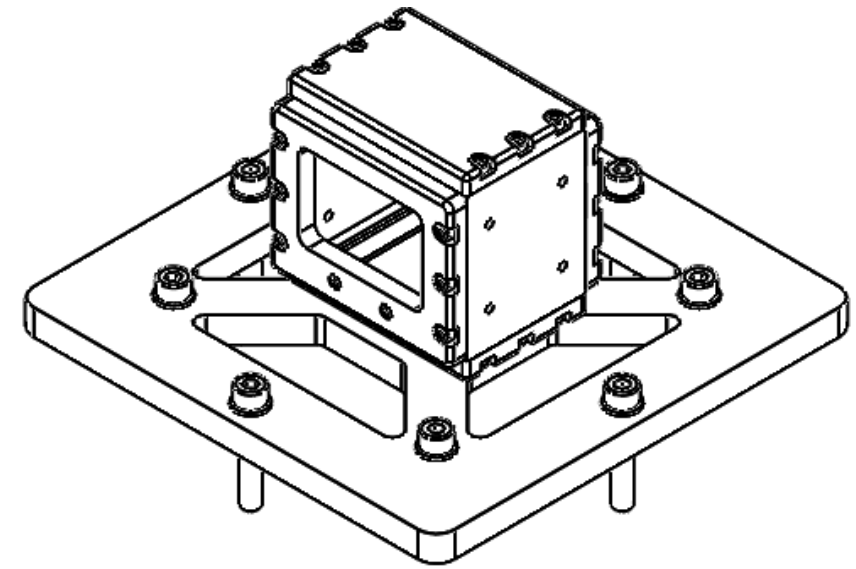


1P Vibration POD assembly instructions

Andrew Dunn



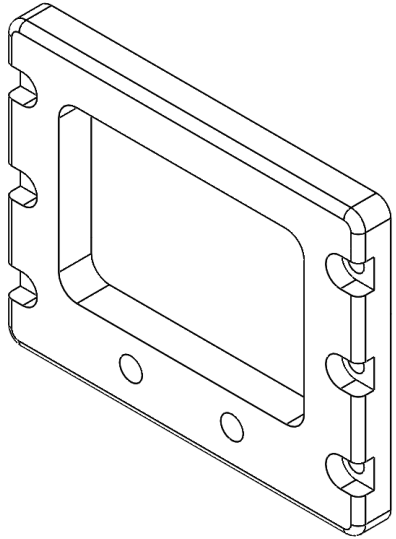
Version

Version	Date	Description
V1	10/12/19	Document Created
V2	06/05/20	Updated instructions based on new design
V3	17/07/20	Updated instructions based on new design
V4	11/04/21	Updated instructions new adapter plate

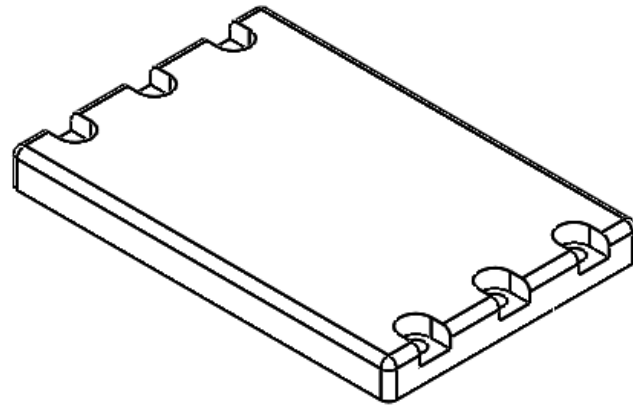
What you need

- LOCTITE 243 thread locker (apply to each screw)
- Torque wrench
- 2 x M6 Spring plunger
- 24 x DIN912 M4 x 12mm screws
- 4 x DIN912 M4 x 20mm screws
- 8 x DIN6903-A4 M8 washers
- 8 x DIN912 M8 x 50mm screws

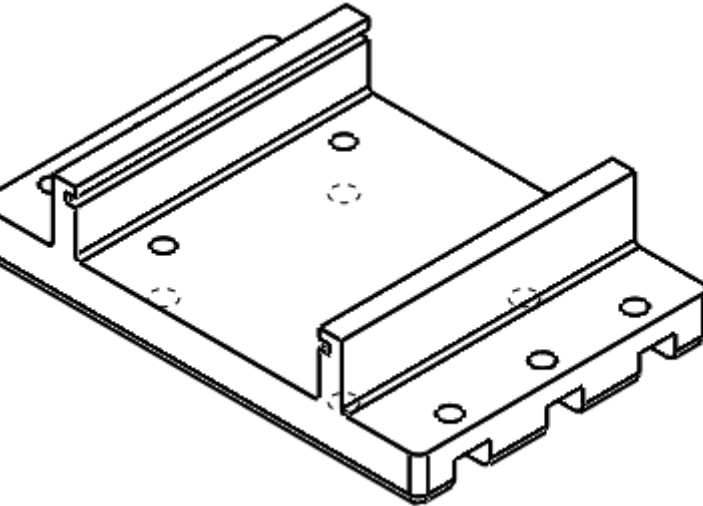
Parts list



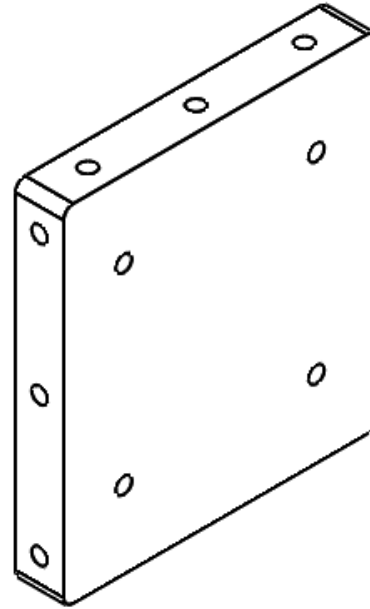
1x T065X006



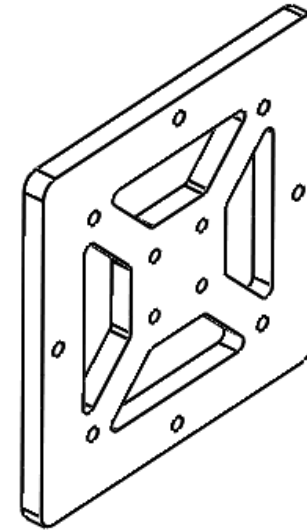
1x T062X006



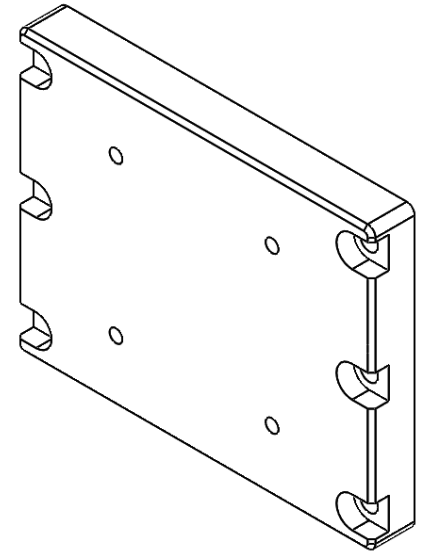
1x T062X005



2x T062X002

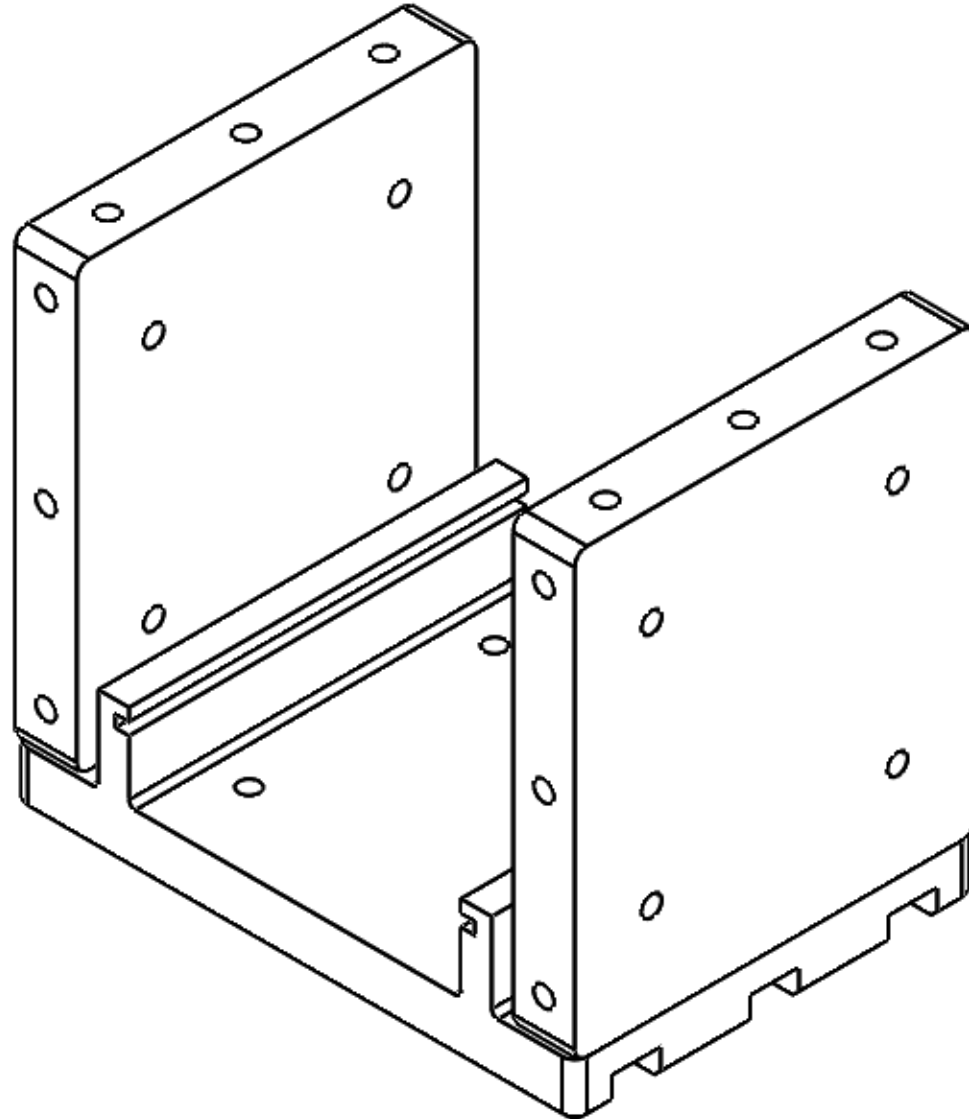


1x T065X008



1x T065X004

STEP 1: Place both T062X002 onto T062X005

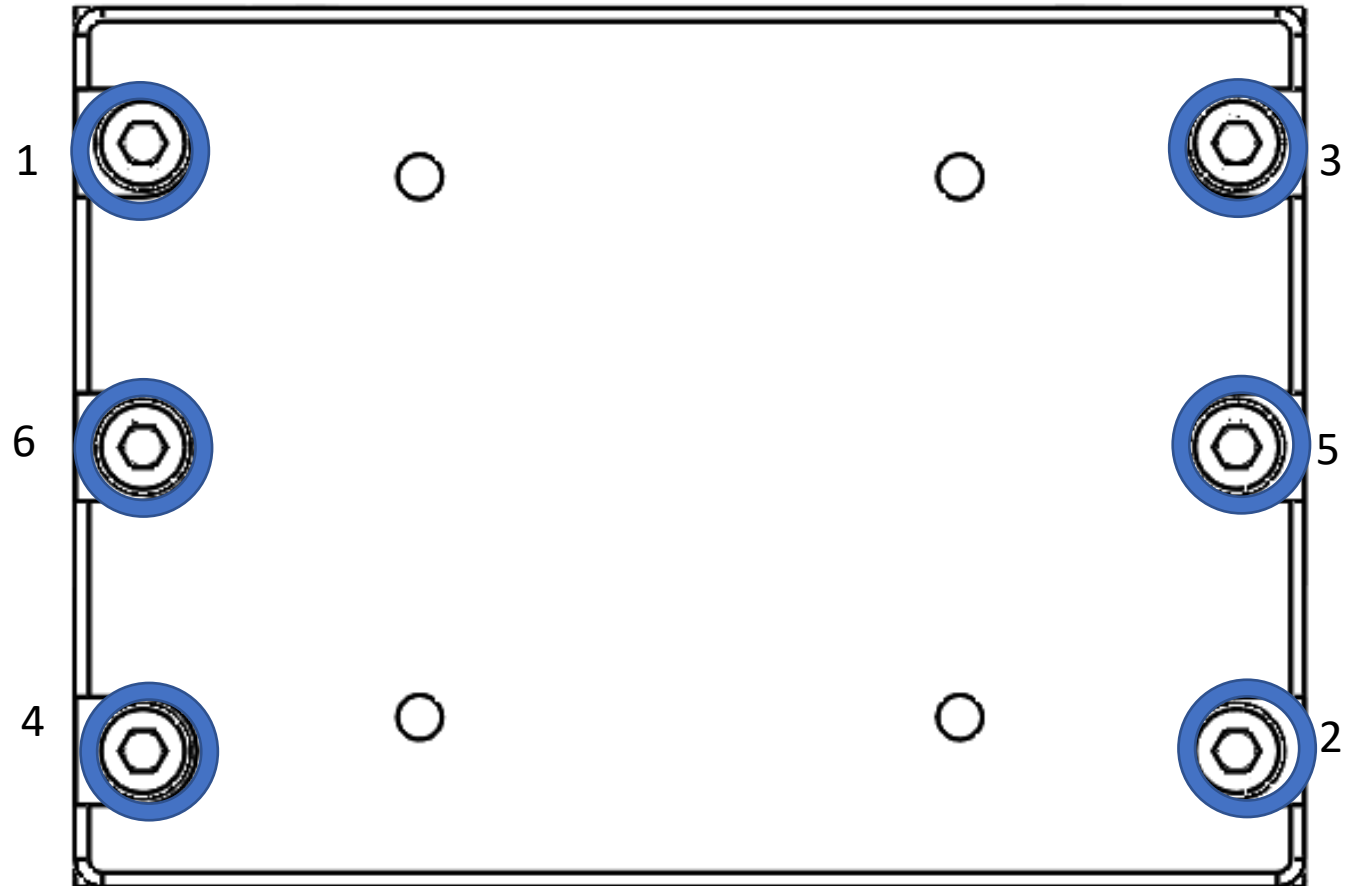


STEP 2: Place M4 bolts into T062X005

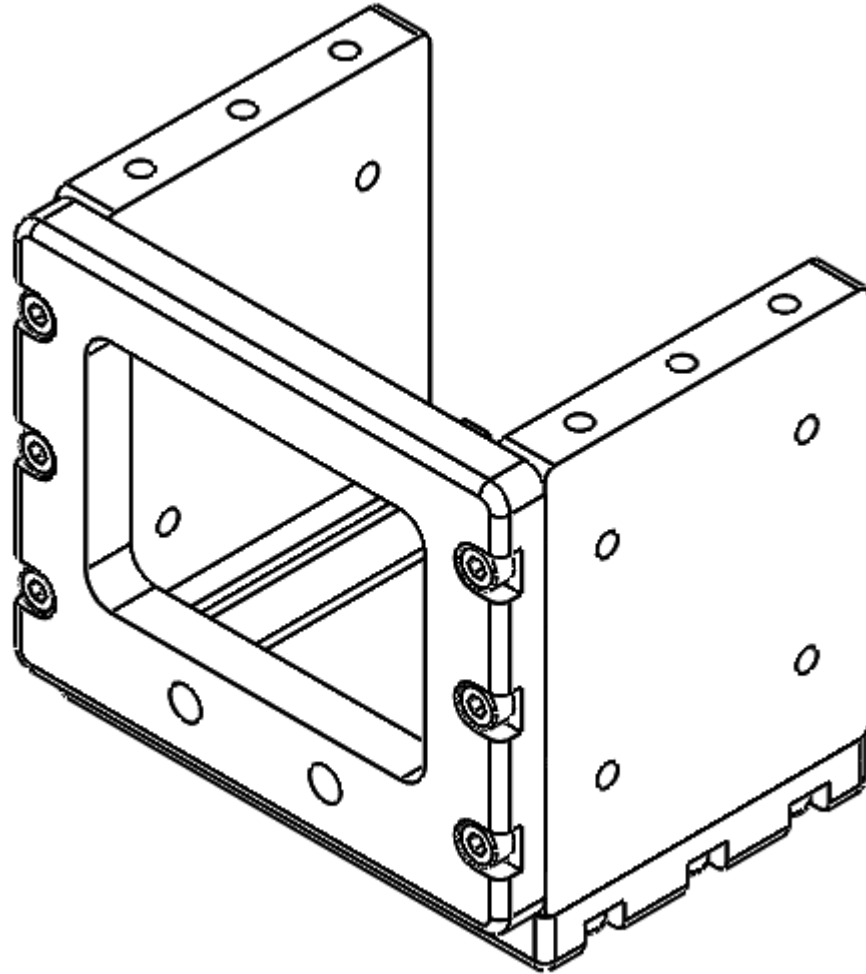
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 6x DIN912 M4 x 12mm screws.



STEP 3: Attach T065X006

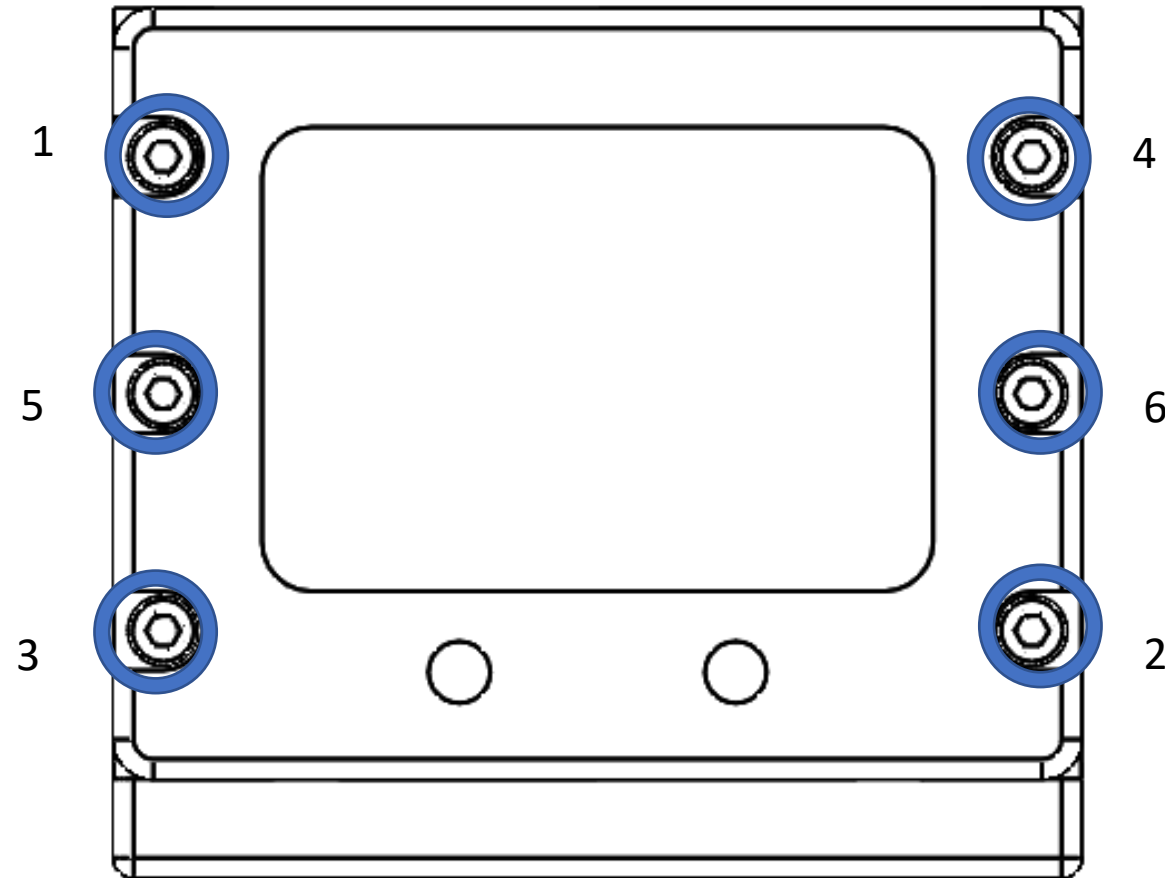


STEP 4: Place M4 bolts into T065X006

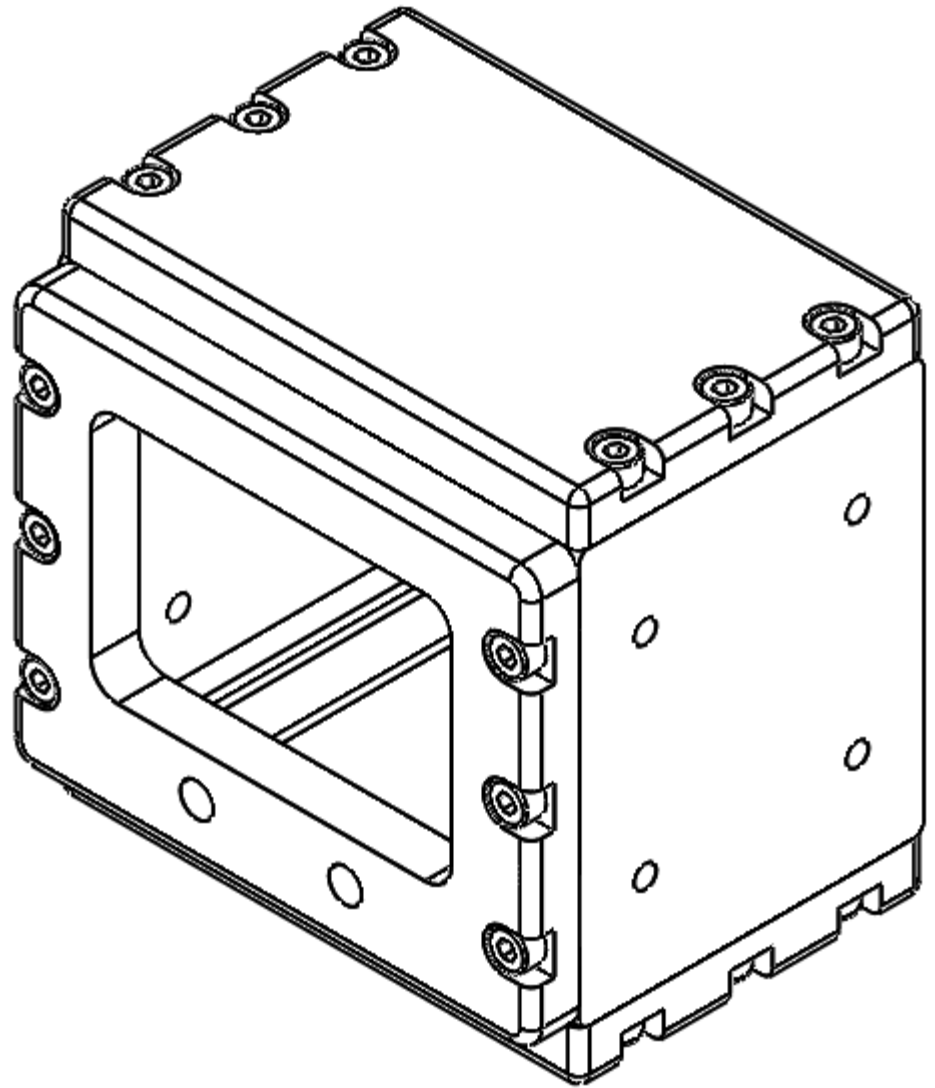
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 6x DIN912 M4 x 12mm screws.



STEP 5: Attach T062X006

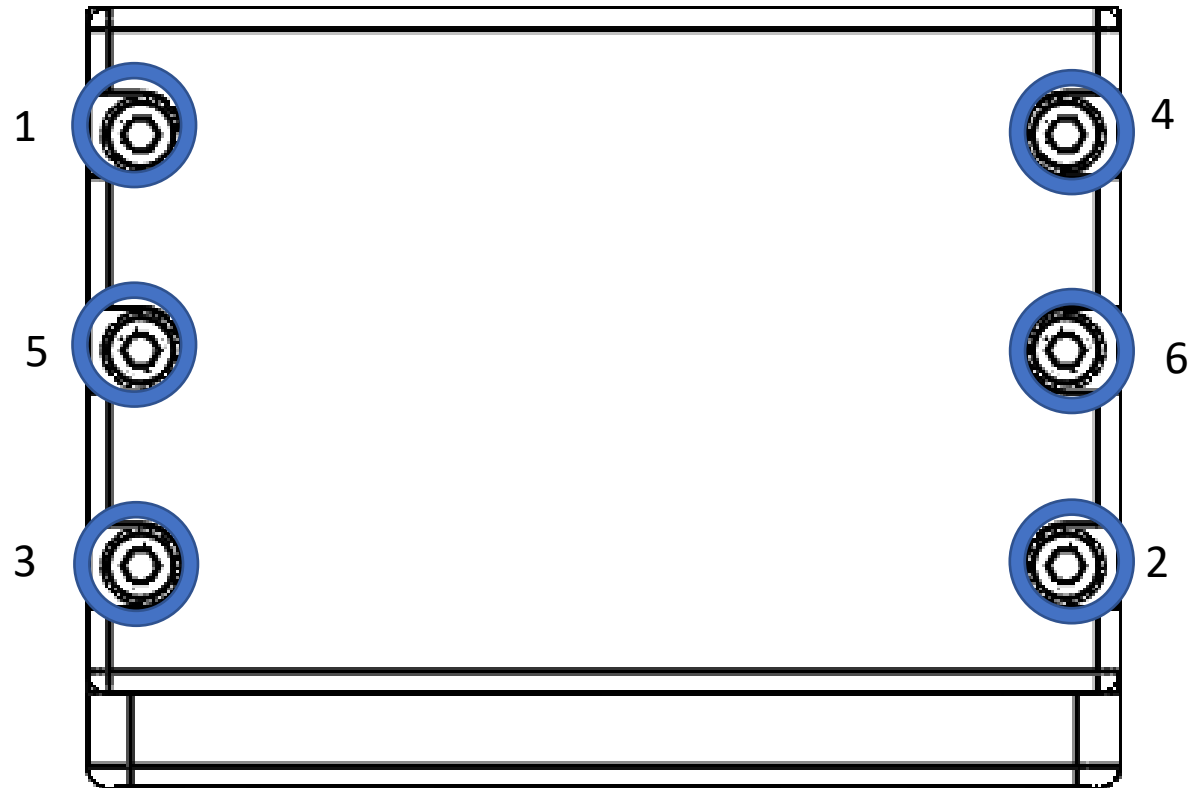


STEP 6: Place M4 bolts into T062X006

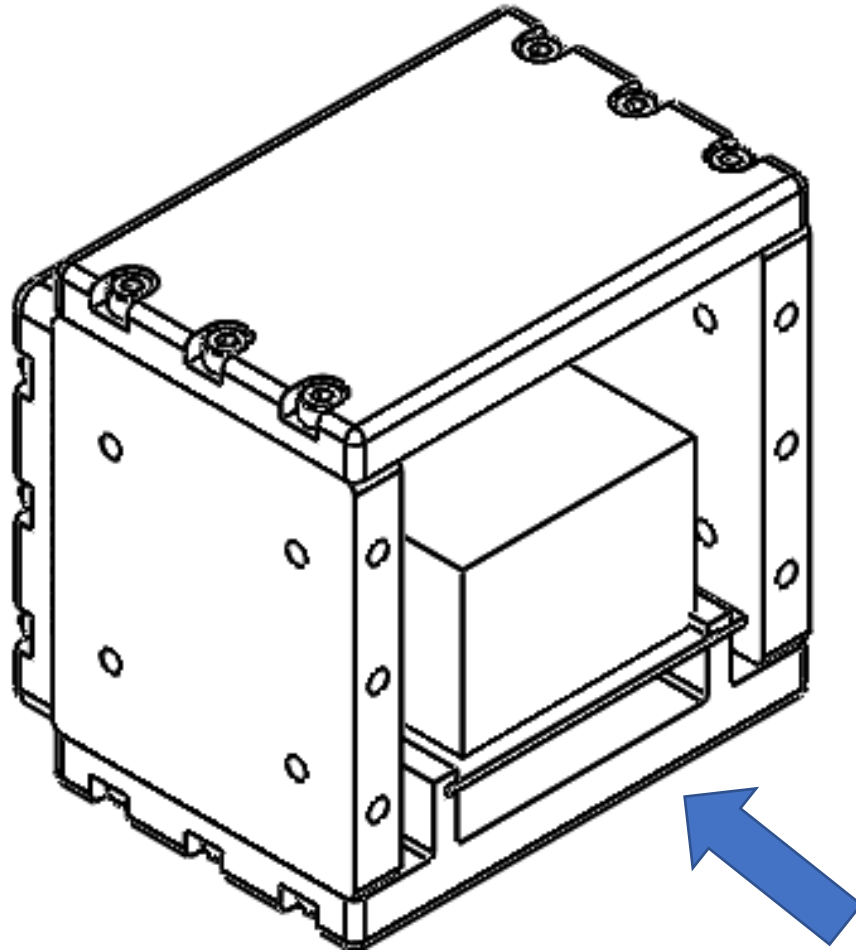
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

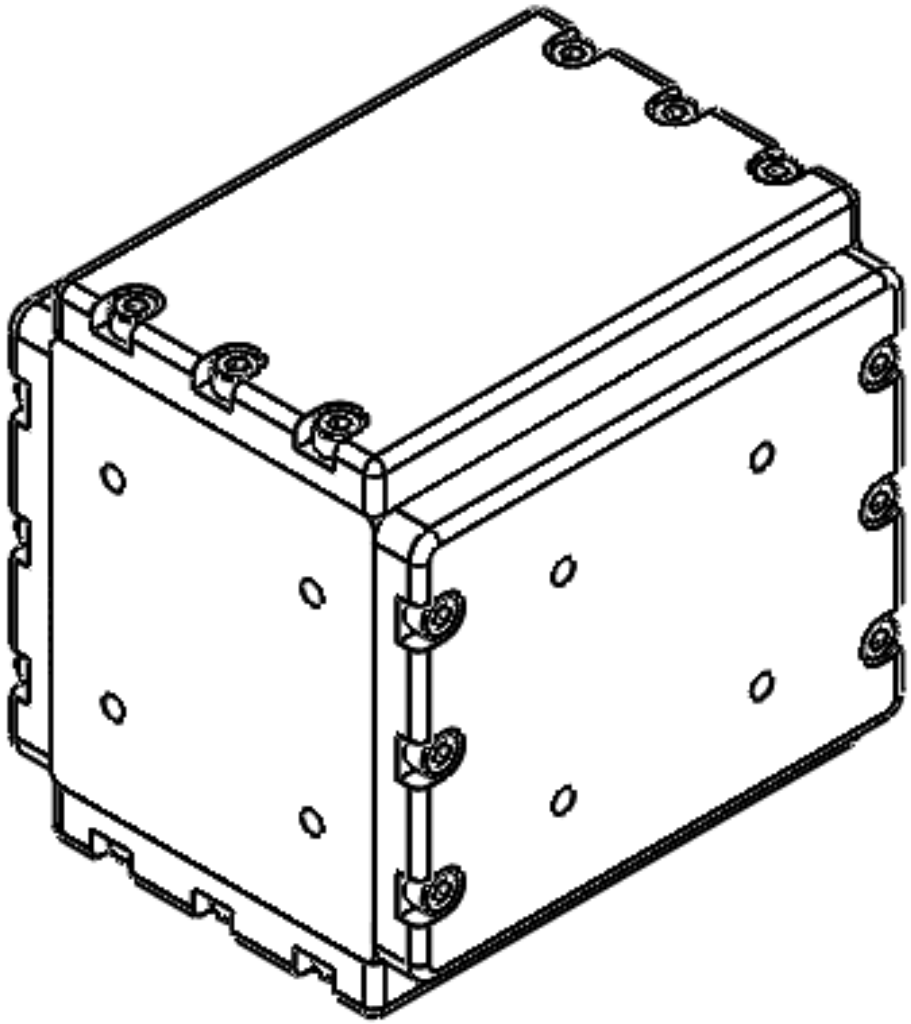
- 6x DIN912 M4 x 12mm screws.



STEP 7: Insert PQ into the POD



STEP 8: Attach T065X004

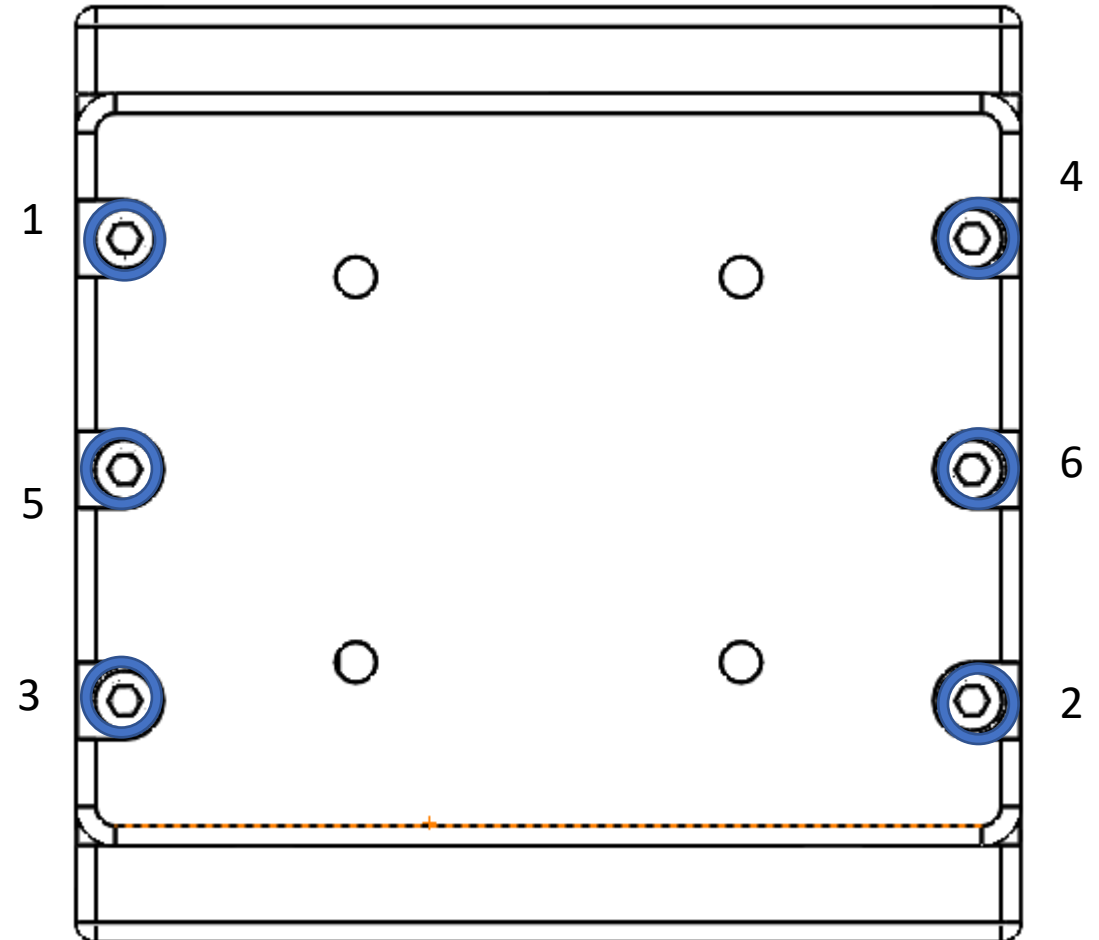


STEP 9: Place M4 bolts into T065X004

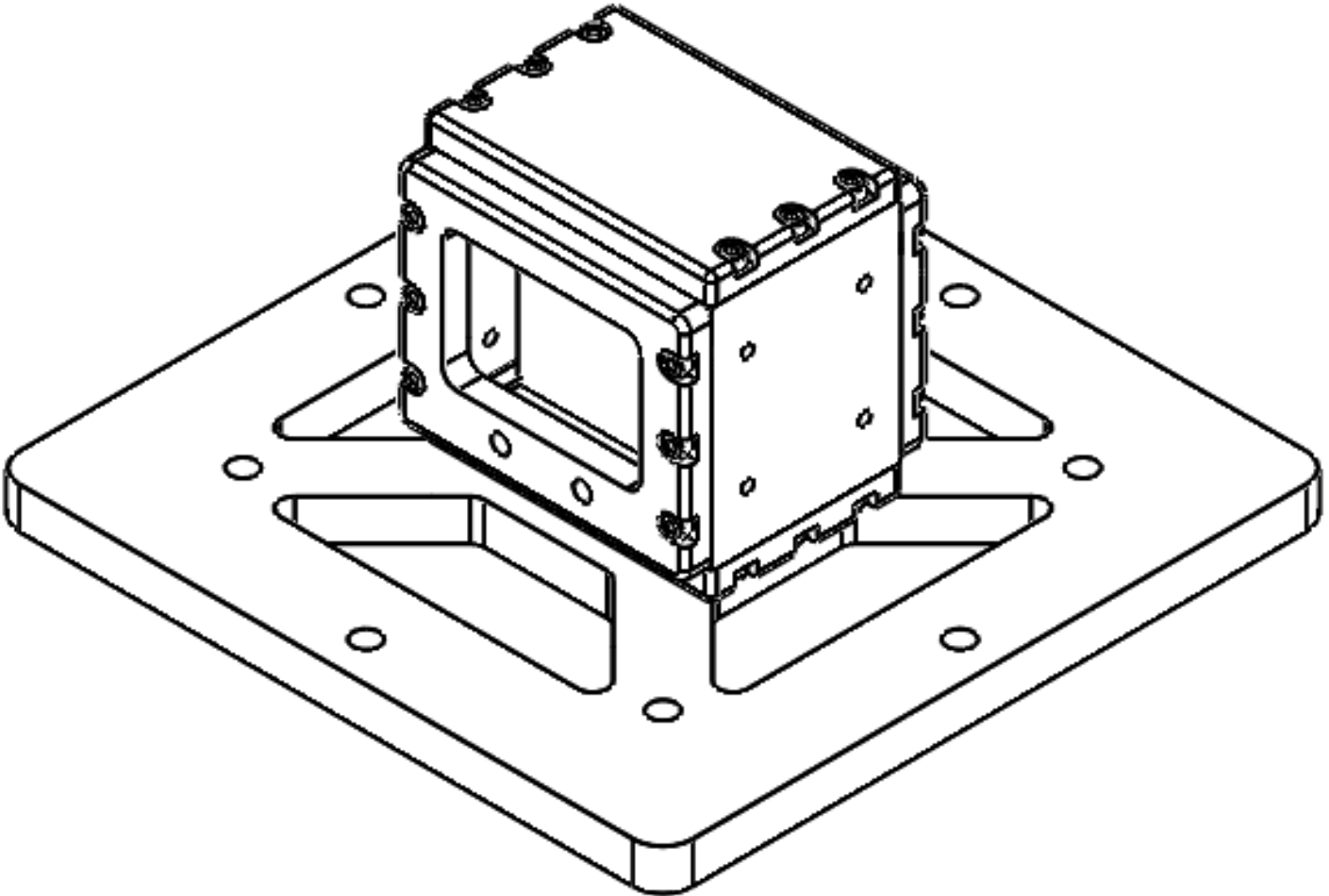
- Insert and hand tighten torque each M4 x 12mm to the highlighted order
- Once each screw is inserted tighten each screw to 4.8Nm

Items needed:

- 6x DIN912 M4 x 12mm screws.



STEP 10: Attach T065X008

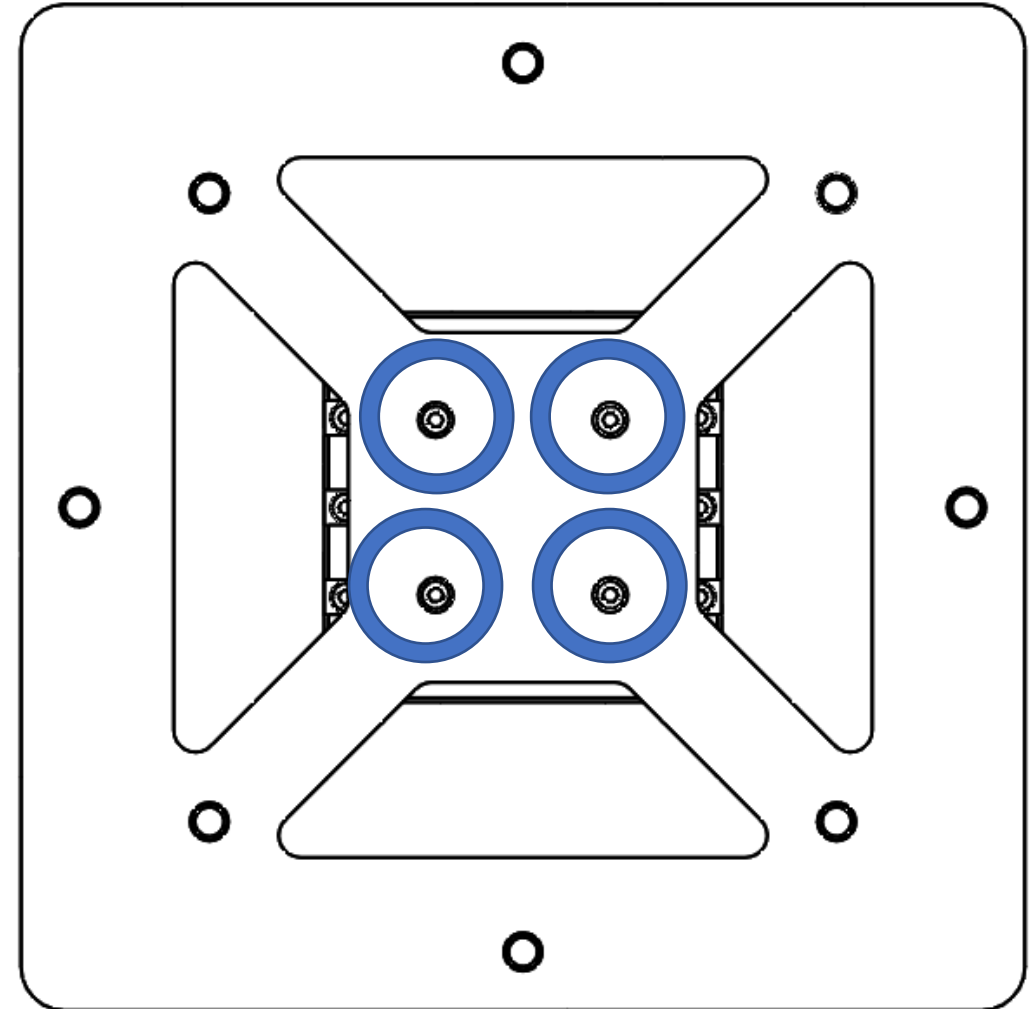


STEP 11: Place M4 bolts into T065X008

- 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 12: Attach Spring plungers

- Insert m6 spring plungers into the M6 holes in the end plate.
- If you are using spring loaded grub screws you can fine tune the preload by changing the depth of the screw in the hole

Items needed:

- 2x M6 spring plunger.

Note:

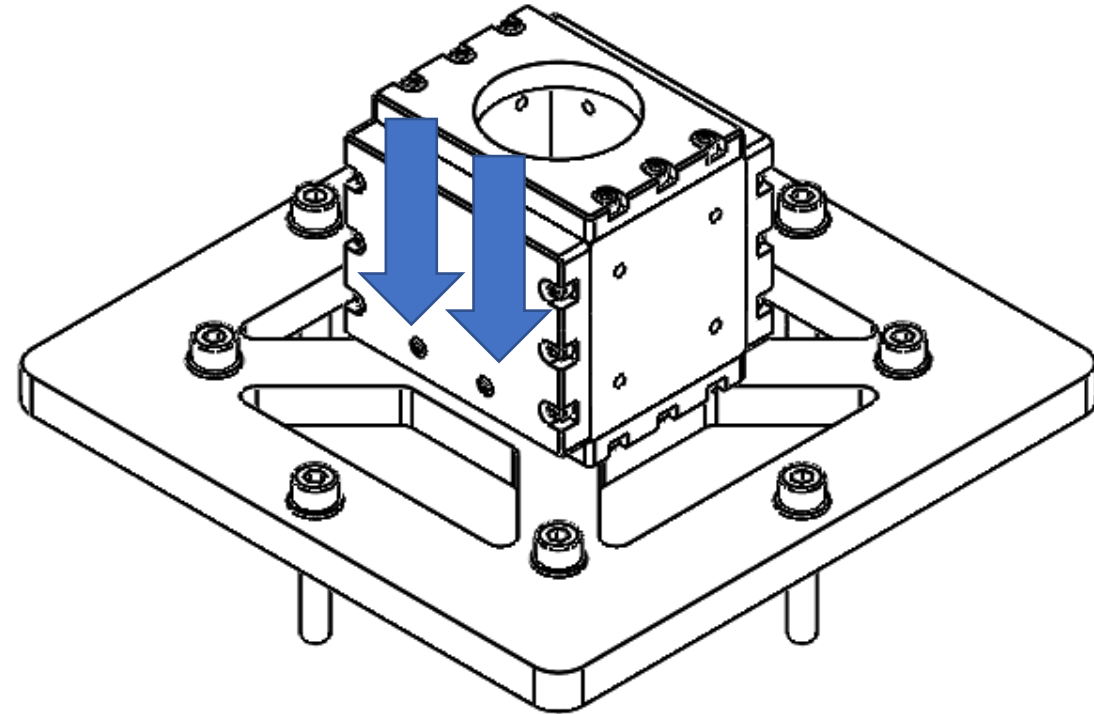
Recommended spring plungers

Misumi: SPRZ6

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

WDS: 842-206

<https://www.wdscomponents.com/en-gb/stainless-steel-spring-plunger-with-hexagon-head-metric-wds-842/c-575/p-1700/v-12812>

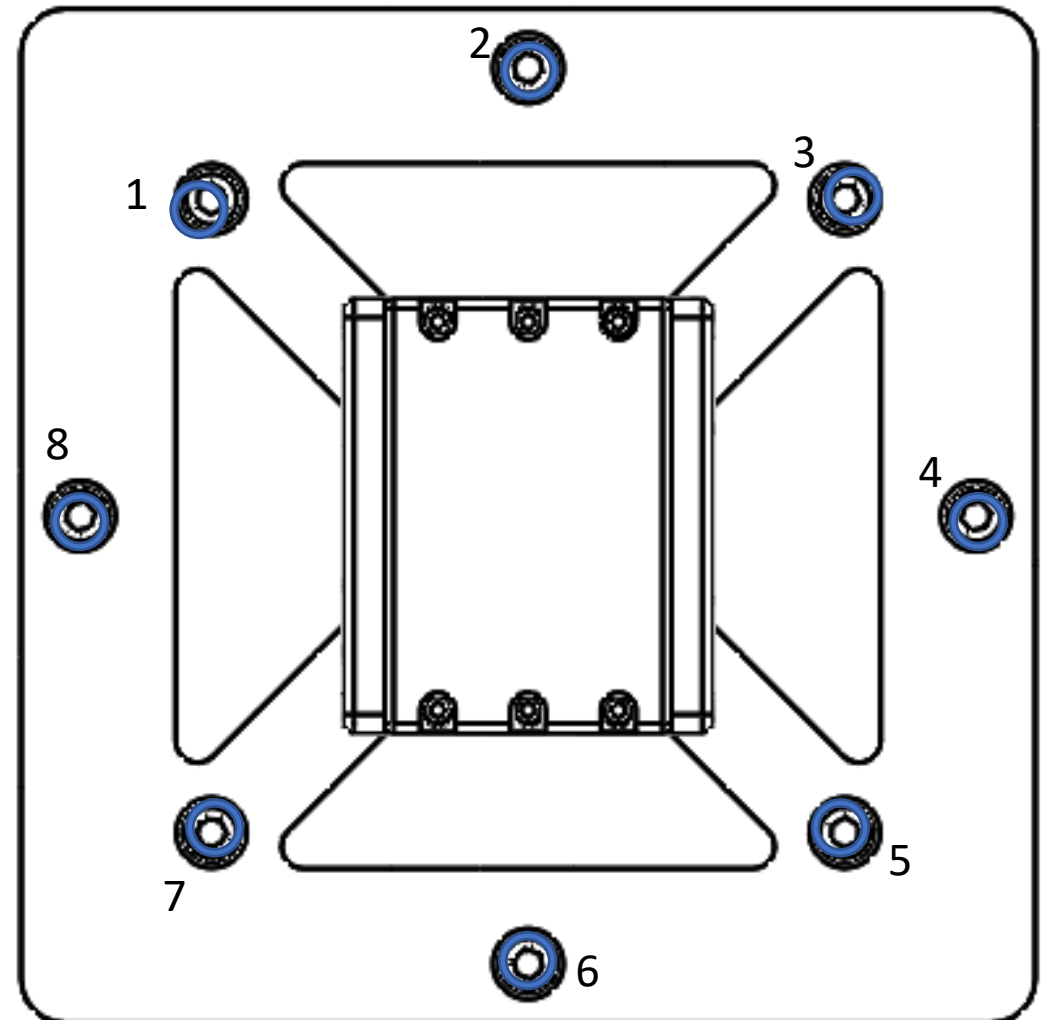


STEP 13: Secure 1P VibePOD to vibrating table

- Insert and hand tighten torque each M8 x 50m.
- Once each screw is inserted tighten each screw to 35.6Nm

Items needed:

- 8x DIN912 M8 x 50mm screws.
- 8x M8 Washers



Contact details

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

