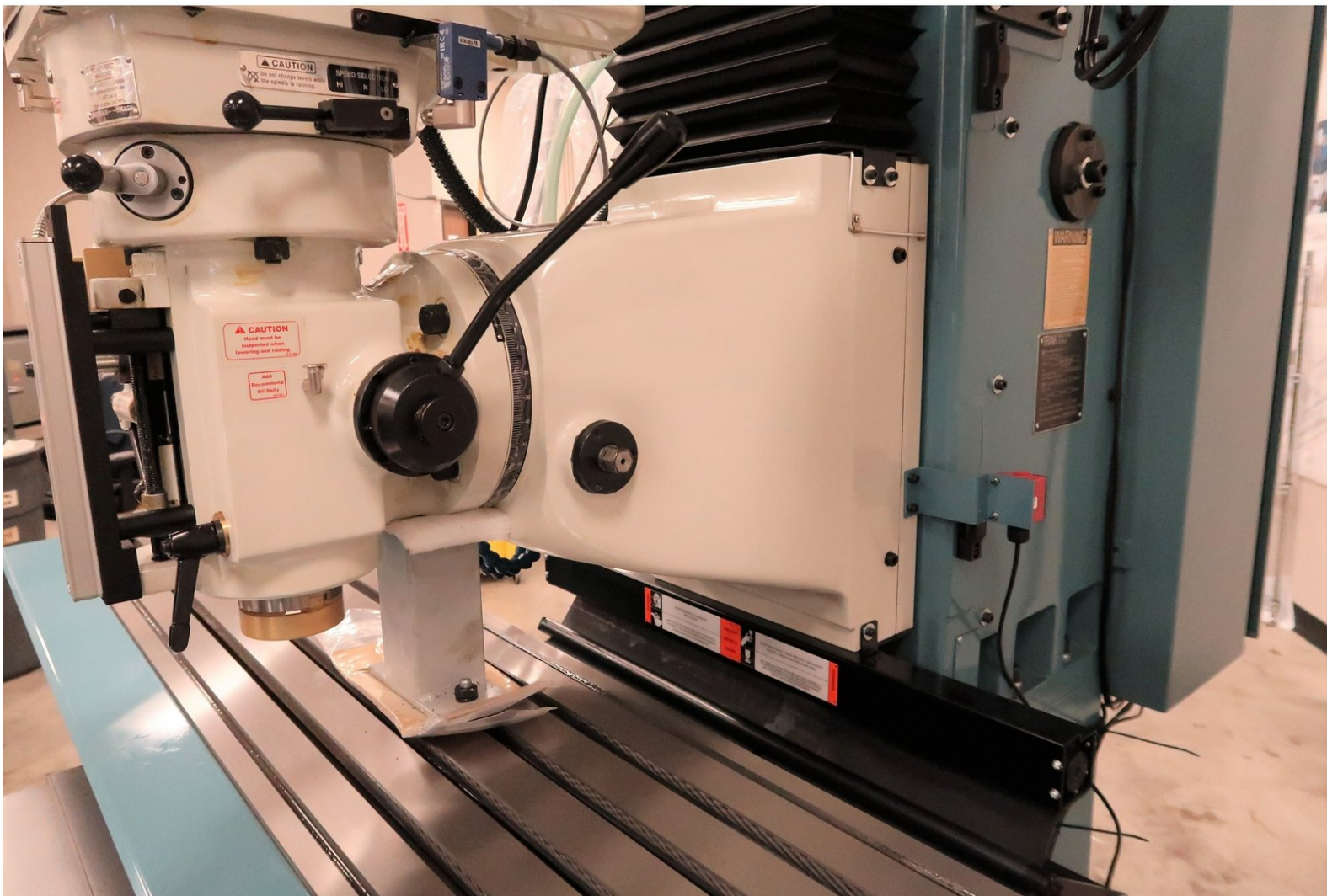




# DPM RX7 - Counterweight Support and Blocking the Head

This guide details how to properly set up the counterweight support and how to block the head of the DPM RX7 machine prior to shipping.

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## TOOLS:

- 3/8 drive ratchet (1)
- 6mm 3 8 drive deep hex socket (1)
- 8mm 3 8 drive deep hex socket (1)
- 10mm Allen Key (1)
- 14mm Allen Bit Socket (1)
- 3/4 socket (1)
- 30-150 ft-lb torque wrench (1)



## PARTS:

- H-369-14A HEAD SHIPPING BLOCK SET - FHM7 (1)

## Step 1 — Align Bottom Counterweight Hole with Column Hole



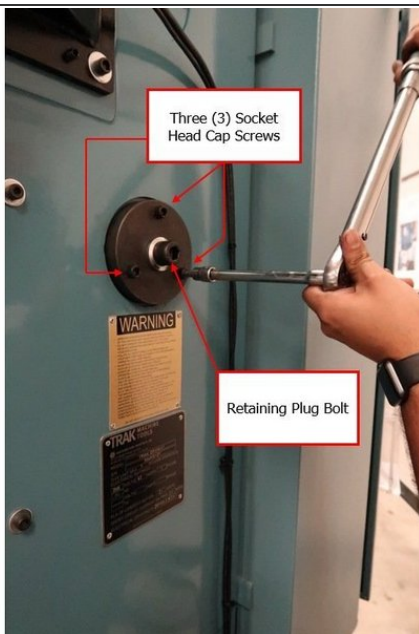
- Jog the head down on the Z-Axis, so that the bottom counterweight hole is aligned with the column hole that is located on the right side of the machine.
- \*Note: there are two (2) counterweight holes; it is the bottom hole that must be aligned with the column hole.

## Step 2 — Place Retaining Plug into Column Hole



- Once both the counterweight and column holes are center aligned, place the retaining plug that supports the counterweight into the column hole.

## Step 3 — Secure Retaining Plug and its Parts into Column



- Using an 8 MM Hex Socket, tighten the three socket head cap screws that secure the counterweight-retaining plug into the column.
- Using a 14 MM Allen Key, tighten the centermost bolt that secures the retaining plug to the counterweight.
- Use a torque wrench to make sure that all three socket head cap screws and the retaining plug bolt are tightly secured into the column.
- The torque specifications required for each screw and bolt are 25 foot-pounds.

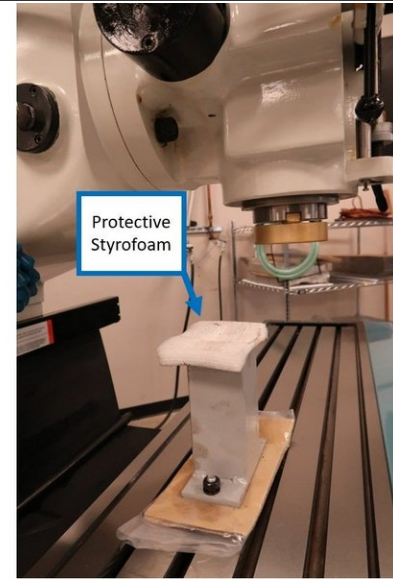
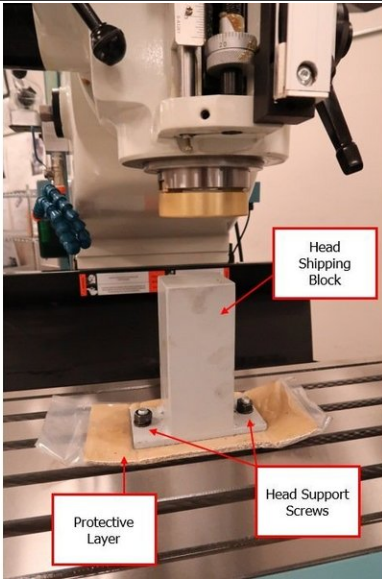


## Step 4 — Blocking the Head - Set Up Support Screws on Table



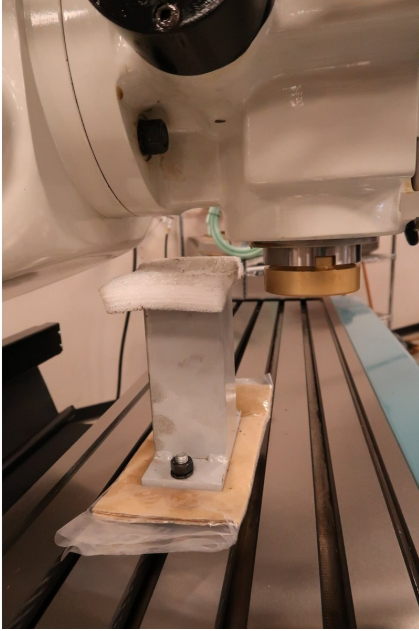
- Once the installation of the counterweight support is complete, make sure that the head is directly above the center of the worktable, and that the measurement for the placement of the head within the X-Axis is at equal distance on both sides.
- Jog the head up on the Z-Axis.
- To begin the setup for the head support on the worktable, place the two (2) head support screws first directly on the worktable surface beneath the head (see image on the left).

## Step 5 — Blocking the Head - Set Up Heading Shipping Block



- Install the entire head shipping block set onto the worktable by placing the protective layer first above the head support screws.
- Place the head shipping block above the protective layer, and then secure the block tightly onto the head support screws.
- Place the protective Styrofoam above the head shipping block.

## Step 6 — Blocking the Head - Align Head with Head Shipping Block on the Y-Axis



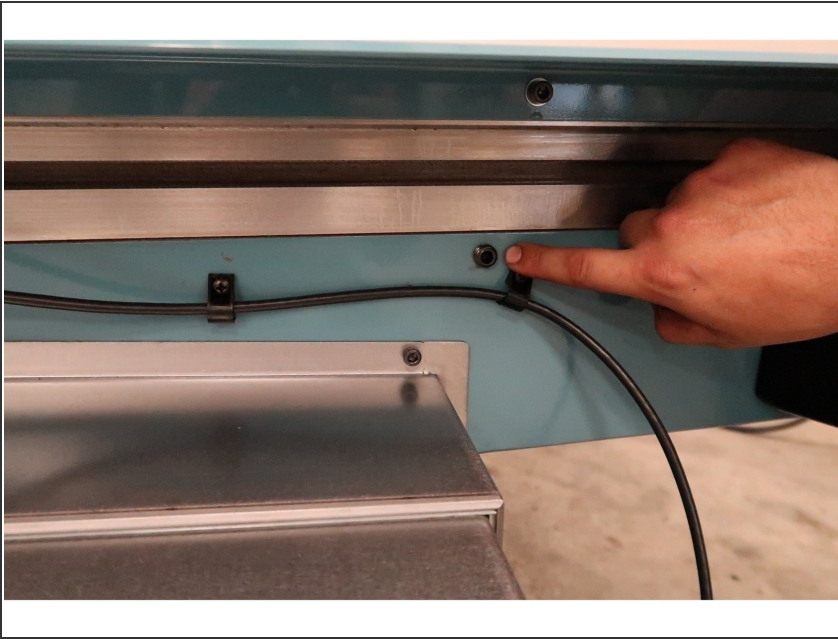
- Move the head back on the Y-Axis until the top of the head shipping block is aligned with the area where the ram meets the head (see image on the left).

## Step 7 — Blocking the Head - Jog Head Down on the Z-Axis onto the Head Shipping Block



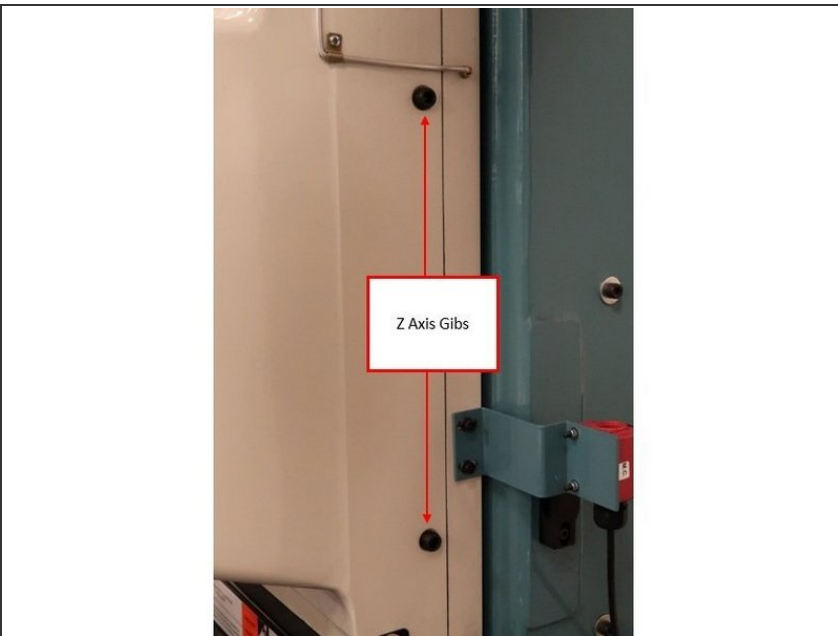
- Jog the head down slowly on the Z-Axis until it bears down on the protective Styrofoam on top of the head shipping block.

## Step 8 — Lock X-Axis Gibs



- Once the head is tightly secured onto the head shipping block, use a 6 MM Socket to lock down the X Axis gibs tightly.

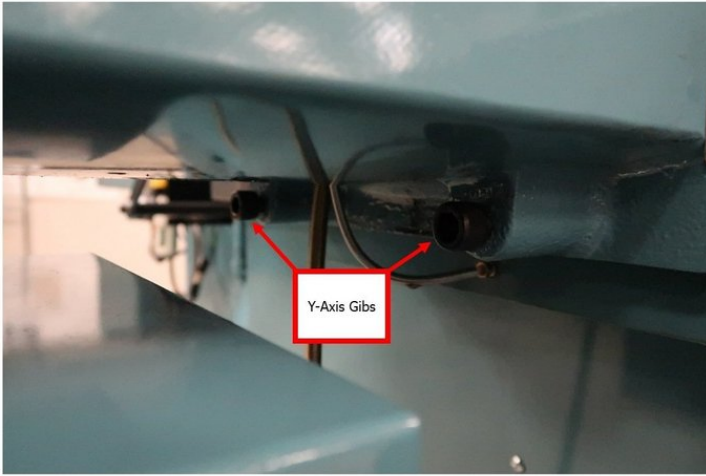
## Step 9 — Lock Z-Axis Gibs



- Use an 8 MM Socket to lock down the Z-Axis gibs tightly.



## Step 10 — Lock Y-Axis Gibs



- Use a 10 MM Allen Key to lock down the Y-Axis gibs tightly.