

5-STEP SHAFT ALIGNMENT PROCEDURE



LUDECA

1



Pre-Alignment Checks



Safety:
Lock-out and tag-out of the machines, etc.



Visual inspection of the foundation, grout, and baseplate.



Clean up: remove rust, scale, paint, dirt from under and around the feet.



Replace damaged shim packs with new, corrosion and crush resistant shims.

2



Rough Alignment and Rough Soft Foot



With all bolts loose align machine to where it looks aligned by eye.



With feeler gauge find obvious gaps and fill them with shims, taking care of any rough soft foot condition.



Re-tighten bolts to 100% torque.



The goal is to minimize any coupling strain, and ensure that the machine is alignable.

3



Initial Laser Alignment Check



Set up laser alignment system.



Take two sets of measurements to ensure repeatability.



<15mils (thou)

Ensure the misalignment is less than 15 mils (thou) at the coupling.

4



Final Soft Foot Check with Laser System



Measure, diagnose, and correct Soft Foot with the assistance of the laser system and feeler gauges.



2mils (thou)

Aim to have all soft foot readings within 2 mils (thou).

5



Final Alignment to Tolerance and Documentation



Measure and correct alignment of the machine to achieve the final alignment to the required targets within tolerances.



Save the alignment file.



Print the report to document the alignment.