

How to leveling the machine

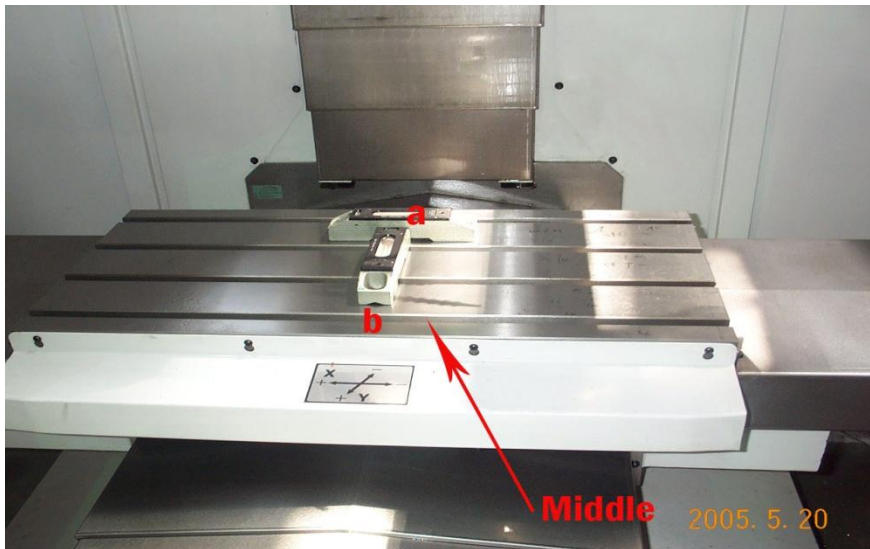
I. Machine Leveling

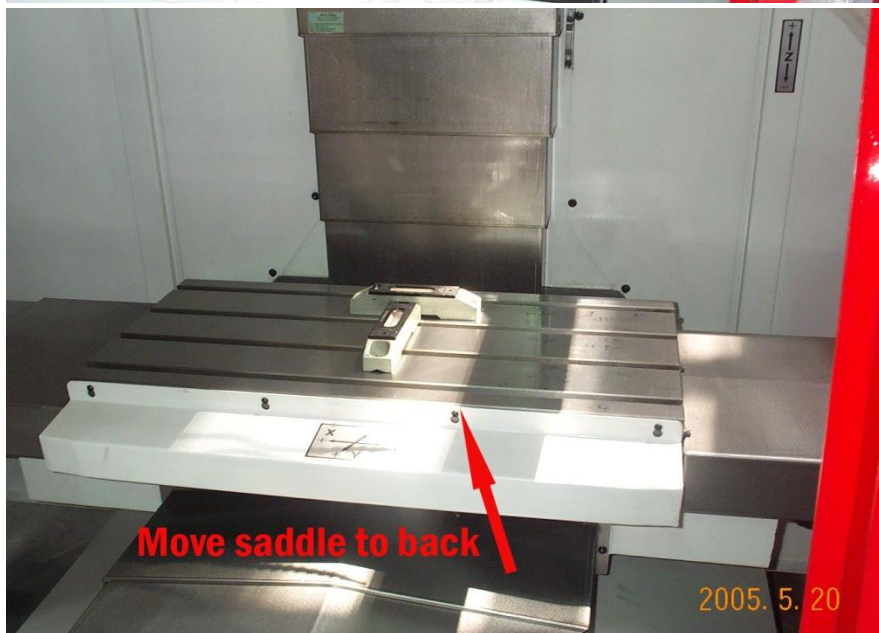
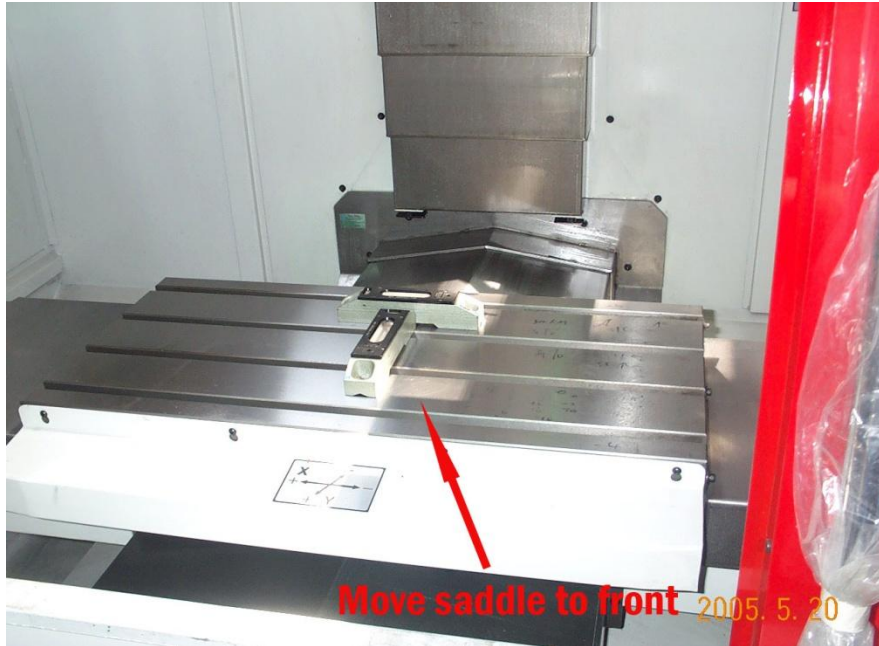
1. Choice the correct size leveling pad put under the machine and put adjusting screw as pic 1 shown, adjust the screw to let it touch to pad, move the table to center of the saddle.

leveling pad and screws



2. Put the precise leveler on table as picture, one front /back, and one left /right, first adjust 4 corner adjust screws, wait till see all the 2 leveler air bubble in middle, then move the saddle to front, adjust front screws, then move the saddle to the back adjust the back screws, repeat to sequence as necessary and ensure all the travel is within +/- half degree.





3. Adjust the center adjust screws to touch the level pad.

II. Table Flatness (x axis 0.06 mm / 1000 mm 、 y axis 0.0 mm / 1000 mm), hand scraping inspection (x axis 0.0 inward, y axis 0.03 mm inward)

1. Move x and y axis to the center of the base.
2. Put the leveler to check the x axis as picture 1.
3. Put the leveler to check the x axis as picture 2.
4. Leveler per degree 0.02mm/m