

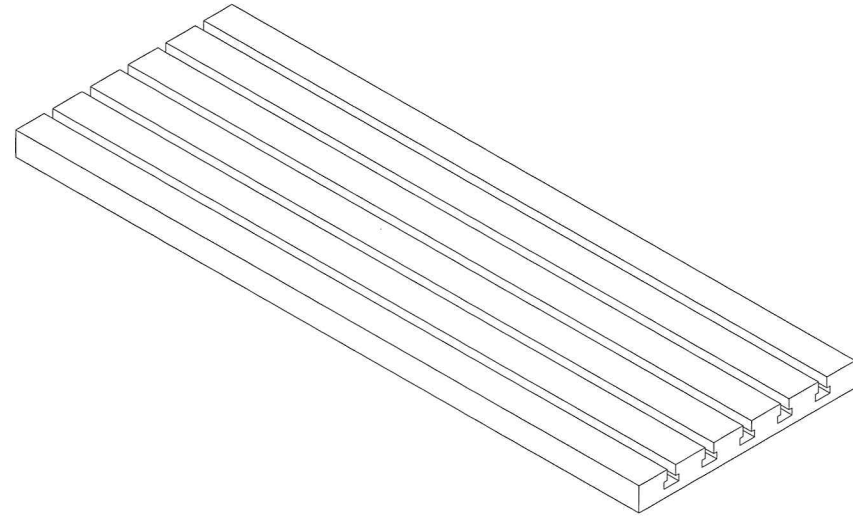
## Multi-Plate Foundation Set-Ups

### STEP 1

#### Prep Table

Clean and stone machine table and bottom of Foundation.

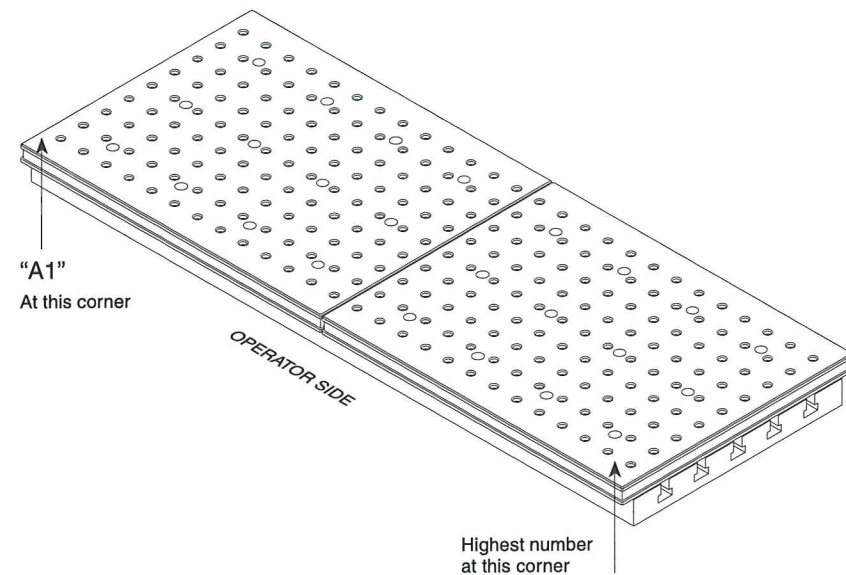
Apply a thin layer of multi-purpose grease to the machine table.



### STEP 2

#### Position Plates

Position Foundations on the machine table. The plates must be installed so the alpha-numeric labeling begins with "A1" at the front left corner. The plates should then be positioned so the numeric labeling increases sequentially.

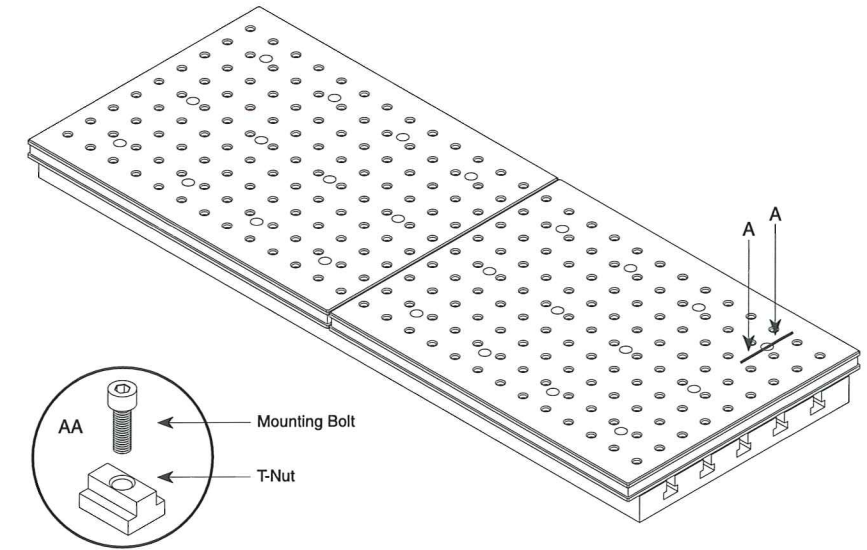


## Multi-Plate Foundation Set-Ups

### STEP 3

#### Engage Mounting Hardware

Adjust the plates to allow engagement of the mounting bolts with the T-nuts (Both Provided). Most tables allow the nuts to be slid into position as needed with a long dowel rod. Some tables do not have T-slots that run through the ends of table. In these instances the T-nuts must all be positioned prior to placing the plates on the machine table. Engage, but do not tighten the mounting bolts at this time.



### STEP 4

#### Align First Plate

Align the grid pattern of the far left plate to the machine axes. Remove plugs from two bushed holes along any row (within the machine travels) and find the center of each bushing using a test dial indicator placed in the machine spindle. The plate should be adjusted so there is no more than 0.005mm (.0002") variation in the Y-axis coordinates. Once square, tighten the mounting bolts (60 Ft-Lb for M12 or 1/2-13 SHCS).

