



Springwood Industrial, Inc.  
1062 N. Kraemer Place  
Anaheim, CA 92806  
Tel: 714-632-9701 Fax: 714-632-9730  
<http://www.acergroup.com>

[info@acergroup.com](mailto:info@acergroup.com)

Klim Industrial, Inc.  
244 N. Randolphville Road  
Piscataway, NJ 08854  
Tel: 732-752-9100 Fax: 732-752-9101  
<http://www.acergroup.com>

[acer\\_klim@yahoo.com](mailto:acer_klim@yahoo.com)

## PROCEDURE TO LEVEL MACHINE

1. Home machine on 3 axes, X, Y, Z. Move table to center

2. Put the leveling pad under the machine. Adjust the foundation bolt and nuts to make the foundation bolts located within the indentation of the pad. (See Fig. 1)

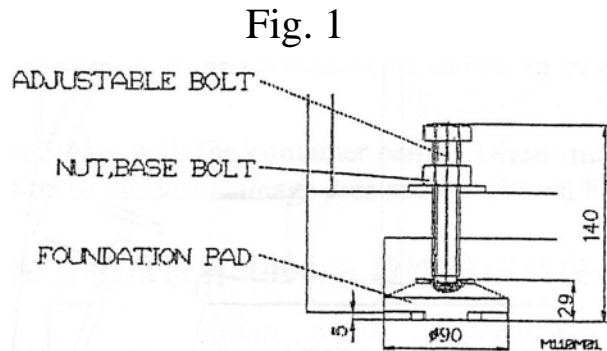
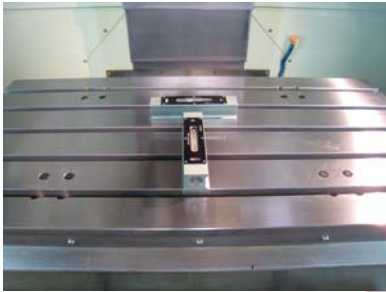


Fig. 2



3. Clean the table surface and put two precision levels 0.0001"/10"  $\approx$  2 sec. on table. (See Fig. 2) Adjust the four corner foundation bolts ensure the bubbles of the level gauge in the middle position and keep the deviation within a half of a graduation.

4. Move the Y-axis saddle to the front. Adjust the front foundation screws. Then move saddle to the back and adjust the back foundation screws. Repeat steps if necessary. Make sure the different value between the front and back position are within  $\pm 0.05\text{mm}$ . (See Fig. 3)

Fig. 3



5. Move X-axis (table) to left, adjust left foundation screws. Move X-axis (table) to right (See Fig. 4), adjust right foundation screws. Repeat same procedure to ensure the different value between left and right position within  $\pm 0.05\text{mm}$ . (See Fig. 5)

Fig. 4

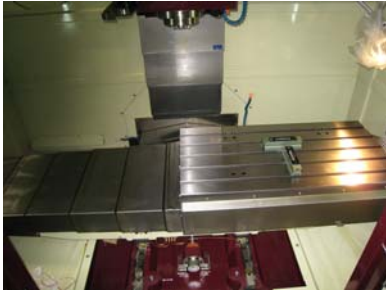
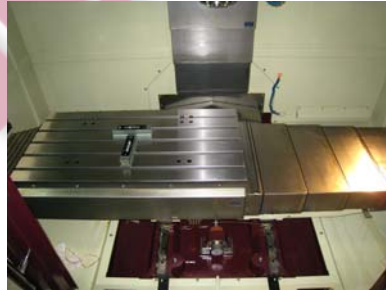


Fig. 5



6. Adjust the center screw to touch the leveling pad. (See Fig. 6)

Fig. 6



7. Tighten all the bolts with nut.