

Mounting instructions for KaBloc AirLoc Wedgmount® precision levelers



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

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



Machine transport

The bolt-on AirLoc Wedgmount® precision levelers, because of their protection against falling out, can remain on the machine flange and do not need to be disassembled for transport. In this case, the Wedgmount® must be kept clear, i.e. the machine must be positioned on wooden beams.

When the machine is raised, ensure that the isolation pad is not stuck to the floor or machine. Otherwise, the Wedgmount® can be pulled apart and become damaged. Observe the Wedgmount® while slowly lifting the machine. If the isolation pads are stuck to the floor, carefully release them using a rubber mallet.

General notes on leveling the machine

Machine feet surfaces that have not been machined require Wedgmount® levelers with spherical seats VRKC(V) with an additional spherical washer set (spherical seat DIN 6319) above the isolation disc on the stud assembly/anchor bolt.

The contact surfaces of both the machine and floor must be thoroughly clean.

With AirLoc Wedgmount®, the leveling stud is turned clockwise to rise the machine.

With heavy machines, it is possible under certain circumstances to adjust the Wedgmount® to the highest position before applying the load. The machine is then leveled downwards which requires considerably less force. Make sure that there is no thread play after leveling by ensuring that the last leveling adjustment is clockwise.

Position the Wedgmount® so that the leveling stud can be easily reached. If the Wedgmount® is in the centre position under the machine, use the AirLoc leveling stud extensions.

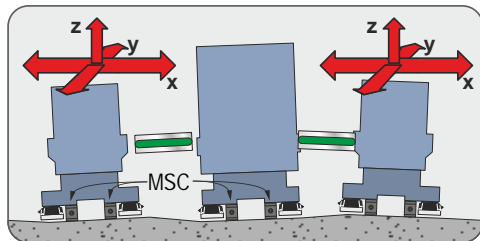
On machines where the centre of gravity is not eccentric, all the anchor points must be equally loaded and the torques on all Wedgmount® levelers must be within the same tolerance range.

With a four-point support, always work in pairs with the support points, i.e. two right, two front, two back etc. with the same number of turns.

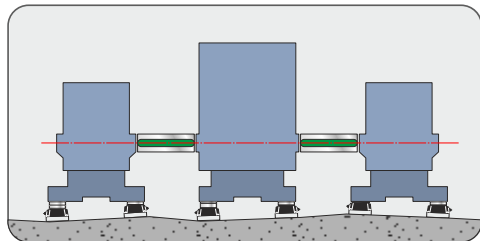
An equal, balanced load must be ensured on the Wedgmount® levelers to prevent the machine from "walking". If this is not the case, level two diagonal Wedgmount® levelers until the torques are approximately equal.

1. Preparations and mounting of the machine or its components

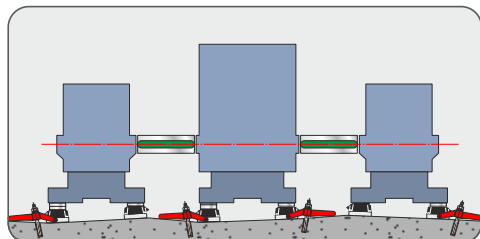
Position the machine or the components belonging to the machine assembly as described in item 2 (mounting instructions for bolt-on Wedgmount®). The components are resting on AirLoc KaBloc Wedgmount® levelers. To precisely align the longitudinal and horizontal directions of the individual components, we recommend lifting the components slightly using the AirLoc MSC-type mounting Wedgmount® levelers. Unlike the KaBloc Wedgmount®, the MSC mounting Wedgmount® levelers are not fitted with non-skid pads, which makes it easier to slide the machine sideways. Accurately align the machine components to the main machine and lower them into the new position on the MSC mounting Wedgmount® levelers.



Proceed in the same way with the remaining components of the machine assembly. Once they are in the correct longitudinal and horizontal positions, the height of the individual components can then be adjusted with the KaBloc Wedgmount®.



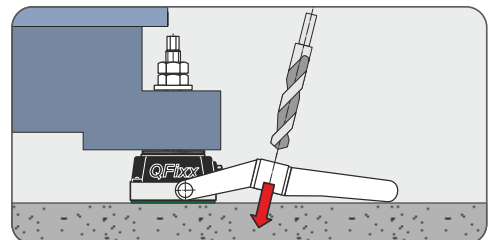
You can now test run the machine and check the alignment of all machine components. If the test run was successful, you can fix the machine components to the floor using the anchoring brackets without moving the components.



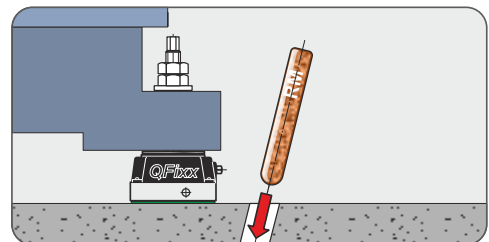
2. Mounting the anchoring brackets and fixing them to the floor

Use fastening bolts to mount the anchoring brackets on the side, using the designated fastening holes of the KaBloc Wedgmount®. Make sure that the front ends of the anchoring brackets are touching the floor.

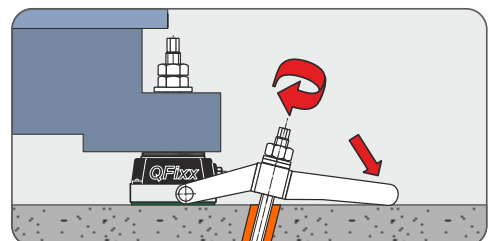
Drill holes into the floor and use the guide on the anchoring brackets to correctly maintain the tilt angle of the bore hole axis.



Then remove the anchoring brackets to drill the holes in the floor to the final size for the resin anchors. Insert the resin anchors.



Re-mount the anchoring brackets and insert the RGM studs in accordance with the instructions of the resin anchor manufacturer. As soon as the resin anchors have hardened, mount the spherical washer set and the gland nuts.



Tighten them by hand, mount the bracket stretcher and tighten it carefully. Then tighten the gland nuts to the end position (please observe the maximum pre-tension force or torque given in the data sheet).