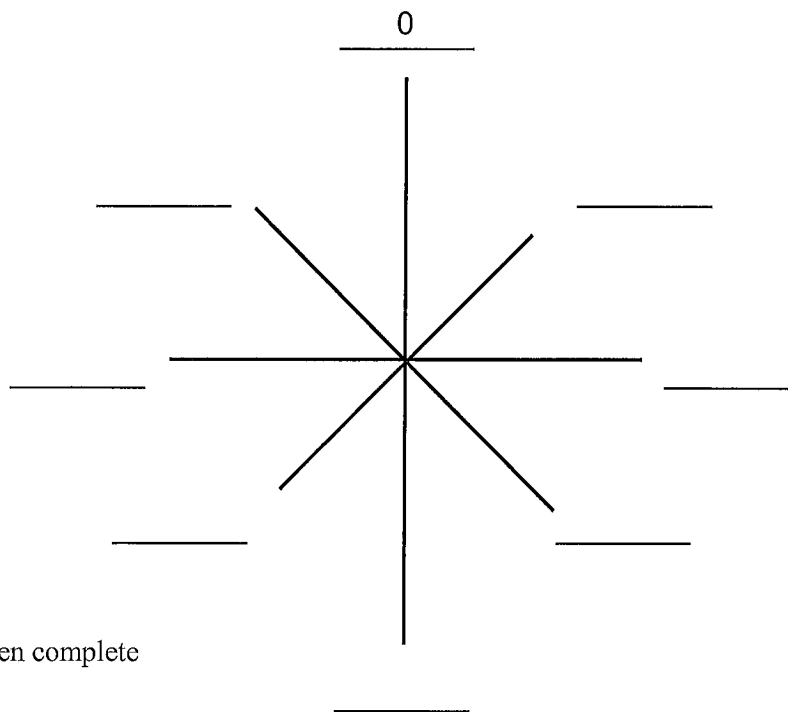


Level and Tram the Machine

(MB MODELS)

1. Center the table in the travels of both the X and the Y-axes.
2. Adjust the center leveling pads so the machine is resting on only the 4 corner pads
3. Use a precision level placed on the center of the table and adjust the pads until the machine is level side to side firmly setting on the 4 corner pads.
4. Rotate the level 90 degrees on the table and adjust the pads until the machine is level front to back.
5. Re-check the side to side level again as it may have changed while adjusting front to back. Repeat steps 6 & 7 until the machine is level in both directions.
6. Using a magnetic base with a dial indicator sweep the table to check tram. The tram should sweep within .001" over a 10" diameter sweep. Adjust leveling pads if necessary. At this stage it is more important to be level to tram and NOT level to the precision level.
7. Extend the center pads (if equipped) to the floor. The center pads should have light pressure applied to them. Be careful not to affect the level or tram while adjusting them.
8. With the level placed lengthwise along the table checking the X-axis level, move the Y-axis in and out. If there is any twist in the Y-axis, the bubble will move as Y travels in and out. Ideally there is no twist and the bubble will not move. If it does move, go back through the process and re-level the machine.



Note tram readings here when complete