

Horizontal Move Function at 7:30













Can't set Optalign at 1:30 clock position?




Normally the MOVE function requires you to set the system at the 1:30 clock position to monitor the MTBM as it is moved laterally. This note enables you to use the MOVE function with the system set at the 7:30 clock position instead of 1:30. This is useful when it is impossible to position the system at 1:30.

i) Move in opposite direction from the signs and arrows shown on the display (and in the direction Optalign suggested in step "b".) Continue moving until number shown in the display is close to 000.0.

Overview

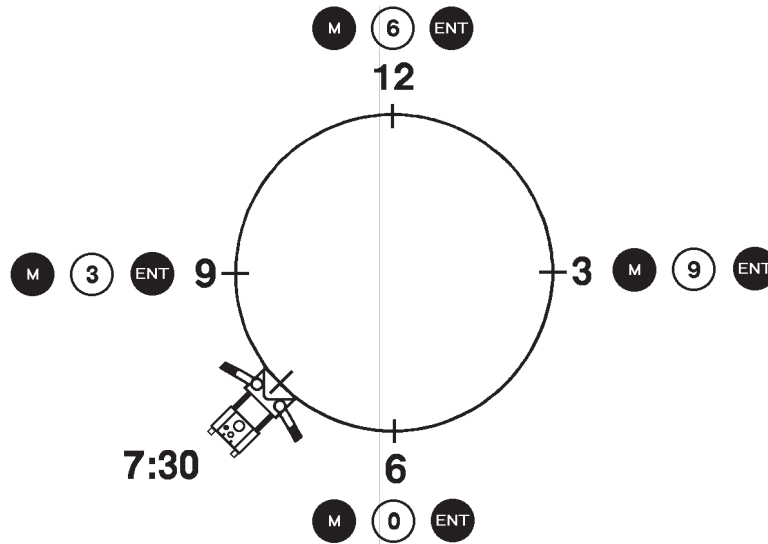
- a) Take readings as in a regular alignment.
- b) Record horizontal moves paying special attention to the **direction** of the displayed moves.
- c) Retake readings as follows:

<u>Position</u>	<u>Keystrokes</u>
12:00	 ,  , 
3:00	 ,  , 
6:00	 ,  , 
9:00	 ,  , 




- d) , record horizontal feet corrections. The value of these corrections should be the same as in step "b", but with opposite sign.
- e) 
- f) Position laser and prism at the 7:30 clock position.
- g) Zero coordinates (0.00.0).
- h) 

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Move at 7:30 Procedure

- 1) **ON**, , **ENT**
- 2) Enter machine dimensions.
- 3) Zero system at 12:00 o'clock.
- 4) Take readings, , **0**, **ENT**, etc.
- 5) **RUN**, record feet corrections. *Pay special attention to the **direction** of the moves.*
- 6) , enter coupling center to prism distance, **ENT**
- 7) Enter 10" DIA. **1**, **0**, **ENT**
- 8) **RCL**, **RCL**, **RCL**
- 9) Record coupling results.

If from the misalignment of the coupling, you decide to make a horizontal move, before making any moves:

10) Retake readings as follows: (see picture above)

<u>Position</u>	<u>Keystrokes</u>
12:00	 , 6 , ENT
3:00	 , 9 , ENT
6:00	 , 0 , ENT
9:00	 , 3 , ENT

- 11) **RUN**, record feet corrections. These should be the same as in step 5 but with opposite sign.
- 12) **MOVE**
- 13) Position system at the **7:30** clock position
- 14) Adjust screen values to zero (0.00.0)
- 15) **MOVE**
- 16) Move in opposite direction from the signs and arrows shown on the display (and in the direction Optalign suggested in step 5). Continue moving until the number shown in the display is close to 000.0.
- 17) Recheck alignment and repeat steps 4 to 17 as necessary.

VO = Vertical Offset
 HO = Horizontal Offset
 VA = Vertical Angularity
 HA = Horizontal Angularity

VF = Front Foot shimming
 VB = Back Foot shimming
 HF = Front Foot Move
 HB = Back Foot Move

Example:

System RPM = 3800

After taking alignment in the regular way we obtain the following results:

VF = 1.0	VB = 1.0
HF = -8.0	HB = -33.5
VO = -1.0	HO = -4.5
VA = 0	HA = -36

Feet corrections show both front and back must be moved towards **9** o'clock (negative correction). Retake alignment readings in at least 3 clock positions as follows:

<u>Position</u>	<u>Keystrokes</u>
12:00	M, 6, ENT
3:00	M, 9, ENT
6:00	M, 0, ENT
9:00	M, 3, ENT

Results

VF = -0.5	VB = -1.0
HF = 7.5	HB = 33.0

Press **MOVE**, Set system at **7:30** clock position, (0.00.0), press **MOVE**.

Slide MTBM toward **9** o'clock. Numbers on the screen *will decrease* toward 000.0.