

# Fabrication Tooling

The following Drilling Jigs have been developed to assist the assembler in quickly and accurately completing a the fabrication process. The assembler simply places the jig on the rail and uses a portable drill to complete the job. By using these jigs the customer avoids the timely and costly process of setting each rail up in a drilling machine.

In addition, Mod Tech has one Assembly Jig used to set the height of the Foot Assembly into a center position. This height then allows an even amount of up or down height adjustment.

All of the Fabrication Tooling are stock items and can be shipped within 5 days ARO. Mod-Tech understands that during a build phase a customer may need some of the tools in a short amount of time. Please contact Mod Tech for rush shipments.

# Drill Jig

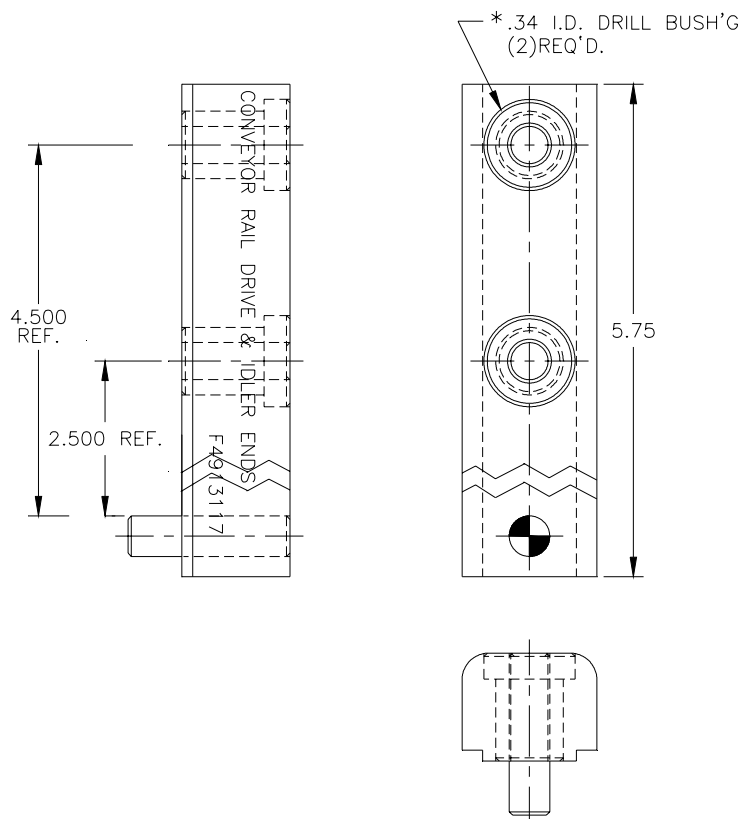
## MAC-4913117

### CONVEYOR RAIL DRILL JIG DRIVE AND IDLER HOLES

**Application:** Drilling the holes to mount the drive and idler plates.

**Features:** Precision machined 6061 with press fit Drill Bushings and Dowel Pin locator.

**Instructions:** Place jig on the back of conveyor rail in key slot with the dowel being used as a hard stop against the machined end of the conveyor rail. Drill (2) holes.



# Drill Jig

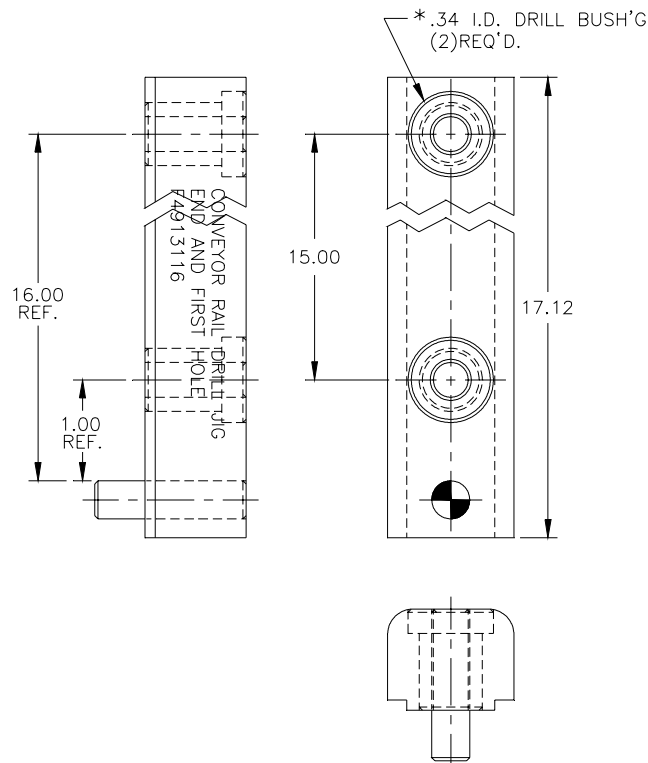
## MAC-4913116

### CONVEYOR RAIL DRILL JIG END AND FIRST HOLE

**Application:** Drilling the first and second holes in the conveyor rail for the "H" Beam Rail Spacer.

**Features:** Precision machined 6061 with press fit Drill Bushings and Dowel Pin locator.

**Instructions:** Place jig on the back of conveyor rail in key slot with the dowel being used as a hard stop against the end of the conveyor rail. Drill (2) holes. After completing this step use Fabrication Jig #MAC-4913016 for the remaining spacer holes. Use this jig again at the opposite end of the conveyor for the final spacer hole.



# Drill Jig

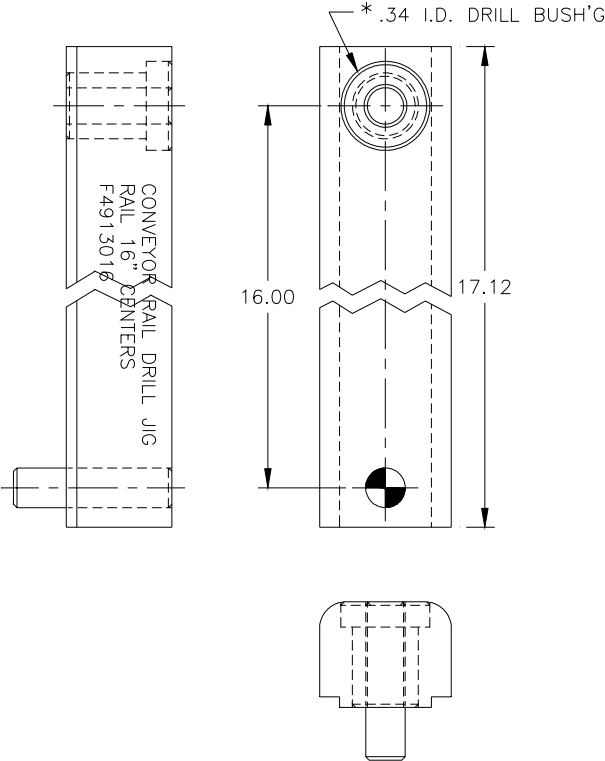
## MAC-4913016

### CONVEYOR RAIL DRILL JIG HOLES ON 16" CENTERS

**Application:** Drilling the 16" (on center) holes in the conveyor rail for the "H" Beam Rail Spacer.

**Features:** Precisions machined 6061 with press fit Drill Bushings and Dowel Pin locator.

**Instructions:** Place jig on the back of conveyor rail in key slot with the dowel pin inserted through the .34: dia hole located 16" from the end of the rail. After drilling through move the jig so the dowel pin is inserted into the hole just drilled. Repeat for the length of the conveyor length.



# Drill Jig

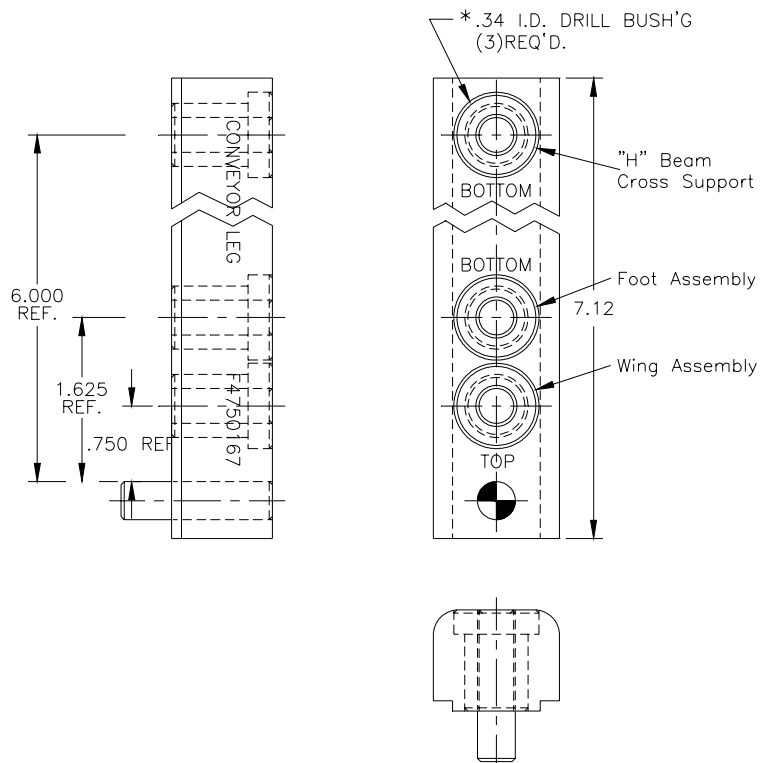
## MAC-4750167

### CONVEYOR LEG DRILL JIG

**Application:** Drilling the holes in the conveyor leg for the Foot Assembly, the "H" Beam Leg Spacer, and the wing mount hole.

**Features:** Precisions machined 6061 with press fit Drill Bushings and Dowel Pin locator.

**Instructions:** Place jig on the back of leg in key slot with the dowel pin used as a hard stop on the lower end of the leg. Drill (2) holes labeled "BOTTOM". Repeat on the top of the leg with (1) hole labeled "TOP".



# Drill Jig

## MAC-4913118

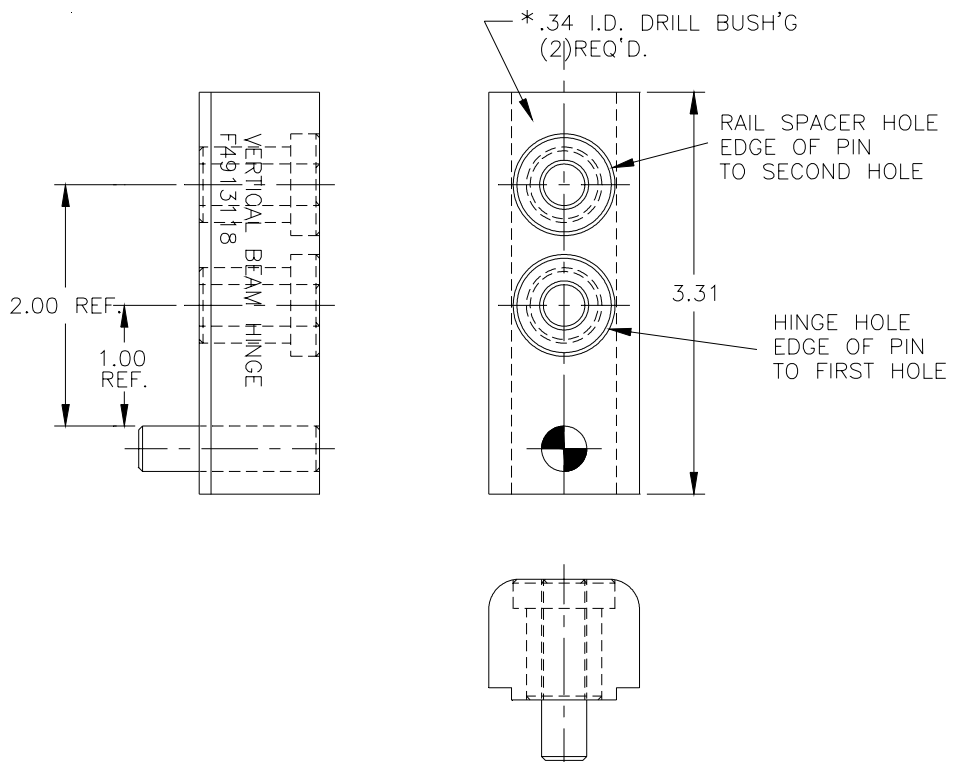
### CONVEYOR RAIL DRILL JIG

### VERTICAL BEAM HINGE

**Application:** Drilling the holes in the conveyor rail for the Vertical Beam Assembly and the "H" Beam Leg Spacer.

**Features:** Precisions machined 6061 with press fit Drill Bushings and Dowel Pin locator.

**Instructions:** Place jig on the back of conveyor rail in key slot with the dowel pin used as a hard stop on the end of the rail. Drill (2) holes.



# Assembly Jig

## MAC-4750106

### FOOT ASSEMBLY SETUP JIG

**Application:** Used to set the height adjustment of the foot assembly to the center or natural position.

**Features:** Machined 6061 aluminum with storage hole.

**Instructions:** On an pre-assembled foot assembly, place the jig in the bottom of an assembled foot so the lip is in contact with the leg extrusion. Push the extrusion up so the ledge makes contact with the foot base and tighten the hex head cap screw.

