



R0015327 Level Frame and quality Check

quality checks and frame levelling

 Difficulty **Medium**

 Duration **1.5 hour(s)**

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Comments

Introduction

Tools Required

2 meter straight edge
1 meter steel rule
300mm engineers level
Standard spanner set
Copper grease
Standard tap set
Tape Measure
Standard ratchet/socket set

Parts Required

Workshop consumable floor pads
D0004576e frame x 1
M12 x 100 set bolts x 4
M12 Standard nut x 4

Step 1 - Clean Threads

Clean all threads in frame using standard taps



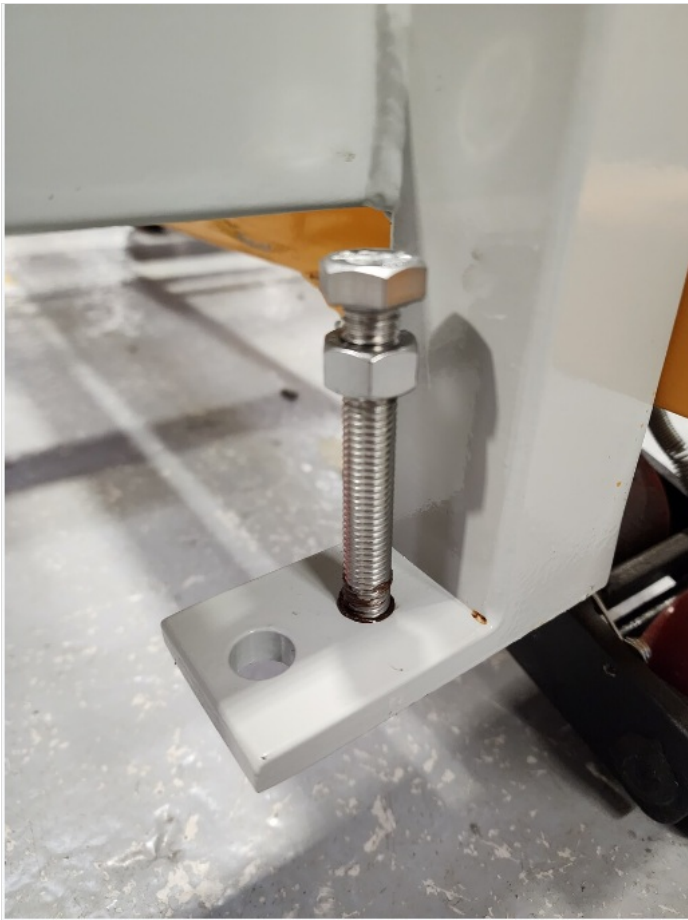




Step 2 - Add levelling bolts

Fit 4 off M12 set bolts with M12 nut and copper slip to frame for levelling

Position black levelling pads beneath each bolt



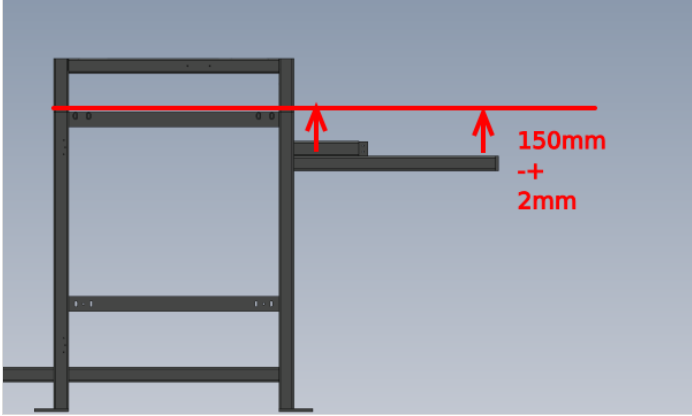




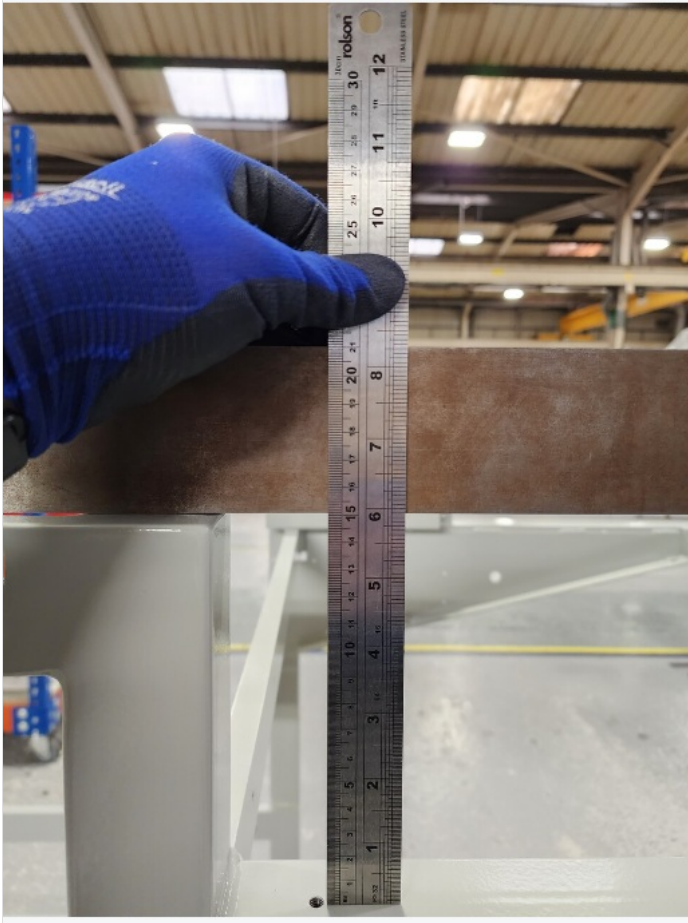
Step 3 - Check projection

check indicated projection using 2 meter straight edge
check all 4 points

150mm \pm 2mm



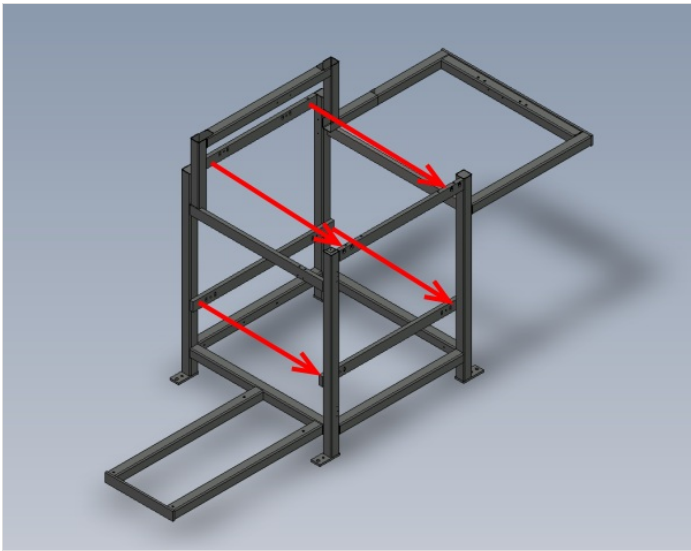




Step 4 - Check parallel

Use 1 meter steel rule or tape measure to check parallel of faces indicated

Report any deviation to supervisor

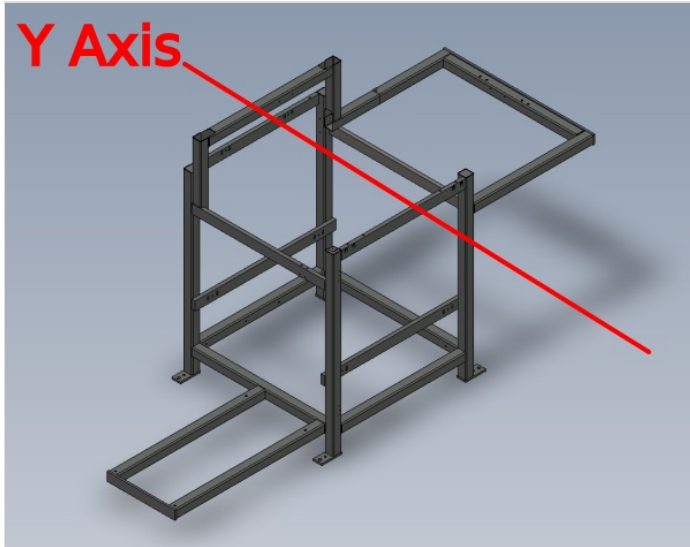




Step 5 - Level Y axis

Use M12 bolts to level frame on the Y axis . Use indicated area to set level of frame

Ensure levelling face is flat



Step 6 - Level X axis

Level X axis using indicated faces

Ensure Y axis level is maintained when adjusting X axis

Take an average over the 4 indicated points to set x axis level

