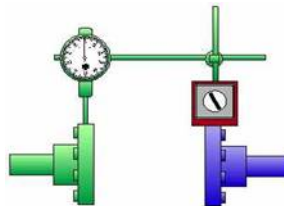


Five Essential Pre Alignment Checks

1- Check Run out

The dial indicator is affixed to any point in space: bearing housing, machine base, hub (broken coupling)

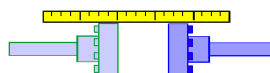
The dial indicator plunger contacts the hub or shaft to be checked



2- Rough Align

Vertical - Reference the highest hub.
Place scale firmly on the highest hub.

Raise or lower the movable shaft to within 20 mils (0.020") of the stationary hub.



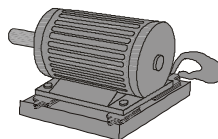
Horizontal - Reference the hub closest to you. Place scale firmly on that hub.

Move the movable hub to within 20 mils (0.020") of the stationary hub.

3- Correct Obvious Softfoot

Loosen all mounting bolts.

Find any obviously loose shim packs. Correct by adding to the loose shim packs.

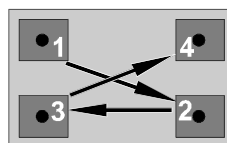


4- Establish Torque Sequence

Use at least 2 "turns" of the sequence.

No more than half tight on first "turn".

Follow sequence throughout the alignment (any time two bolts are loosened).



5 - Check Final Softfoot

Loosen one bolt at a time.

Use a 2 mil (.002") shim or feeler gauge to check.

Correct any foot with 2 mils or more softness.

Re-tighten the bolt after each check.

