

# **LEVELING PROCEDURE FOR OUTRIGGERS**

## **FOR VB-80/100**

For added rigidity and better machine performance Fryer Machine Systems recommends that the machine itself and the right and left outriggers be securely bolted to the floor of your facility.

Due to variations in casting design we are unable to give exact dimensions on where each mounting bolt should be located. This must be done on a machine-to-machine basis.

Each step must first be completed on both sides before moving to the next step.

First: The machine must be leveled. In our facility we use a precision level accurate to within .0005 over 12". A level of that caliber or better will be more than adequate for the set up process of your machine.

Second: After the machine is leveled you will need to place the outriggers into position. The two Outriggers as well as the four locating brackets will be marked as to which side is which and also Front and rear. The two outriggers must be placed under the saddle supports but not making Contact with the linear roller bearing.

Third: Each bearing on the saddle supports is on its own way. To start the roller bearings must be Pushed as far in toward the center of the saddle support as possible while still being able to Securely tighten the lock nut on the threaded rod. Doing this will give you as much adjustment As possible to eliminate any table rock that will occur when the table is moved from side to side.

Fourth: Move the X-axis into the middle of its travel. Place a .002 piece of shim stock in between the roller bearing and the outrigger way. Slowly raise the outrigger with the leveling bolts until there is some friction between the shim and the roller bearing. While doing this you must be sure to keep the outrigger running parallel with The Y-axis. This can be checked by placing an indicator base on the saddle, the needle on the way of the outrigger and running the Y-axis back and forth over the full travel. If this is not done Serious damage could result.

Fifth: After you have some friction between the shim and the roller bearing; remove the shim. Now you Will need two indicators. One must be placed on the front of the saddle with the needle on the outrigger way and the second on the back of the saddle with the needle also on the way. After this Set up is done move the X axis from the middle of the travel to the end of the travel on the side that The indicators are set up on. The numbers you see on the indicators is the amount of table rock. The table rock can be taken up pulling the roller bearings out towards the front and rear of the Machine. This will put more pressure between the outrigger way and the roller bearing. Make small adjustments and re-check the table rock after each adjustment. When the correct Amount of pressure is applied the resulting table rock amount should be from .002-.004. If you find that you can not adjust the bearing enough to achieve the desired number you can Also raise the outrigger with the leveling bolts some more.(Be sure to keep the outrigger running Parallel with the Y axis.)

After these steps are completed you should be able to move your axis around with no problem. We recommend that some grease be applied the way surface to lubricate the roller bearing. Also the table rock should be rechecked and adjusted if need be about one week after installation.

If you have any questions, comments or concerns please feel free to call Fryer Machine Systems at 1-800-776-8877.

(OUTRIGGER LEVEL-030801)