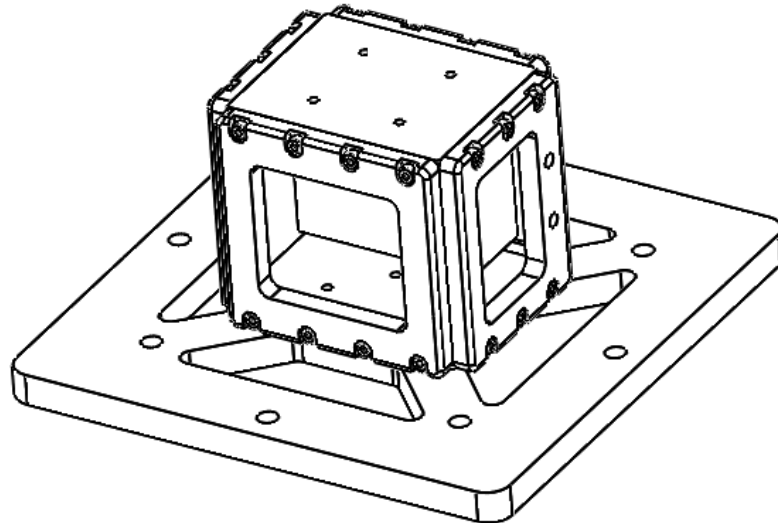
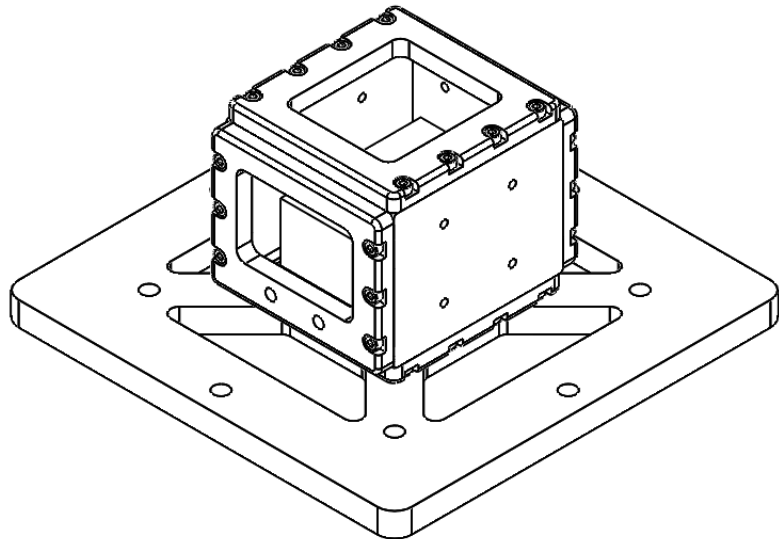
Items needed:

- 8x DIN912 M8 x 30mm screws.
- 8 x DIN125 M8 washers



# STEP 14: Reorientation of VibePOD

- To test the VibePOD in another axis.
- Disconnect the adapter plate.
- Disconnect the VibePOD from the adapter plate.
- Flip the VibePOD to the new orientation.
- Follow Steps 11 – 13.



# Contact details

- Get in touch if you need assistance with qualifying your pocketcube.
- Follow me on Twitter: @Spac3C4d3t
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- Website: <https://wyrmeengineering.com/>
- Email: Andrew.dunn@wyrmeengineering.com

