

HPMA/HPPA unassembled arm assembly instructions



Please ensure that the V seals are fitted in their correct position, as shown in the images above.

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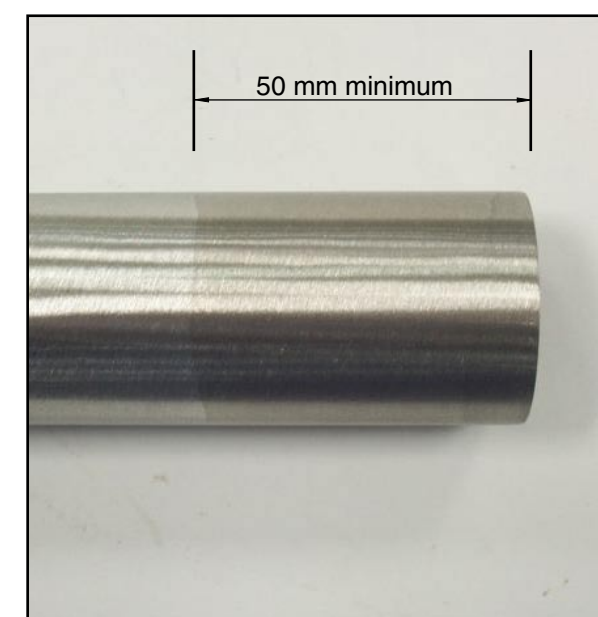


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For handling and general information on the adhesive and the activator used in this document, please refer to the respective LOCTITE® product data sheet.

Ensure that both ends of the tube, inside and out, are deburred and degreased with Isopropol alcohol or an equivalent. Activate both ends of the tube with LOCTITE® 7649, inside and out, a minimum distance of 50 mm.





Inject 3.5 ml of LOCTITE® 326 evenly into the base of the cavity between the hub bore and the glue shield as shown in the image above.



Inject 3.0 ml of LOCTITE® 326 evenly into the base of the cavity between the probe holder bore and the glue shield as shown in the image above.

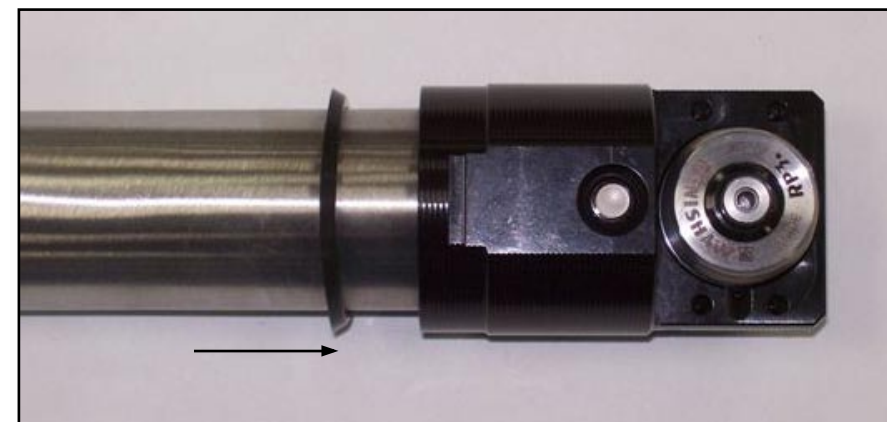
1. Fit the V seals onto both ends of the tube as shown in the image below.



2. Insert the tube into the hub.
3. Connect the probe cable to the probe holder as shown in the image below.
4. Fit the probe holder to the tube.



5. Ensure that all parts are fully engaged.
6. Hold the assembly in position for at least 15 minutes whilst the initial curing process takes place.
7. As the adhesive is curing, wipe away any excess glue and fit the V seals as shown in the image below.



 After assembly, do not cycle the arm for a minimum of 12 hours during which the full adhesive curing process takes place.