Mounting instructions for AirLoc Wedgmount® precision levelers

Please read these operating instructions carefully. The weights that are supported by these precision parts can be extremely heavy. Due to the extremely high gear ratio of the wedge construction, these loads are usually hidden and are often underestimated. Incorrect or poorly planned assembly of the Wedgmount® precision levelers can impair the performance of the machine.

The product must be in a technically flawless condition. Do not use if you notice visible damage!

### Safety instructions

- **Avoid overloading**
  - AirLoc Wedgmount® levelers are designed to support a specific load. Please consult the data sheet for the permissible maximum load of the machine foot and the Wedgmount®. Otherwise, this could damage the Wedgmount®.
  - Please note that the machine centre of gravity is off centre, this can cause the Wedgmount® to roll over on its base or its base plates on the different Wedgmount® levelers and the maximum load of the Wedgmount® as the reference for the maximum load.

- **Avoid the levering range**
  - Every Wedgmount® has a levelling range. When you reach the upper or lower limit, the leveling stud is not effective. Do not apply turn to force the leveling stud. Otherwise, this could damage the Wedgmount®.
  - Use spacers or AirLoc levelers on the spherical seating to widen the leveling range. Unnecessary!

- **Ensure an equal load on the Wedgmount®**
  - The Wedgmount® machine is usually loaded. In an eccentric load can cause the wedge to break when the Wedgmount® is in the middle position. In the worst case, this could cause the machine to tip over.

- **Level the machine before tightening the bolt-on or bolt-through Wedgmount®**
  - With a bolt-on and bolt-through Wedgmount®, first level the Wedgmount®. Then tighten the threaded fitting. Never level the machine if the threaded fitting is tightened as this could damage the Wedgmount®.

- **Mounting top-heavy machines to the floor**
  - For heavy loading, the Wedgmount® must be located as far as possible under the weight.
  - Danger of falling!
  - Use a side load or rig/drop clamp Wedgmount® to securely mount the machine to the floor.

### Free-standing VRC

1. **Installation-skid pads**
   - The AirLoc pads placed under the Wedgmount® vary in thickness according to the type of load used. The thickness of the pad must always be on the upper surface against the machine.

2. **Preparations and mounting the machine**
   - The contact surfaces of the machine and floor must be thoroughly clean. It is important that all contact surfaces have the same level and are free of any foreign particles. A raised stud in the X- and Y-direction can only be achieved on MSC-type AirLoc Wedgmount® levelers or other mounting aids, prior to transferring the load onto the Wedgmount® in their correct height position.
   - Machines that are lowered by crane must be placed onto MSC-type AirLoc Wedgmount® levelers, or onto suitable wooden blocks in order to avoid damaging the Wedgmount®. The machine is lowered onto mounting Wedgmount® levels and can then be carefully placed onto the Free-standing Wedgmount®. The final adjustment can then be carried out (please refer to the information to point 3 for the setting time).

3. **Machine support points**
   - The load should be distributed over the entire Wedgmount® leveler whenever possible. Partial or overloaded loading should be avoided.
   - If the free-standing conditions are unsatisfactory, the following variations must be observed:
     - Mounts with 3 wedges, apply the load so that the weight is distributed over the three wedges even in the loaded end and position.
     - Mounts with 4 wedges, distribute the load over the centre wedges and do not apply the load between the centre wedges.
   - Preferably, the load should be applied to the entire longitudinal length of the Wedgmount® in the direction of the weld edge.

   **CAUTION:** The load on the smaller surfaces on top of the Wedgmount® will exceed the maximum specified load of the isolation or non-skid pads.

4. **Setting time of the isolation material**
   - All isolation pads fixed under the Wedgmount® will be compressed under load. The compression process requires a certain amount of time. The machine adjustment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-levelled. We recommend regular checks of the machine alignment (min. once per year).
   - Tighten the mounts after levelling adjustment.

5. **General notes on levelling the machine**
   - Level the machine before tightening the bolt-on or bolt-through Wedgmount®.
   - With a bolt-on and bolt-through Wedgmount®, first level the Wedgmount®. Then tighten the threaded fitting. Never level the machine if the threaded fitting is tightened as this could damage the Wedgmount®.

### Bolt-on VRC / VRK / VRKCV / Jacmount® (GLRN)

1. **Preparations and mounting the machine**
   - The contact surfaces of the machine and floor must be thoroughly clean. It is important that all contact surfaces have the same level and are free of any foreign particles. A raised stud in the X- and Y-direction can only be achieved on MSC-type AirLoc Wedgmount® levelers or other mounting aids, prior to transferring the load onto the Wedgmount® in their correct height position.

2. **Avoid unbalanced load by ball head adjustment**
   - Rough machined feet or uneven ground require Wedgmount® levelers with spherical seats VRKCS with an additional spherical washer set (spherical seat DIN 5155) above the isolation disc on the stud assembly anchor bolt.

   **WARNING:**
   - Balanced and equal load and that full area coverage is ensured.

   **CAUTION:**
   - The stud assembly is fixed to the floor in accordance with the installation drawing from the machine manufacturer. The Wedgmount® levelers are inserted onto the stud assembly. Machines that are lowered by crane must be placed onto MSC-type AirLoc mounting Wedgmount® levelers, or onto suitable wooden blocks in order to avoid damaging the Wedgmount®. The machine is lowered onto the Wedgmount® levelers and can then be carefully placed onto the Bolt-on Wedgmount®. The final adjustment can then be carried out (please refer to the information to point 3 for the setting time).

3. **First complete the fine leveling then tighten**
   - Do not insert into the machine. The wedge load bears the machine in the centre position under the machine, use the AirLoc levelling stud extensions.

### Bolt-through VRC / VRK / VRKCV / Jacmount® (GLRN)

1. **Preparations and mounting the machine**
   - The contact surfaces of the machine and floor must be thoroughly clean. It is important that all contact surfaces have the same level and are free of any foreign particles. A raised stud in the X- and Y-direction can only be achieved on MSC-type AirLoc Wedgmount® levelers or other mounting aids, prior to transferring the load onto the Wedgmount® in their correct height position.

2. **Avoid unbalanced load by ball head adjustment**
   - Rough machined feet or uneven ground require Wedgmount® levelers with spherical seats VRKCS with an additional spherical washer set (spherical seat DIN 5155) above the isolation disc on the stud foot.

### Rigid clamp (without isolation)

1. **Preparations and mounting the machine**
   - The Wedgmount® machine is usually loaded. In an eccentric load can cause the wedge to break when the Wedgmount® is in the middle position. In the worst case, this could cause the machine to tip over.

2. **Avoid unbalanced load by ball head adjustment**
   - Rough machined feet or uneven ground require Wedgmount® levelers with spherical seats VRKCS with an additional spherical washer set (spherical seat DIN 5155) above the isolation disc on the stud foot.

### Socket-mounted VRKCS (Jacmount® GLRN)

1. **Assembly**
   - Screw the M24 threaded sleeves evenly into the machine base until the collar, without any thread, is protruding below the machine flange (the M24 thread on the threaded sleeve should not be pulled through the machine flange). Insert the AirLoc Wedgmount® with socket pin into the threaded sleeve and pull the cross-connection over the collar of the M24 threaded sleeve. Align the Wedgmount® to the machine flange.

2. **Preparations and mounting the machine**
   - The contact surfaces of both machine and floor must be thoroughly clean. It is important that all contact surfaces have the same level and are free of any foreign particles. A raised stud in the X- and Y-direction can only be achieved on MSC-type AirLoc Wedgmount® levelers or other mounting aids, prior to transferring the load onto the Wedgmount® in their correct height position.

   **WARNING:**
   - Balanced and equal load and that full area coverage is ensured.

   **CAUTION:**
   - The machine should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-levelled. We recommend regular checks of the machine alignment (min. once per year).

### Anchoring top-heavy machines to the floor

1. **Threaded anchor installation**
   - All isolation pads fixed under the Wedgmount® will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-levelled. We recommend regular checks of the machine alignment (min. once per year).
   - Tighten the machine after levelling adjustment.

2. **First complete the fine leveling then tighten**
   - Do not insert into the machine. The wedge load bears the machine in the centre position under the machine, use the AirLoc levelling stud extensions.

### Setting time of the isolation material

- All isolation pads fixed under the Wedgmount® will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-levelled. We recommend regular checks of the machine alignment (min. once per year).

### Disassembly

- **515.5–VRKCS:** Level the Wedgmount® to its lowest position. Insert a 3 mm stud anchor (18 mm) into the drilled hole. Use the M16 stud anchor through the drilled left-hand side of the spherical washer and the Wedgmount® in the M4 threaded sleeve drill hole. If necessary, turn the Wedgmount® so that the side with the bore holes are flush. Use the M42 threaded sleeve with the Wedgmount®.

- **Unscrew the M16 stud from the spherical washer, remo- ve the M42 threaded sleeves.**

- **Re-mount the M16 stud or screw it into the Wedgmount® to re-assemble.**
KaBloc Wedgmount® levelers

1. Preparations and mounting of the machine or its components
   Position the machine or the machine assembly as described in item 2. Mounting the machine components to the machine assembly, the height of the individual components can then be adjusted with the KaBloc Wedgmount®.

2. Mounting the anchoring brackets and fixing them to the floor
   Use lashing bolts to mount the anchoring brackets on the side, using the designated lashing holes of the KaBloc Wedgmount®. Make sure that the front ends of the anchoring brackets are touching the floor.

3. Preparing the machine
   Position the machine or the components belonging to the machine assembly. Once they are in the correct longitudinal and horizontal positions, the machine or the components can be fixed to the floor with the KaBloc Wedgmount®.

4. Preparing the machine
   Once they are in the correct longitudinal and horizontal positions, the machine or the components can be fixed to the floor with the KaBloc Wedgmount®.

5. Preparing the machine
   Position the Jacmount® so that the leveling stud can be easily reached. If all the Jacmount® Adjustment Levellers are fitted, the machine must be re-leveled. We recommend regular checks of the Jacmount® Adjustable Levellers at intervals of approximately 3 weeks after installation and, if necessary, the machine must be re-leveled. We recommend regular checks of the machine alignment (min. once per year).

6. Preparing the machine
   If all the Jacmount® Adjustment Levellers are fitted, the machine can be carefully lowered and leveled over the manual head of the special stud. When the machine is properly leveled, tighten the counter nut with washer.

7. Preparing the machine
   All vibration isolation pads fixed under the Jacmount® Adjustable Levellers will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-leveled. We recommend regular checks of the machine alignment (min. once per year).

8. Preparing the machine
   All vibration isolation pads fixed under the Jacmount® Adjustable Levellers will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-leveled. We recommend regular checks of the machine alignment (min. once per year).

9. Preparing the machine
   All vibration isolation pads fixed under the Jacmount® Adjustable Levellers will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-leveled. We recommend regular checks of the machine alignment (min. once per year).

10. Preparing the machine
    All vibration isolation pads fixed under the Jacmount® Adjustable Levellers will be compressed under load. The compression process requires a certain amount of time. The machine alignment should be checked approximately 3 weeks after installation and, if necessary, the machine must be re-leveled. We recommend regular checks of the machine alignment (min. once per year).