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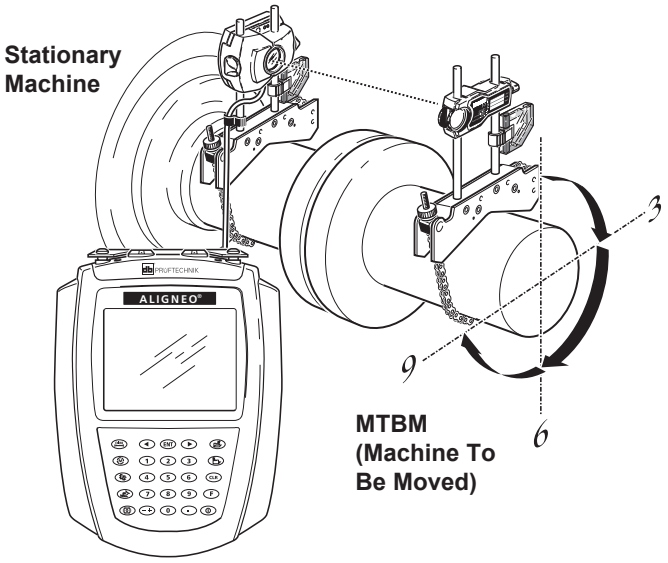
ALIGNEO®

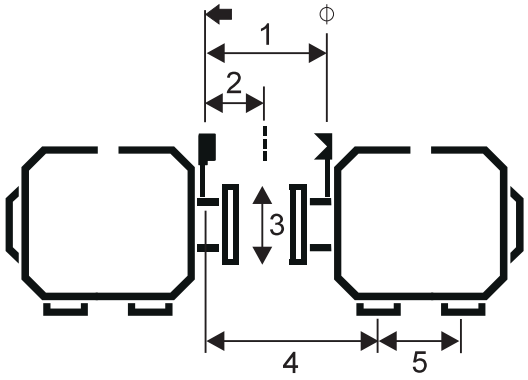
Alignment of horizontal machines

File No. _____ **Machine No. Type** _____ **Operator** _____ **Date** _____

1. Mount ALIGNEO® and switch on ⏻



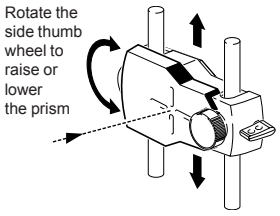
2. Enter dimensions

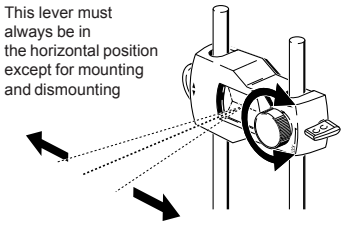


- 1. Laser to prism _____ ENT
  (Arrow point to hash mark "ϕ" on prism)
  (Center-to-center of support posts)
- 2. Laser to center of coupling _____ ENT
  (Center of flex planes)
- 3. Working diameter **10"** ENT
  (Coupling diameter) (Default value)
- 4. Laser to front foot _____ ENT
- 5. Front foot to back foot _____ ENT

3. Measure

- Adjust prism so that laser beam strikes center of the prism cap cross hair.





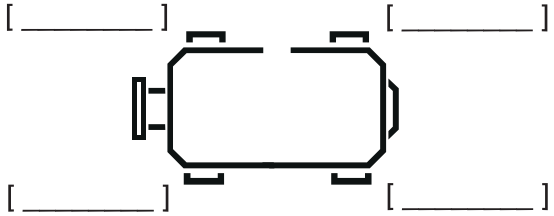
- Remove cap.
- Adjust prism until coordinates are close to 0 0.
- 0 3 6 9 will appear on the screen.
- Rotate shaft to any 45° clock position using the ALI 5.020 external inclinometer.
- Press the numker key of the clock position (e.g. 0 for 12 o'clock) and press ENT. Measure at least three of the eight clock positions, as viewed towards the stationary machine.

Go to Step 4a or 4b ➔

Soft Foot

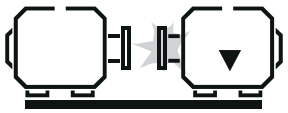
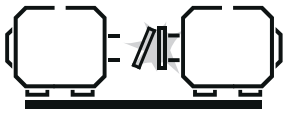
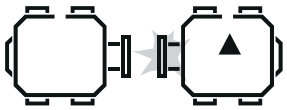
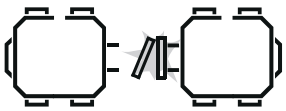
- Position shafts at either 90° or 270° (±4°).
- Adjust beam close to 0 0 if necessary. Press ENT. (Not necessary if "----" appears.)
- Press 0 then loosen the bolt, press ENT to record value then tighten bolt.
- Press ◄ or ► to move to the next foot.

Follow this procedure for all remaining feet and correct soft foot if greater than 0.002".

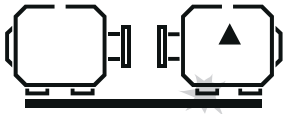
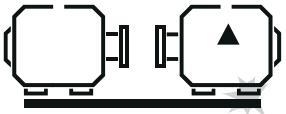
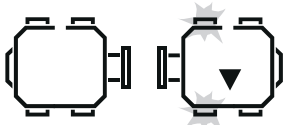
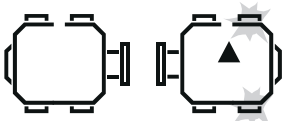


This form covers only the entry-level firmware of the ALIGNEO. Please refer to the operating manual for optional firmware features not covered on this form.

4a. Coupling Results

Vertical Offset	Vertical Gap	Horizontal Offset	Horizontal Gap
			
(+) ▲ (-) ▼	(+) (-)	(+) ▲ (-) ▼	(+) (-)
1. _____ ►	_____ ►	_____ ►	_____
2. _____ ►	_____ ►	_____ ►	_____
3. _____ ►	_____ ►	_____ ►	_____
4. _____ ►	_____ ►	_____ ►	_____
5. _____ ►	_____ ►	_____ ►	_____

4b. Foot Corrections

Front Foot Shim	Back Foot Shim	Front Foot Move	Back Foot Move
			
(+) ▲ add shims (-) ▼ remove shims	(+) ▲ add shims (-) ▼ remove shims	(+) ▲ toward 3 o'clock (-) ▼ toward 9 o'clock	(+) ▲ toward 3 o'clock (-) ▼ toward 9 o'clock
1. _____ ►	_____ ►	_____ ►	_____
2. _____ ►	_____ ►	_____ ►	_____
3. _____ ►	_____ ►	_____ ►	_____
4. _____ ►	_____ ►	_____ ►	_____
5. _____ ►	_____ ►	_____ ►	_____

5. Move

- Rotate shaft to any 45° clock position using the ALI 5.020 external inclinometer.
- Adjust beam close to 00 if necessary.
- When Enter appears press (ENT).
- Loosen bolts.
- Move machine horizontally into alignment.
- Retighten bolts.

Tolerances for Shaft Alignment

RPM	Offset (mils)		Gap (mils/10")		Spacer Shaft (mils/inch)	
	Excellent	Acceptable	Excellent	Acceptable	Excellent	Acceptable
600	5.0	9.0	10.0	15.0	1.8	3.0
900	3.0	6.0	7.0	10.0	1.2	2.0
1200	2.5	4.0	5.0	8.0	0.9	1.5
1800	2.0	3.0	3.0	5.0	0.6	1.0
3600	1.0	1.5	2.0	3.0	0.3	0.5
7200	0.5	1.0	1.0	2.0	0.2	0.3

All Speeds: Maximum Soft Foot Reading 2 mils.
Use OEM or in-house tolerances if available.

Order No. 01-208-01

02/24/2016