



Tecnologie Avanzate

Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 1/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
WORKING CYCLE PHASE	DESCRIPTION AND NOTES		IMAGES	

APPLICABLE DOCUMENTATION:

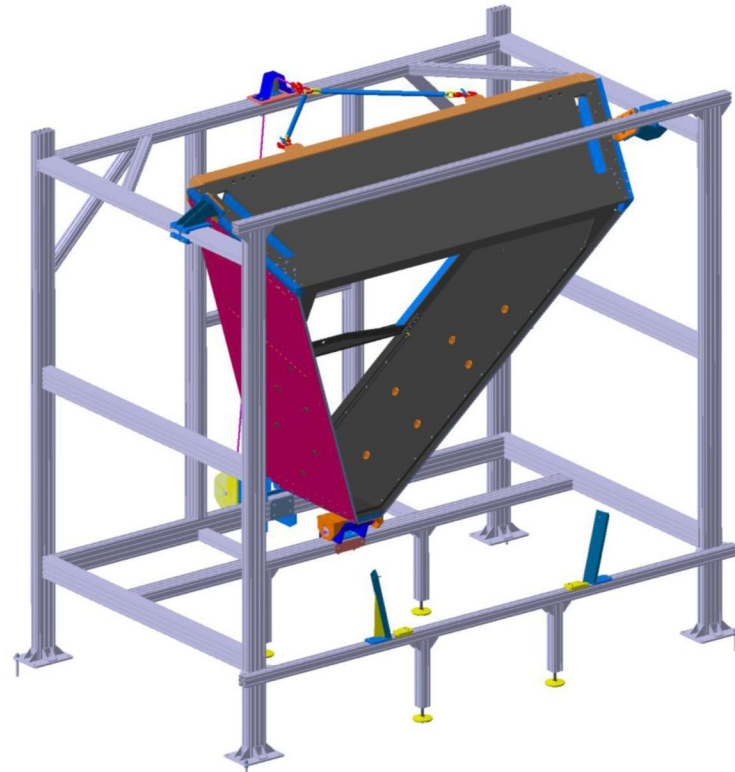
Assembly Structure For RICH Module_August 2016

TOOL:

TA-STR-001 RICH Assembly Structure

BILL OF P/Ns:

P/N	Q.ty	P/N	Q.ty
TA-RICH-002	1	TA-RICH-035	1
TA-RICH-012	1	TA-RICH-036	1
TA-RICH-013	1	TA-RICH-037	1
TA-RICH-019	1	TA-RICH-038	1
TA-RICH-020	1	TA-RICH-039	1
TA-RICH-021	1	TA-RICH-045	1
TA-RICH-022	1	TA-RICH-046	1
TA-RICH-023	1	TA-RICH-047	4
TA-RICH-024	1	TA-RICH-078	1
TA-RICH-025	1	TA-RICH-079	1
TA-RICH-026	1	TA-RICH-080	1
TA-RICH-027	1	TA-RICH-083	1
TA-RICH-028	1	TA-RICH-092	1
TA-RICH-029	1	TA-RICH-093	1
TA-RICH-030	1	TA-RICH-094	1
TA-RICH-031	1	TA-RICH-095	1
TA-RICH-032	1	TA-RICH-096	1
TA-RICH-033	1	TA-RICH-097	1
TA-RICH-034	1	TA-RICH-098	1



COMPILED BY:

I. Loi

VERIFIED BY:

M. Pinna

APPROVED BY:

P. Coluzzi



Tecnologie Avanzate

Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 2/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
WORKING CYCLE PHASE	DESCRIPTION AND NOTES		IMAGES	
STANDARDS REQUIRED:				
	<i>TYPE</i>	<i>Q.ty</i>		
	Screw STEEL M5 x 12 ISO 4762	22		
	Screw STEEL M5 x 25 ISO 4017	4		
	Screw STEEL M6 x 16 ISO 4762	16		
	Screw STEEL M8 x 20 ISO 4762	62		
	Screw STEEL M8 x 25 ISO 4762	10		
	Screw STEEL M8 x 30 ISO 4762	23		
	Screw STEEL M10 x 35 ISO 4762	82		
	Washer STEEL M5 ISO 7089	38		
	Washer STEEL M6 ISO 7089	16		
	Washer STEEL 8 x 16 ISO 7089	115		
	Washer STEEL 10 x 20 ISO 7089	92		
	Washer STEEL M24 ISO 7089	18		
	Washer STEEL 8,8 M28 ISO 7089	8		
	Nut STEEL 8,8 M24 ISO 4032	8		
	NAS1802-6-10	20		
	NAS1802-4-13	12		
	Bolt STEEL M10 x 40 ISO 4014	6		
	Bolt STEEL M10 x 45 ISO 4014	4		
	Bolt STEEL M24 x 60 ISO 4014	2		
	Bolt STEEL 8,8 M24 x 65 ISO 4014	8		
	Screwed Bar M24	2		
	Bolteye M24	2		
	Assembly Lifting Tool	1		

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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 3/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.010	<p>Before beginning the assembly of the RICH CLAS12 module move backward the items:</p> <ul style="list-style-type: none"> • TA-RICH-053; • TA-RICH-054; • TA-RICH-060; • TA-RICH-063 <p>in the way represented in the figure:</p>	

COMPILED BY: I. Loi <i>I. Loi</i>	VERIFIED BY: M. Pinna <i>M. Pinna</i>	APPROVED BY: P. Coluzzi <i>P. Coluzzi</i>
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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 4/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.020	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-019 N° 1 TA-RICH-020 N° 1 TA-RICH-021 N° 1 TA-RICH-022 N° 4 Screw STEEL M8 x 20 ISO 4762 N° 11 Washer STEEL 8 x 16 ISO 7089 N° 7 Screw STEEL M8 x 30 ISO 4762 N° 8 Screw STEEL M10 x 35 ISO 4762 N° 8 Washer STEEL 10 x 20 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	<p>TA-RICH-019</p> <p>TA-RICH-021</p> <p>N.B. Maintain a gap of 0.5 mm between TA-RICH-021 and TA-RICH-020</p> <p>TYPICAL 4 POS.: N°1 SCREW M8x20 N°1 WASHER 8x16</p> <p>TYPICAL 7 POS.: N°1 SCREW M8x30 N°1 WASHER 8x16</p> <p>TYPICAL 8 POS.: N°1 SCREW M10x35 N°1 WASHER 10x20</p> <p>TA-RICH-020</p> <p>TA-RICH-022</p> <p>TA-RICH-021</p>

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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 5/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
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OP.030

Install the assembled items on TA-RICH-055 by using:

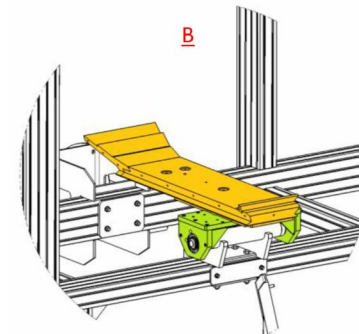
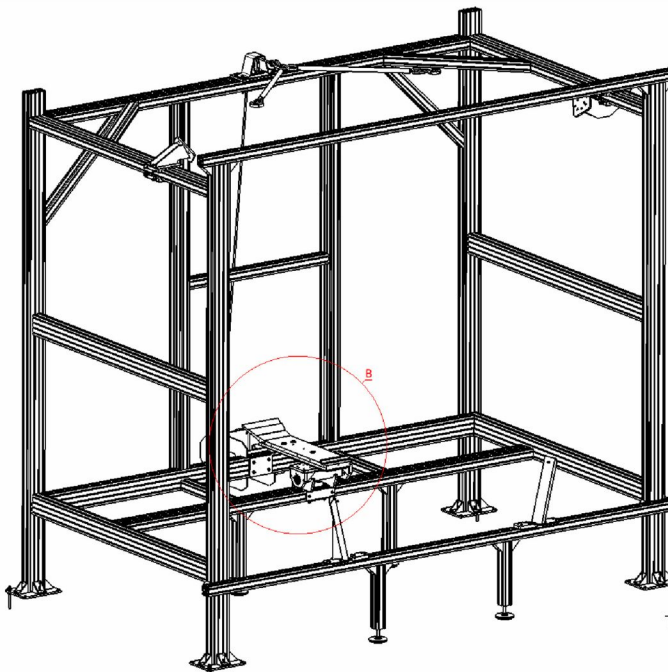
- N° 4 Bolt STEEL M10 x 45 ISO 4014
- N° 4 Washer STEEL 10 x 20 ISO 7089

in the way represented in the figure:

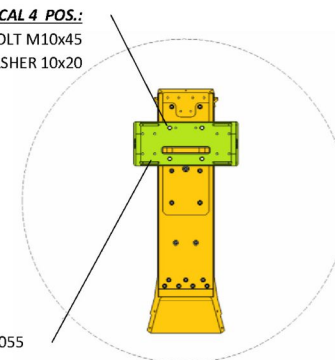
After that, pull out the locking pins TA-STR-026 from TA-RICH-055.

Turn 65 ° angle the assembly and lock the position obtained through the locking pins, previously removed, in order to make the rotation assembly stable and to continue the assembly, as shown on the side:

HEAVY OPERATION (80 Kg)



TYPICAL 4 POS.:
 N°1 BOLT M10x45
 N°1 WASHER 10x20



TA-RICH-055

ASSEMBLY INSTRUCTIONS

COMPILED BY:	VERIFIED BY:	APPROVED BY:
I. Loi <i>I. Loi</i>	M. Pinna <i>M. Pinna</i>	P. Coluzzi <i>P. Coluzzi</i>



P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 6/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.040	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-002 N° 1 TA-RICH-012 N° 10 Screw STEEL M8 x 25 ISO 4762 N° 10 Washer STEEL 8 x 16 ISO 7089 N° 6 Screw STEEL M10 x 35 ISO 4762 N° 6 Washer STEEL 10 x 20 ISO 7089 <p>Follow the instruction below and observe the figures:</p> <ol style="list-style-type: none"> Take P/N TA-RICH-002 and place on the floor; Position two or more lifting slings around the particular; Take the fork lift and get the harnessed particular as close as possible to the assembled parts; With the support of operators, the forklift and thanks to the installation tools (TA-STR-027, TA-STR-028, TA-STR-029, TA-STR-030), bring TA-RICH-002 in position with TA-RICH-021 in way to allow the assembly; Do the same operations with TA-RICH-012. 	

HEAVY OPERATION (130 Kg)

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Tecnologie Avanzate

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 7/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.050	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-045 N° 1 TA-RICH-046 N° 16 Screw STEEL M8 x 30 ISO 4762 N° 16 Washer STEEL 8 x 16 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	<p>The drawing shows a perspective view of a rectangular metal frame assembly. Components are labeled as follows: TA-RICH-002 (left vertical support), TA-RICH-012 (top horizontal beam), TA-RICH-045 (right vertical support), and TA-RICH-046 (bottom horizontal beam). A callout points to a grid of 16 screw/washer positions on the top surface, labeled 'TYPICAL 16 POS.: N°1 SCREW M8x30 N°1 WASHER 8x16'.</p>

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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 8/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
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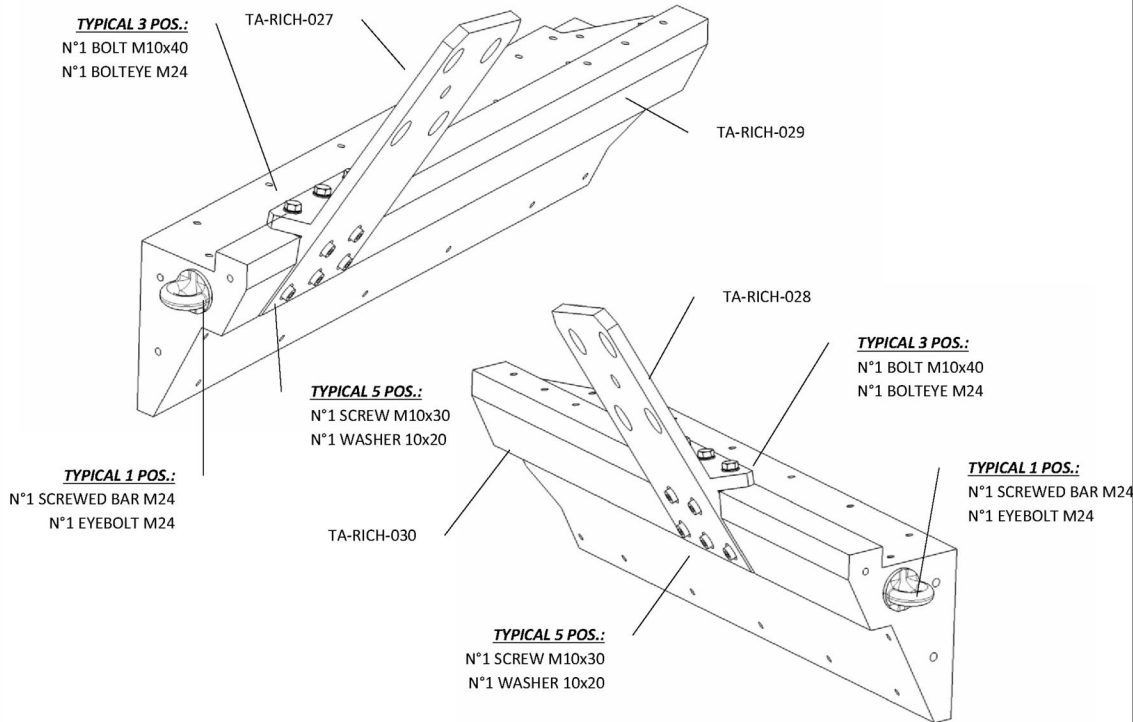
HEAVY OPERATION (60 Kg)

OP.060

Withdraw the following items:

- N° 1 TA-RICH-027
- N° 1 TA-RICH-028
- N° 1 TA-RICH-029
- N° 1 TA-RICH-030
- N° 6 Bolt STEEL M10 x 40 ISO 4014
- N° 44 Washer STEEL 10 x 20 ISO 7089
- N° 38 Screw STEEL M10 x 35 ISO 4762
- N° 2 Screwed Bar M24
- N° 2 Bolteye M24

Firstly, assemble TA-RICH-027 with TA-RICH-029 and TA-RICH-028 with TA-RICH-030, than install the M24 Screwed Bars and the eyebolts on them as shown:



COMPILED BY:	VERIFIED BY:	APPROVED BY:
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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 9/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
HEAVY OPERATION (60 Kg)	<p>Assemble the parts with TA-RICH-002 and TA-RICH-012 following the instruction below and observing the figures:</p> <ol style="list-style-type: none"> 1) Take TA-RICH-029 and place on the floor; 2) Tie a ribbon in the eyebolt and lift using forklift; 3) Bring the part next to TA-RICH-002 until you have the surface in abutment with the panel; 4) With the support of operators and of the forklift turn TA-RICH-029 until you have each hole perfectly aligned; 5) Fix both particulars with the screws previously taken; 6) Do the same between TA-RICH-030 and TA-RICH-012; 7) Remove Eyebolts and Screwed Bars from TA-RICH-029 and TA-RICH-030. 	

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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 10/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.070	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-033 N° 1 TA-RICH-034 N° 1 TA-RICH-096 N° 1 TA-RICH-097 N° 12 Screw STEEL M8 x 20 ISO 4762 N° 12 Washer STEEL 8 x 16 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	<p>TYPICAL 12 POS.: N°1 SCREW M8x20 N°1 WASHER 8x16</p> <p>N.B. Ensure zero tolerance contact between the parts</p>

COMPILED BY:	VERIFIED BY:	APPROVED BY:
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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 11/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.080	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-035 N° 1 TA-RICH-036 N° 1 TA-RICH-094 N° 1 TA-RICH-095 N° 26 Screw STEEL M8 x 20 ISO 4762 N° 26 Washer STEEL 8 x 16 ISO 7089 <p>On the opposite side of that shown in the OP.070, assemble the collected items in the way represented in the figure:</p>	

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Installation & Control Scheme

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P/N: TA-RICH-001

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SHEET: 12/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.090	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-037 N° 1 TA-RICH-038 N° 16 Screw STEEL M8 x 20 ISO 4762 N° 16 Washer STEEL 8 x 16 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	<p>TA-RICH-038</p> <p>TA-RICH-037</p> <p>TYPICAL 16 POS.: N°1 SCREW M8x20 N°1 WASHER 8x16</p>

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Tecnologie Avanzate

Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 13/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.100	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-047 S/N 1 N° 1 TA-RICH-047 S/N 2 N° 1 TA-RICH-047 S/N 3 N° 1 TA-RICH-047 S/N 4 N° 12 Screw STEEL M5 x 12 ISO 4762 N° 12 Washer STEEL M5 ISO 7089 <p>Assemble the collected items so as to be positioned internally to the RICH case, as represented in the figure:</p>	<p>TA-RICH-047 S/N 2</p> <p>TA-RICH-034</p> <p>TA-RICH-038</p> <p>TA-RICH-047 S/N 1</p> <p>TA-RICH-046</p> <p>TA-RICH-047 S/N 4</p> <p>TA-RICH-047 S/N 3</p> <p>TYPICAL 12 POS.: N°1 SCREW M5x12 N°1 WASHER M5</p>

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Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 14/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.110	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-092 N° 1 TA-RICH-093 N° 1 TA-RICH-039 N° 4 Screw STEEL M8 x 20 ISO 4762 N° 4 Washer STEEL 8 x 16 ISO 7089 N° 4 Screw STEEL M5 x 25 ISO 4762 N° 4 Washer STEEL M5 ISO 7089 <p>Observing the figure, follow the instructions:</p> <ol style="list-style-type: none"> Place the TA-RICH-039 on TA-RICH-047s; Place TA-RICH-092 and TA-RICH-093 on TA-RICH-039 and assemble them with TA-RICH-047s using Screw M5x25; Assemble TA-RICH-092 on TA-RICH-002 using Screw M8x20; Assemble TA-RICH-093 on TA-RICH-012 using Screw M8x20. 	<p>TA-RICH-092</p> <p>TA-RICH-002</p> <p>TA-RICH-012</p> <p>TA-RICH-093</p> <p>TA-RICH-039</p> <p>TA-RICH-012</p> <p>TA-RICH-037</p> <p>TYPICAL 4 POS.: N°1 SCREW M8x20 N°1 WASHER 8x16</p> <p>TYPICAL 4 POS.: N°1 SCREW M5x25 N°1 WASHER M5</p>

<p>COMPILED BY:</p> <p>I. Loi</p>	<p>VERIFIED BY:</p> <p>M. Pinna</p>	<p>APPROVED BY:</p> <p>P. Coluzzi</p>
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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 15/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.120	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-023 N° 1 TA-RICH-024 N° 1 TA-RICH-025 N° 1 TA-RICH-026 N° 10 Screw STEEL M5 x 12 ISO 4762 N° 10 Washer STEEL M5 ISO 7089 N° 16 Screw STEEL M6 x 16 ISO 4762 N° 16 Washer STEEL M6 ISO 7089 <p>Observing the figure, follow the instructions:</p> <ol style="list-style-type: none"> Place TA-RICH-023 and TA-RICH-024 on TA-RICH-037 and TA-RICH-038 and fix with Screw M5x12; Place TA-RICH-025 and TA-RICH-026 and assemble on TA-RICH-002 and TA-RICH-012 them with Screw M6x16. 	

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Tecnologie Avanzate

Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 16/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.130	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-013 N° 20 Screw NAS1802-6-10 N° 20 Washer STEEL 8x16 ISO 7089 N° 26 Screw STEEL M10 x 35 ISO 4762 N° 26 Washer STEEL 10 x 20 ISO 7089 <p>Follow the instruction below and observe the figures:</p> <ol style="list-style-type: none"> Take P/N TA-RICH-013 and place on the floor; Position two or more lifting slings around the particular; Take the fork lift and get the harnessed particular as close as possible to the assembled parts; With the support of operators and of the forklift, bring TA-RICH-013 in position with TA-RICH-029 and TA-RICH-030 in way to allow the assembly, and fix it with Screw M10x35; Complete the assembly fixing TA-RICH-045 and TA-RICH-046 to TA-RICH-013 by NAS1802-6-10. 	

HEAVY OPERATION (80 Kg)

COMPILED BY:	VERIFIED BY:	APPROVED BY:
I. Loi	M. Pinna	P. Coluzzi



P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 17/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi

WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.140	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 TA-RICH-031 N° 1 TA-RICH-032 N° 12 Screw NAS1802-4-13 N° 12 Washer STEEL M5 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	<p>TYPICAL 6 POS.: N°1 NAS1802-4-13 N°1 WASHER M5</p> <p>TYPICAL 6 POS.: N°1 NAS1802-4-13 N°1 WASHER M5</p>

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P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 18/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
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WORKING CYCLE PHASE	DESCRIPTION AND NOTES	IMAGES
OP.150	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 1 Assembly Lifting Tool N° 2 Bolt STEEL M24x60 ISO 4018 N° 2 Washer STEEL M24 ISO 7089 N° 4 Bolt STEEL M10 x 35 ISO 4014 N° 4 Washer STEEL 10 x 20 ISO 7089 <p>Assemble the collected items in the way represented in the figure:</p>	

HEAVY OPERATION (100 Kg)

COMPILED BY:	VERIFIED BY:	APPROVED BY:
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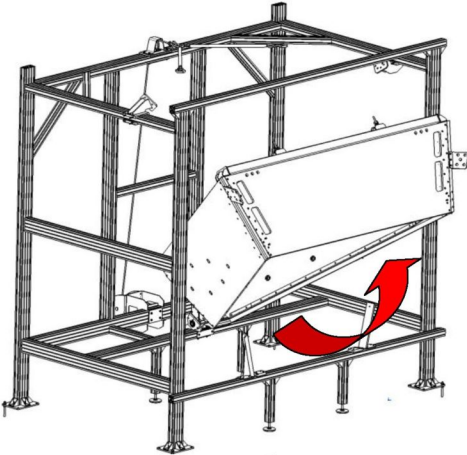
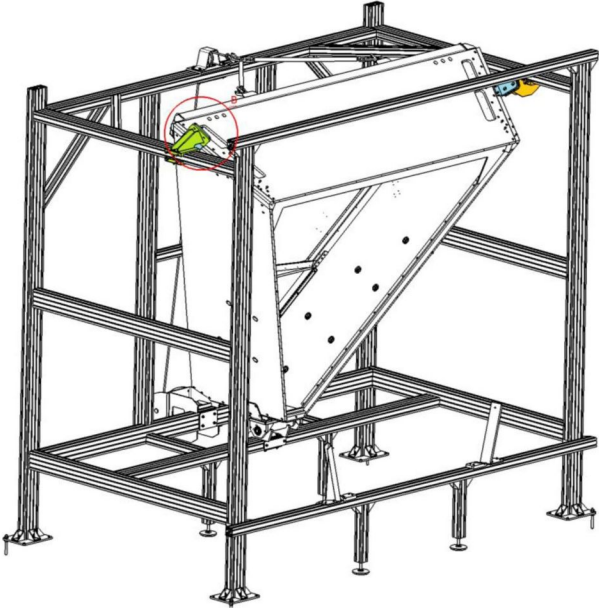
Installation & Control Scheme

Mod. 75/95/00

P/N: TA-RICH-001

DESCRIPTION: Rich CLAS12 Assembly

SHEET: 19/19

REV.	DATE	REVIEW'S REASON	MODIFIED PHASES	SIGNATURE
0	18/10/2016	FIRST EMISSION	N.A.	I. Loi
WORKING CYCLE PHASE	DESCRIPTION AND NOTES		IMAGES	
OP.160	<p>Withdraw the following items:</p> <ul style="list-style-type: none"> N° 8 Bolt STEEL 8,8 M24 x 65 ISO 4014 N° 8 Washer STEEL 8,8 M28 ISO 7089 N° 16 Washer STEEL M24 ISO 7089 N° 8 Nut STEEL 8,8 M24 ISO 4032 <p>Follow the instruction below and observe the figures:</p> <ol style="list-style-type: none"> Fix the hooks to Assembly Lifting Tool's eyebolts; Note: to ensure safety the detector should be connected to both the lifting fixture and the gantry crane. The gantry crane will effectively support the bulk of the load throughout the lift. Using Tackle System Assy lift up the RICH CLASS12 Assembly unless the Inner Plate TA-RICH-021 is parallel with the floor; Move forward Stirrup Supports TA-RICH-053, TA-RICH-054, TA-RICH-060, TA-RICH-063 until intercepting Connection Stirrups TA-RICH-027, TA-RICH-028; Using the item collected, fix the RICH CLASS12 Assembly with the Structure through the Stirrups Supports. <p>N.B. During the lifting, make sure that the movement is continuous and constant.</p> <p>N.B. Ensure proper cable winding during lifting.</p>		  <p>TA-RICH-027 TA-RICH-053</p> <p>TYPICAL 8 POS.: N°1 BOLT M24x65 N°2 WASHER M24 N°1 WASHER M28 N° 1 NUT M24</p> <p>TA-RICH-060</p>	

HEAVY OPERATION (700 Kg)

COMPILED BY:

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APPROVED BY:

P. Coluzzi