

# F800 CNC BACK GAUGE FOR FAB50 & FAB80 PRESS BRAKES

## SECTION 1: X-Axis Back Gauge

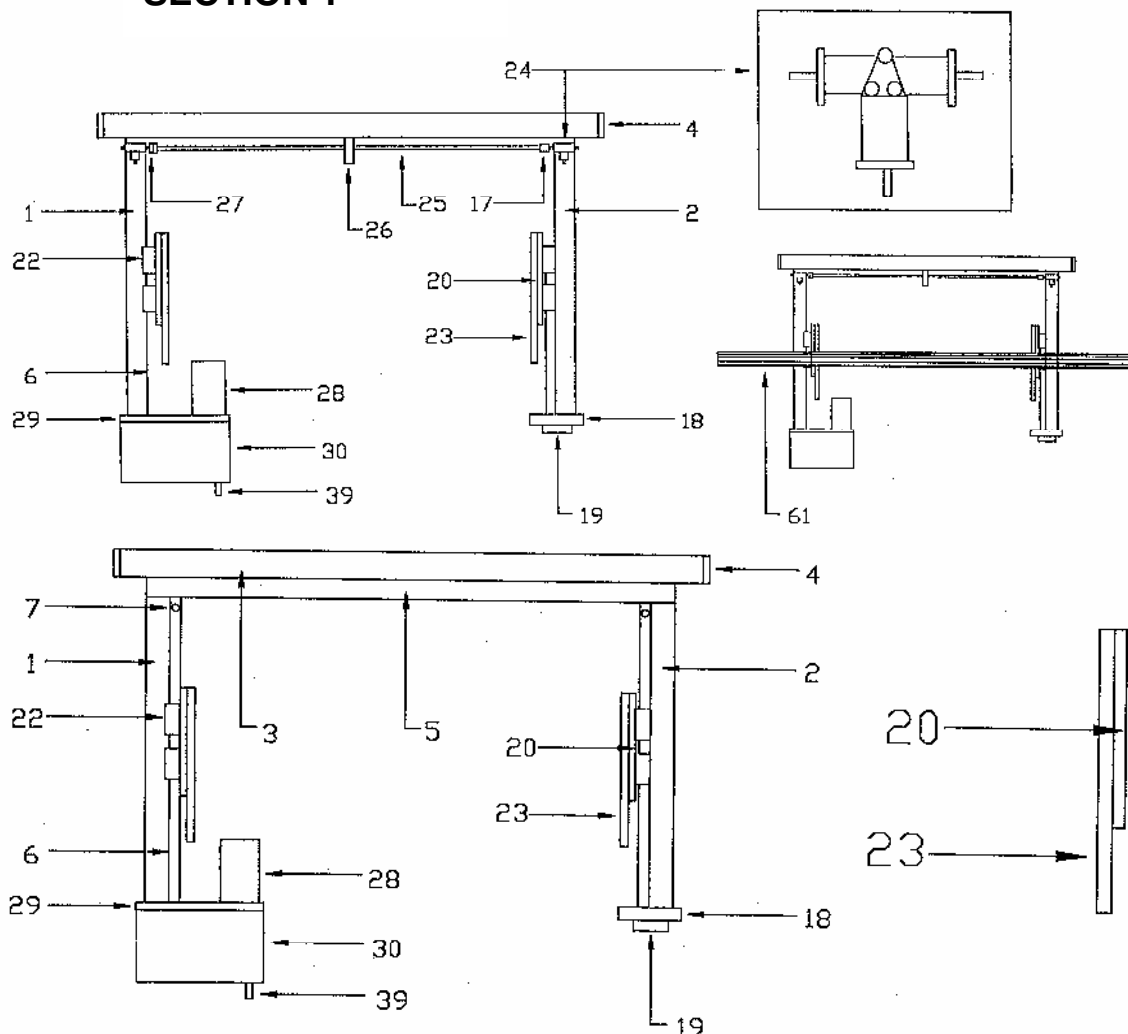
To order parts in this section, review the drawings and write down the item numbers of the parts that you require. Refer to the last page in this section for the matching item numbers, part numbers and description.

## SECTION 2: Finger Assembly

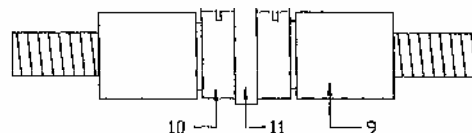
## SECTION 3: Manual R-axis, Upright Assembly

## Section 4: Programmable R-Axis Assembly

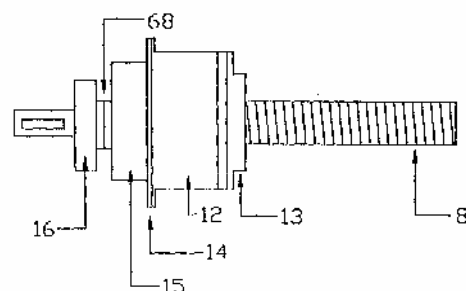
### SECTION 1

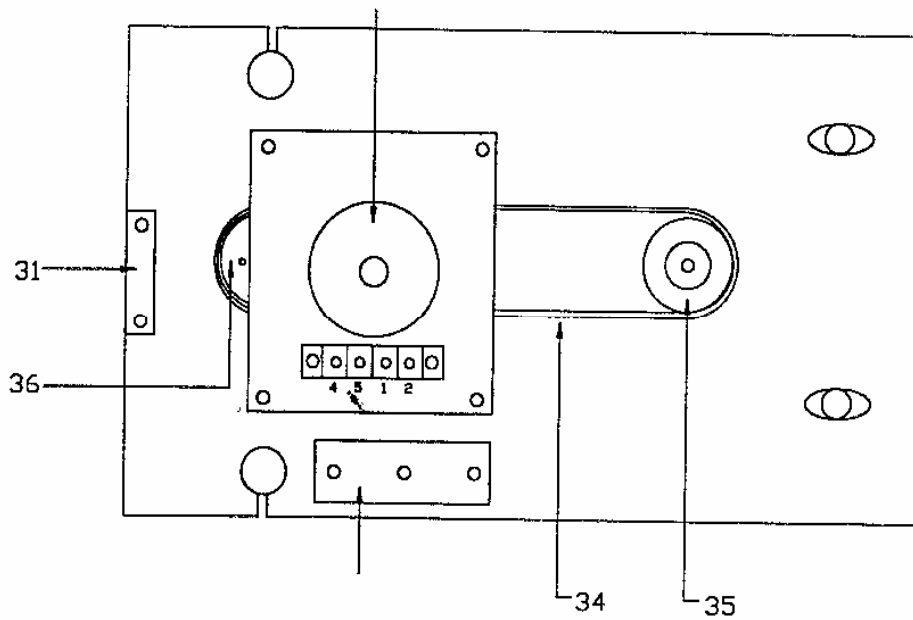


BALL NUT ASSEMBLY

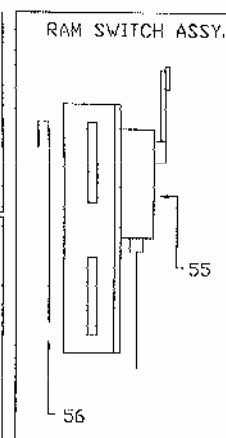
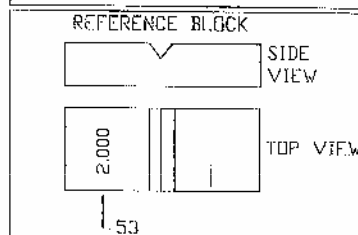
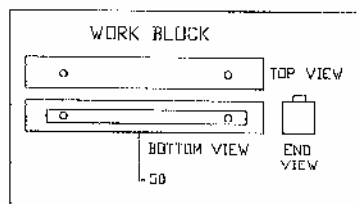
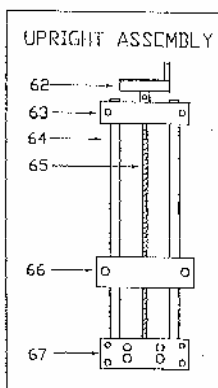
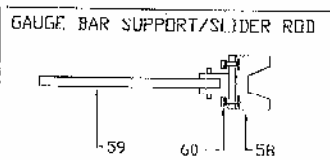
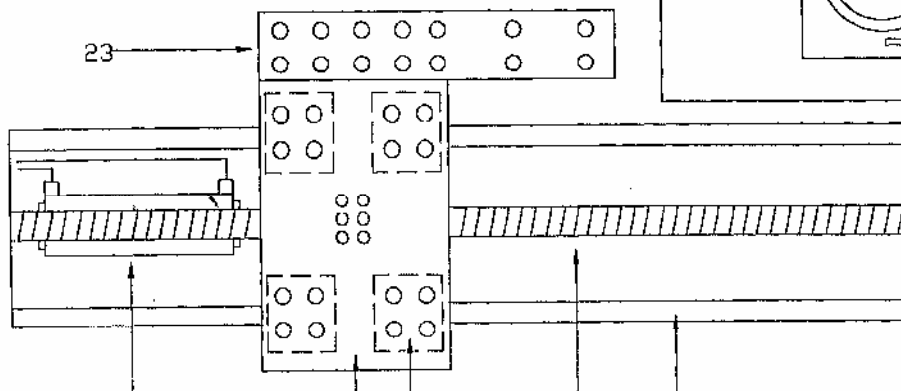
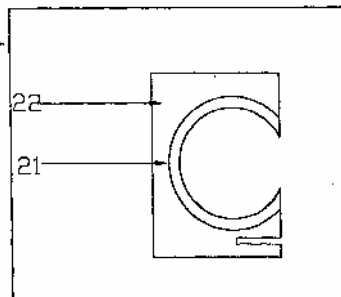


BRAKE ASSEMBLY





22  
END VIEW



## F800 X-AXIS BACK GAUGE

| ITEM | PART NUMBER | DESCRIPTION               |
|------|-------------|---------------------------|
| 1    | 2236-001    | LEFT CASTING              |
| 2    | 2236-002    | RIGHT CASTING             |
| 3    | 2236-003    | FRONT PLATE               |
| 4    | 2236-004-B  | END CAP (G/24-B)          |
|      | 2236-004-HD | END CAP (G/24-HD)         |
|      | 2236-004-TD | END CAP (G/24-TD)         |
| 5    | 2236-005    | BRAKE WIRE CHANNEL        |
| 6    | 2236-006    | HARDENED WAY              |
| 7    | 2236-007    | ROLL PIN                  |
| 8    | 2236-008    | BALL SCREW                |
| 9    | 2236-009    | BALL NUT                  |
| 10   | 2236-010    | BALL NUT PLATE            |
| 11   | 2236-011    | BALL NUT BLOCK            |
| 12   | 2236-012    | BRAKE ARMATURE            |
| 13   | 2236-013    | BRAKE DISC.               |
| 14   | 2236-014    | BEARING RETAINER          |
| 15   | 2236-015    | BEARING                   |
| 16   | 2236-016    | THD SHAFT COLLAR          |
| 17   | 2236-017    | COUPLING, RIGID           |
| 18   | 2236-018    | REAR PLATE                |
| 19   | 2236-019    | REAR PLATE COVER          |
| 20   | 2236-020    | CARRIER PLATE             |
| 21   | 2236-021    | BALL BUSHING              |
| 22   | 2236-022    | BALL BUSHING              |
| 23   | 2236-023    | EXTENDER                  |
| 24   | 2236-024    | RIGHT ANGLE DRIVE CROWN   |
| 25   | 2236-025-B  | CONNECTING ROD (G/24-B)   |
|      | 2236-025-HD | CONNECTING ROD (G/24-HD)  |
|      | 2236-024-TD | CONNECTING ROD (G/24-TD)  |
| 26   | 2236-026    | ROD SUPPORT               |
| 27   | 2236-017    | COUPLING, RIGID           |
| 28   |             | MOTOR H-344-H-0802        |
| 29   | 2236-029    | MOTOR BRACKET             |
| 29A  |             | X-MOTOR ADAPTER           |
| 30   | 2236-030    | MOTOR COVER               |
| 31   | 2236-031    | COVER BLOCK               |
| 33   | 2236-033    | LIMIT SWITCH              |
| 34   | 2236-034    | DRIVE BELT                |
| 35   | 2236-035    | DRIVE SPROCKET            |
| 36   | 2236-036    | DRIVEN SPROCKET           |
| 46   | 2236-046    | MOUNT. HARDWARE           |
| 47   | 2236-047    | MOUNT. HARDWARE           |
| 48   |             | MOUNT. HARDWARE CONT. BOX |
| 49   | 2236-049    | MOUNT HARDWARE            |
| 50   | 2236-050    | WORK BLOCK                |
| 53   | 2236-053    | REF. BLOCK                |
| 58   | 2236-058    | GAUGE BAR SUPPORT         |
| 59   | 2236-059    | SLIDER ROD                |
| 60   | 2236-060    | TEE BOLT                  |
| 61   | 2236-061-B  | GAUGE BAR S.E. (G/24-B)   |
|      | 2236-061-HD | GAUGE BAR S.E. (G/24-HD)  |
|      | 2236-061-TD | GAUGE BAR S.E. (G/24-TD)  |

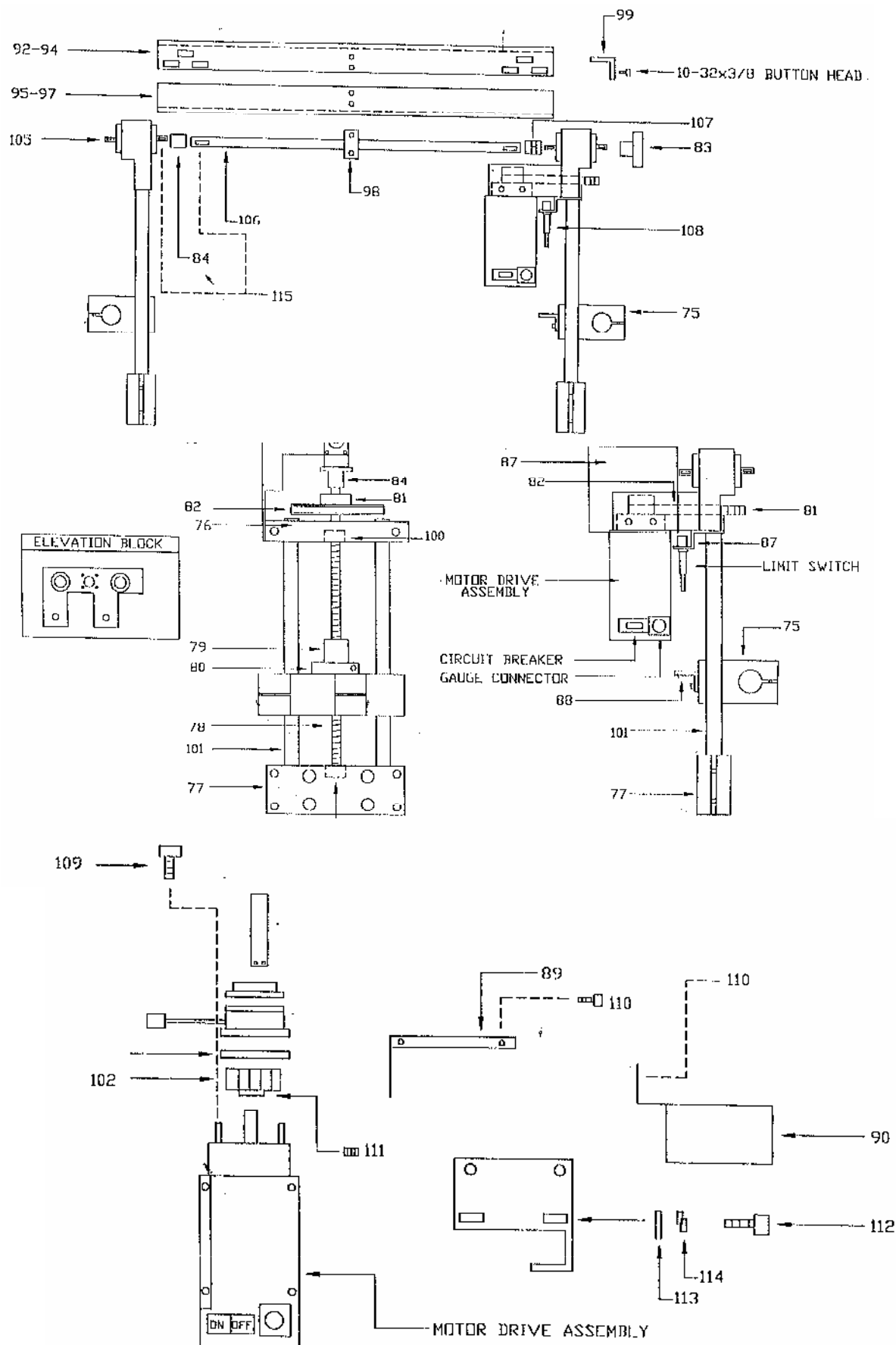
| ITEM | PART NUMBER | DESCRIPTION              |
|------|-------------|--------------------------|
| 1    | 2236-301    | FINGER ROD               |
| 2    | 2236-302    | FLIP FINGER              |
| 3    | 2236-303    | FINGER PLATE             |
| 4    | 2236-304    | FINGER KEY 1/2 X 5/8 X 3 |
| 5    | 2236-305    | SHAFT COLLAR (MACHINED)  |
| 6    | 2236-306    | TIP ADAPTER              |
| 7    | 2236-307    | FLAT WASHER              |
| 8    | 2236-308    | KNURLED HEAD SCREW       |
| 9    | 2236-309    | RATCHET HANDLE           |
| 10   | 2236-310    | KNURLED NUTS             |
| 11   | 2236-311    | SPRING                   |
| 12   | 2236-312    | SHAFT COLLAR             |
| 13   | 2236-313    | SOCKET SET SCREW         |
| 14   | 2236-314    | LOCK RING                |
| 15   | 2236-315    | CAP SCREW (PATCH)        |
| 16   | 2236-316    | TEE NUT                  |
| 17   | 2236-317    | WASHER FLAT              |
| 18   | 2236-318    | HALF DOG                 |
| 19   | 2236-319    | HEX NUT                  |
| 20   | 2236-320    | BUTTON HEAD CAP SCREW    |
| 21   | 2236-321    | BUTTON HEAD CAP SCREW    |
| 22   | 2236-322    | SNAP RING                |
| 23   | 2236-323    | SOCKET SET SCREW         |

| ITEM | PART NUMBER | DESCRIPTION              |
|------|-------------|--------------------------|
| 1    | 2236-301    | FINGER ROD               |
| 2    | 2236-302    | FLIP FINGER              |
| 3    | 2236-303    | FINGER PLATE             |
| 4    | 2236-304    | FINGER KEY 1/2 X 5/8 X 3 |
| 5    | 2236-305    | SHAFT COLLAR (MACHINED)  |
| 6    | 2236-306    | TIP ADAPTER              |
| 7    | 2236-307    | FLAT WASHER              |
| 8    | 2236-308    | KNURLED HEAD SCREW       |
| 9    | 2236-309    | RATCHET HANDLE           |
| 10   | 2236-310    | KNURLED NUTS             |
| 11   | 2236-311    | SPRING                   |
| 12   | 2236-312    | SHAFT COLLAR             |
| 13   | 2236-313    | SOCKET SET SCREW         |
| 14   | 2236-314    | LOCK RING                |
| 15   | 2236-315    | CAP SCREW (PATCH)        |
| 16   | 2236-316    | TEE NUT                  |
| 17   | 2236-317    | WASHER FLAT              |
| 18   | 2236-318    | HALF DOG                 |
| 19   | 2236-319    | HEX NUT                  |
| 20   | 2236-320    | BUTTON HEAD CAP SCREW    |
| 21   | 2236-321    | BUTTON HEAD CAP SCREW    |
| 22   | 2236-322    | SNAP RING                |
| 23   | 2236-323    | SOCKET SET SCREW         |

# MANUAL R-AXIS

The drawing consists of two views of a mechanical assembly. The left view is a front elevation showing a vertical assembly. At the top, a horizontal plate (1) is supported by a vertical post (2). A horizontal bar (3) is mounted on the post. Below this, a horizontal plate (4) is shown with two circular holes. A vertical rod (5) passes through the center of this plate. A horizontal plate (6) is mounted on the rod. Below this, a horizontal plate (7) is shown with two circular holes. A vertical rod (8) passes through the center of this plate. A horizontal plate (9) is mounted on the rod. Below this, a horizontal plate (10) is shown with two circular holes. A vertical rod (11) passes through the center of this plate. A horizontal plate (12) is mounted on the rod. Below this, a horizontal plate (13) is shown with two circular holes. A vertical rod (14) passes through the center of this plate. A horizontal plate (15) is mounted on the rod. The right view is a side elevation showing the same assembly from a different perspective. It shows the vertical rod (5) and the horizontal plate (4) at the top. The rod passes through a series of horizontal plates (7, 10, 13, 15) which are mounted on a vertical support structure. The bottom plate (15) has a circular hole on its side. The top plate (4) has a circular hole on its side. The side view shows the vertical rod (5) passing through the center of the plates. The side view also shows the horizontal plate (12) at the bottom, which has a circular hole on its side. The side view shows the vertical rod (11) passing through the center of the plates. The side view also shows the horizontal plate (15) at the bottom, which has a circular hole on its side. The side view shows the vertical rod (14) passing through the center of the plates. The side view also shows the horizontal plate (15) at the bottom, which has a circular hole on its side.

SECTION 4:  
PROGRAMMABLE R-AXIS



## PROGRAMMABLE R-AXIS PARTS LIST

| ITEM | PART NUMBER | DESCRIPTION              |
|------|-------------|--------------------------|
| 75   | 2236-075    | ELEVATION BLOCK          |
| 76   | 2236-076    | UPPER CLAMP              |
| 77   | 2236-077    | LOWER CLAMP              |
| 78   | 2236-078    | BALL SCREW               |
| 79   | 2236-079    | BALL NUT                 |
| 80   | 2236-080    | BALL NUT PLATE           |
| 81   | 2236-081    | SPROCKET                 |
| 82   | 2236-082    | BELT                     |
| 83   | 2236-083    | HAND WHEEL               |
| 84   | 2236-084    | COUPLING                 |
| 87   | 2236-087    | 32 AD MOTOR BKT          |
| 88   | 2236-088    | SWITCH ACTUATOR          |
| 89   | 2236-089    | MTR BKT COVER            |
| 90   | 2236-90     | BELT GUARD               |
| 91   | 2236-91     | G. BOX SUP. L&R          |
| 92   | 2236-092-HD | CHAN HD                  |
| 93   | 2236-093-B  | CHAN B                   |
| 94   | 2236-094-TD | CHAN BPG                 |
| 95   | 2236-095    | CON ROD CVR (CHAN) HD    |
| 96   | 2236-096    | CON ROD CVR (CHAN)B      |
| 97   | 2236-097    | CON ROD CVR (CHAN) BPG   |
| 98   | 2236-098    | CON ROD SUP (ALL SYS)    |
| 99   | 2236-099    | CON ROD CVR              |
| 100  | 2236-100    | BEARING                  |
| 101  | 2236-101    | SHAFT                    |
| 102  | 2236-102    | SPROCKET                 |
| 105  | 2236-105    | GEAR BOX                 |
| 106  | 2236-106-B  | CONNECTING ROD (G/24-B)  |
|      | 2236-106-HD | CONNECTING ROD (G/24-HD) |
|      | 2236-106-TD | CONNECTING ROD (G/24-TD) |
| 107  | 2236-107    | FLEXIBLE COUPLING        |
| 108  |             | LIMIT SWITCH             |
| 109  | 2236-109    | SCREW (SHCS) (4)         |
| 110  | 2236-110    | SCREW (BUTTON) (6)       |
| 111  | 2236-111    | SCREW (SET) (2)          |
| 112  | 2236-112    | SCREW (SHCS) (4)         |
| 113  | 2236-113    | HEAVY F/W (4)            |
| 114  | 2236-114    | LOCK WASHER (4)          |
| 115  | 2236-115    | WOODRUFF KEY (3)         |