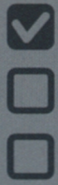


5-STEP Shaft Alignment Procedure

1



PRE-ALIGNMENT CHECKS



Safety:
Lock-out and tag-out
of the machines, etc.



Visual inspection of the
foundation, grout,
and baseplate.



Clean up: remove rust,
scale, paint, dirt from
under and around
the feet.



Replace damaged
shim packs with new,
corrosion and crush
resistant shims.



If applicable, check
foundation for flatness and
levelness before installing
or aligning machines.

2



ROUGH ALIGNMENT AND ROUGH SOFT FOOT



With all bolts loose align
machine to where it
looks aligned by eye.



With feeler gauge find
obvious gaps and fill
them with shims, taking
care of any rough soft
foot condition.

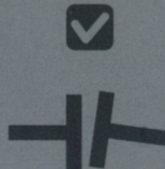


Re-tighten bolts to
100% torque.



The goal is to minimize
any coupling strain, and
ensure that the machine
is alignable.

3



INITIAL LASER ALIGNMENT CHECK



Set up laser
alignment system.



Take two sets of
measurements to
ensure repeatability.



Ensure the misalignment
is less than 0.5 mm at
the coupling.

4



FINAL SOFT FOOT CHECK WITH LASER SYSTEM



Measure, diagnose,
and correct soft foot
with the assistance of
the laser system and
feeler gauges.



0.05 mm

Aim to have all soft foot
readings within 0.05 mm.

5



FINAL ALIGNMENT TO TOLERANCE AND DOCUMENTATION



Measure and correct
alignment of the
machine to achieve
the final alignment to
the required targets
within tolerances.



Save the alignment file.



Print the report to
document
the alignment.

