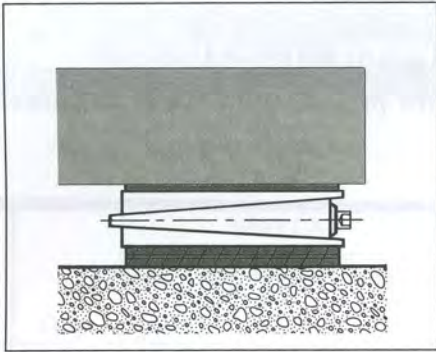


AIRLOC WEDGMOUNTS

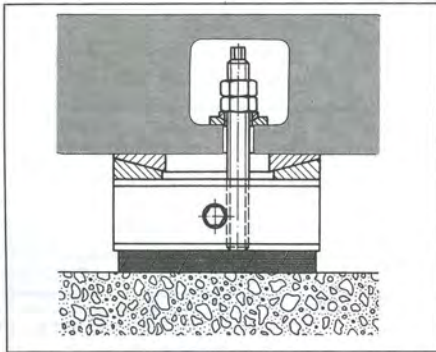
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Wedgmount® Precision Levelers

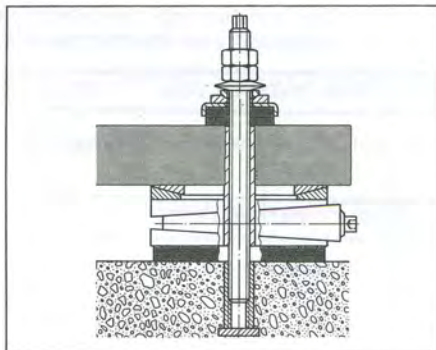
VRC-Compact



VRKC-Compact



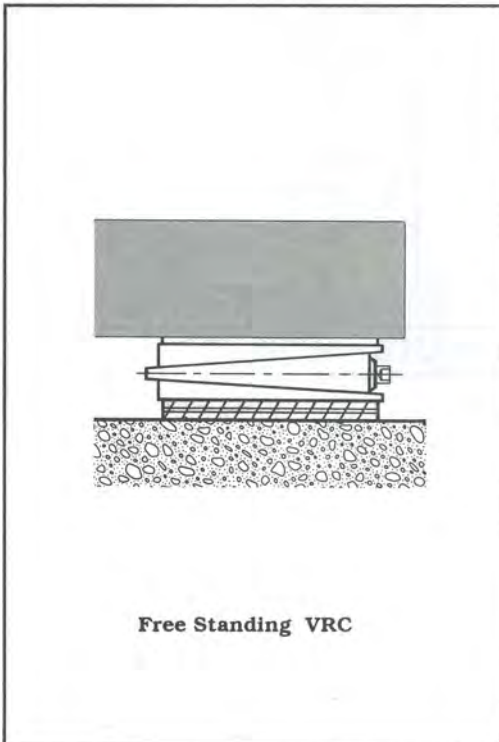
VRKC-Compact



VRC - Compact is the designation for the new generation of Wedgmount Precision Levelers with optimal characteristics.

FEATURES

- Fine adjustment - up or down - under full load - to 0.0004"
- More compact through elastic vertical blocking.
- Transverse stability through pre-tensioned wedges.
- Longitudinal stability through self-lock wedges .Outer and middle wedge are permanently and rigidly connected. connected.
- Low overall height , cast iron construction.
- The natural frequency of the wedgmount precision leveler is adjustable.



VRC/A 4-17-4 PAD BOTTOM / SL PAD TOP

Most popular combination for all type Machine tools.
Excellent isolation , dampening and non- skid properties.

VRC/B 4-17-0 PAD BOTTOM / SPO PAD TOP

Very good non-skid properties, minimal deflection. Especially suited for turning, grinding and transfer machines, etc.

VRC/D 4-17-4 PAD BOTTOM / 4-17-4 PAD TOP

For high impact machinery , punch presses , shears , etc.

VRC/E SPO PAD BOTTOM / SPO PAD TOP

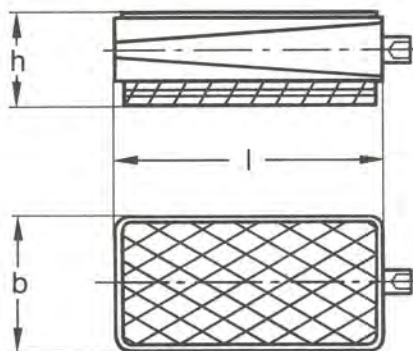
For leveling only , no vibration control
Excellent non- skid properties.

VRC/HD 4-17-50 PAD BOTTOM / SPO PAD TOP

Excellent dampening qualities for heavy loads.

VRC/K 4-17-6 PAD BOTTOM / SPO PAD TOP

Used for the lifting capacity of the mount only.



VRC 3 PIECE CONSTRUCTION

VRC COMPACT WEDGMOUNTS SPECIFICATIONS

Type	l (ins.)	b (ins.)	Height (h) per / pad type			Leveling Range (ins.)	Max. Load Cap - Lbs per Wedgmount Type.					
			A (ins.)	B/K (ins.)	D (ins.)		A	B	D	E	HD	K
1 VRC	4.13	2.17	2.36	2.17	2.60	+ 1/8" - 1/4"	1000	1500	1000	3400	2500	4500
2 VRC	5.91	2.95	2.36	2.17	2.60	+ 3/16" - 3/16"	2000	3000	2000	6800	5000	9000
3 VRC	7.87	3.74	2.68	2.48	2.91	+ 1/4" - 1/4"	3500	5000	3500	11300	8300	14500
4 VRC	7.87	7.87	2.68	2.48	2.91	+ 1/4" - 1/4"	6500	10000	6500	22500	17500	31000
6 VRC	4.53	9.84	3.62	3.43	3.86	+ 1/4" - 3/8"	5000	7500	5000	18000	12000	21000
7 VRC	6.89	9.06	3.62	3.43	3.86	+ 5/16" - 3/8"	6500	10000	6500	22500	17500	31000

THE FOLLOWING SOCKET WRENCHES ARE REQUIRED TO LEVEL VRC MOUNTS

1VRC - 6MM MALE HEX HEAD

6VRC - 14MM MALE HEX HEAD

2VRC - 10MM MALE HEX HEAD

7VRC - 17MM MALE HEX HEAD

3VRC - 12MM MALE HEX HEAD

8VRC - 14MM MALE HEX HEAD

4VRC - 12MM MALE HEX HEAD

10VRC - 19MM MALE HEX HEAD

(IF USING A 12.8 MM DRIVE RATCHET WRENCH)

VRC - Compact - Jumbo - Precision- Leveling Wedgmounds are particularly suitable for freestanding installations of large presses and similar heavy duty machinery. Types 11VCR - and 12VCR are available in bolt-on and bolt-thru models

FEATURES

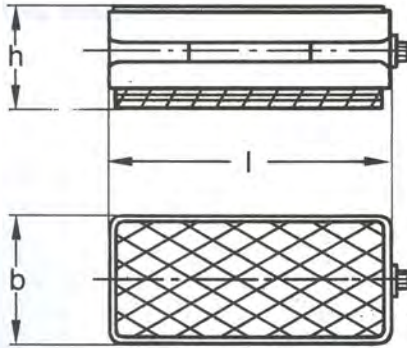
- Fine adjustment - up or down - under full load - to 0.0004"
- High coefficient of friction of Airloc prevents machine shifting.
- Different type pads allows various degrees of isolation efficiency.
- Constant leveling is ensured
- Qucikly installed-flexable system- economical.



Free Standing - Jumbo - Wedgmount
10-VRC / G

VRC/B	4-17-0	PAD BOTTOM	/	SPO PAD TOP
VRC/E*	SPO	PAD BOTTOM	/	SPO PAD TOP
VRC/G	4-17-4	PAD BOTTOM	/	SPO PAD TOP
VRC/HD	4-17-50	PAD BOTTOM	/	SPO PAD TOP
VRC/K	4-17-6	PAD BOTTOM	/	SPO PAD TOP

* only non-skid use



VRC 4 PIECE CONSTRUCTION

VRC - COMPACT JUMBO - WEDGMOUNTS SPECIFICATIONS

Type	. l (ins.)	b (ins.)	Height (h) per / pad type					Leveling Range (ins.)	Max. Load Cap - Lbs per Wedgmount Type.				
			B (ins.)	E (ins.)	G (ins.)	HD (ins.)	K (ins.)		B	E	G	HD	K
5 VRC	9.84	4.53	3.43	2.95	3.46	3.86	3.43	+ 0.31" - 0.28"	7500	18000	5000	12000	21000
8 VRC	10.04	8.07	3.43	2.95	3.46	3.86	3.43	+ 0.31" - 0.28"	13500	34000	9000	22500	33700
10 VRC	14.60	9.06	3.43	2.95	3.46	3.86	3.43	+ 0.51" - 0.28"	22500	56000	15000	38000	56000
11VRC	19.75	11.88	3.43	2.95	3.46	3.86	3.43	+ 0.47" - 0.16"	40500	100000	27000	67000	112000
12 VRC	25.59	15.75	5.79	5.31	5.83	6.22	5.79	+ 0.63" - 0.16"	67000	175000	45000	112000	220000

THE FOLLOWING SOCKET WRENCHES ARE REQUIRED TO LEVEL VRC MOUNTS

5VRC - 14MM MALE HEX HEAD

11VRC - 19 MM MALE HEX HEAD

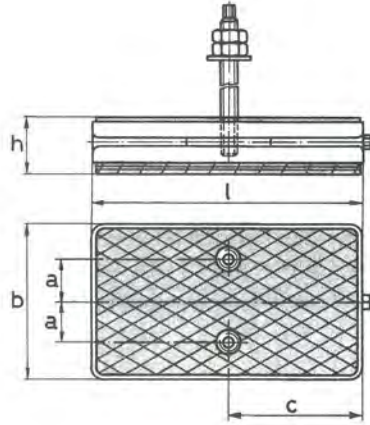
8VRC - 19MM MALE HEX HEAD

12VRC - 24 MM MALE HEX HEAD

10VRC - 19 MM MALE HEX HEAD

(IF USING A 12.8 MM DRIVE RATCHET WRENCH)

11 .1 & 12 .1 JUMBO VRC BOLT -ON WEDGMOUNTS WITH VARIOUS PAD SELECTIONS

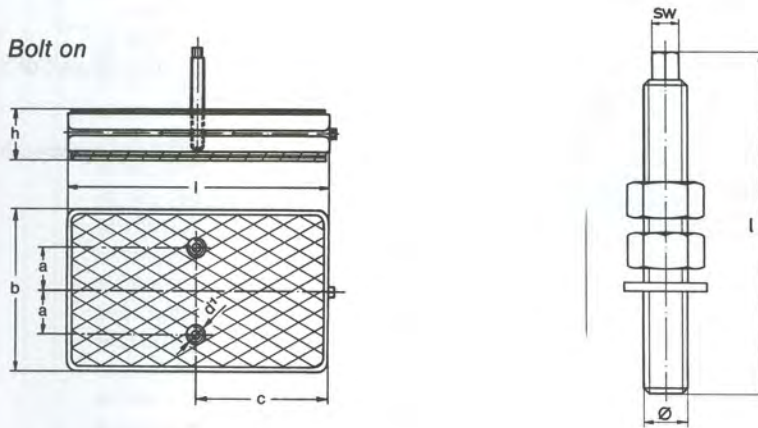


Type	l (ins.)	b (ins.)	a (ins.)	c (ins.)	inner Thd (mm.)	Height (h) per / pad type				Leveling Range (ins.)	Max. Load Cap - Lbs per Wegmount		
						B (ins.)	E / K (ins.)	G (ins.)	HD (ins.)		B (lbs.)	E / K / HD (lbs.)	G (lbs.)
11.1 VRC	19.93	11.99	3.18	9.96	M24	3.45	2.98	3.49	3.89	+ 0.48" - 0.16"	40500	56000	27000
12.1 VRC	25.81	15.88	4.37	12.90	M30	5.84	5.36	5.88	6.27	+ 0.64" - 0.16"	67000	112000	45000

- VRC/B 4-17-0 PAD BOTTOM / SPO PAD TOP
- VRC/E* SPO PAD BOTTOM / SPO PAD TOP
- VRC/G 4-17-4 PAD BOTTOM / SPO PAD TOP
- VRC/HD 4-17-50 PAD BOTTOM / SPO PAD TOP
- VRC/K 4-17-6 PAD BOTTOM / SPO PAD TOP

* only non-skid use

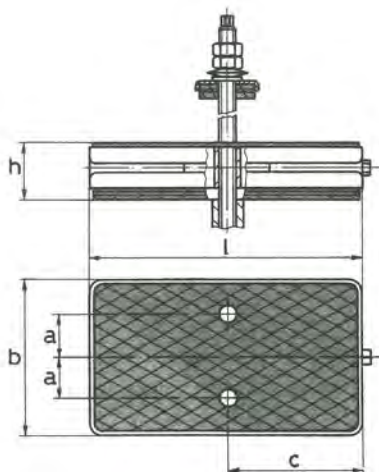
11 .1 & 12 .1 JUMBO VRC BOLT -ON WEDGMOUNTS WITH STUD SELECTIONS



Studs for VRC Jumbo BOLT-ON Wedgmounds

Type VRC	Tapped Hole d1	SW mm	Stud lgth l mm
11.1 VRC	M24	17mm	M24 x 200
12.1 VRC	M30	17,m	M30 x 200

11 .2 & 12 .2 JUMBO VRC BOLT -THRU WEDGMOUNTS WITH VARIOUS PAD SELECTIONS



Jumbo VRC bolt-thru

11.2-, 12.2-VRC

Recommended stud type S.

- The isolation washers are part of the standard delivery.

- Anchoring normally executed with dowel

- To be ordered separately:

Type	l (ins.)	b (ins.)	a (ins.)	c (ins.)	Bore Hole (mm.)	Height (h) per / pad type				Leveling Range (ins.)	Max. Load Cap - Lbs per Wegmount		
						B (ins.)	E / K (ins.)	G (ins.)	HD (ins.)		B (lbs.)	E / K / HD (lbs.)	G (lbs.)
11.2 VRC	19.93	11.99	3.18	9.96	26	3.45	2.98	3.49	3.89	+ 0.48" - 0.16"	40500	56000	27000
12.2 VRC	25.81	15.88	4.37	12.90	26	5.84	5.36	5.88	6.27	+ 0.64" - 0.16"	67000	112000	45000

VRC/B 4-17-0 PAD BOTTOM / SPO PAD TOP

VRC/E* SPO PAD BOTTOM / SPO PAD TOP

VRC/G 4-17-4 PAD BOTTOM / SPO PAD TOP

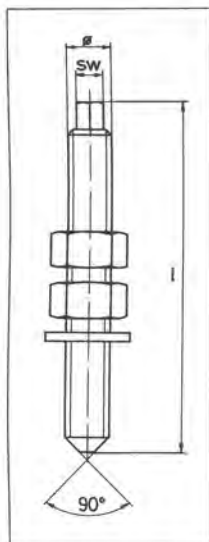
VRC/HD 4-17-50 PAD BOTTOM / SPO PAD TOP

VRC/K 4-17-6 PAD BOTTOM / SPO PAD TOP

* only non-skid use

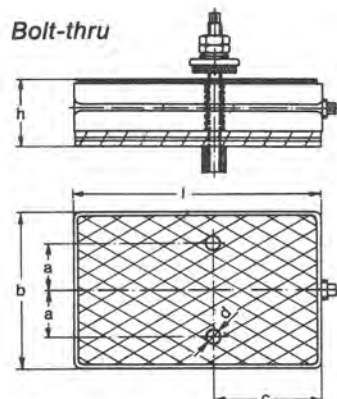
11 .2 & 12 .2 JUMBO VRC BOLT - THRU WEDGMOUNTS WITH STUD SELECTIONS

Type S complete, galvanised
for bolt-thru Wedgmount Precision Levelers.



Dimensions in mm		SW
Dimension	$\phi \times l$	
M 12 x 150		8
M 14 x 150		10
M 16 x 150		10
M 16 x 200		10
M 16 x 300		10
M 18 x 150		13
M 18 x 200		13
M 18 x 300		13
M 20 x 150		13
M 20 x 200		13
M 20 x 300		13
M 24 x 150		17
M 24 x 200		17
M 24 x 300		17
M 30 x 200		19

Size of stud depends on hole ϕ in machine foot.

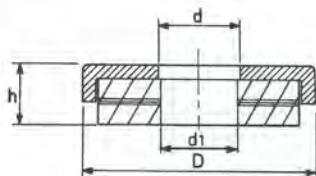


VRC	Bore ϕd mm	Recommended stud size
11.2	30	M 24
12.2	40	M 30

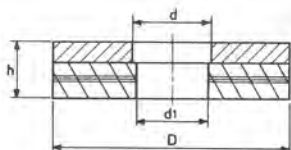
Isolation Washers

together with anchoring bolt (stud), disc springs, isolation tube form the AirLoc anchoring system bolt-thru AirLoc Wedgmount Precision Levelers.

Type N / G



Type J / K / L



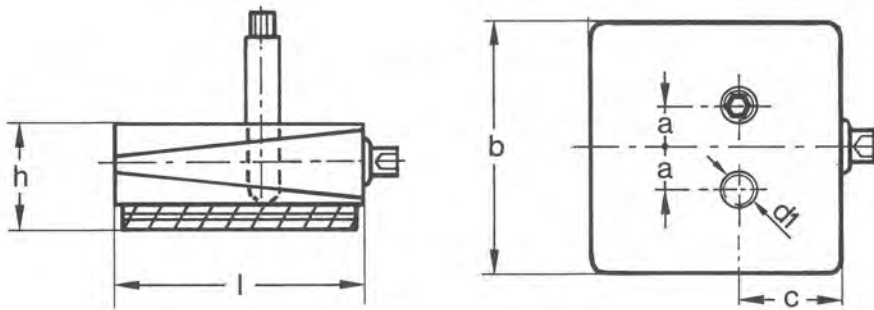
Type	suitable for studs	Dimensions in mm			
		D	d	d 1	h
N 6	M 16 / M 18 / M 20	60	22	20	17
G 6	M 20 / M 22 / M 24	70	26	24	17
J 6	M 27 / M 30 / M 36	110	38	36	22
K 6	M 39 / M 42 / M 48	160	51	48	24
L 6	M 52 / M 56 / M 60	180	62	60	24

VRC COMPACT BOLT-ON WEDGMOUNTS

The upper side is plain and is used where the precision leveler and the machine must form a unit. The Airloc material (4 / 0 / 50 / 6 / 6C*) rests on the floor. The unit is bolted to the machine base by type P stud.

One type P - stud is necessary for one VRC Precision Wedgmount Leveler. The threaded hole should be selected to place the Wedgmount in the ideal position with regard to the machine base.

VRC - Compact BOLT - ON



Type VRC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d1 inner Thd (mm.)	Height (h) per / pad type			Leveling Range (ins.)	Max. Load Cap per Wedgmount in lbs			
						4 (ins.)	0 / 6 / 6C* (ins.)	50 (ins.)		4 (lbs.)	0 (lbs.)	50 (lbs.)	6 / 6C* (lbs.)
202-VRC/*	4.57	4.57	1.07	2.28	M16	2.22	2.18	2.62	+0.16" -0.20"	2300	3400	5600	9000
203-VRC/*	5.50	5.50	1.07	2.78	M16	2.42	2.38	2.82	+0.24" -0.24"	3400	5000	8500	13500
204-VRC/*	6.75	6.75	1.07	2.70	M20	2.70	2.66	3.10	+0.20" -0.32"	5000	7400	13400	18000
205-VRC/*	7.15	9.13	1.07	3.57	M20	3.06	3.02	3.45	+0.36" -0.36"	7200	10800	18000	27000

ORDER EXAMPLE : 204 -VRC / 6

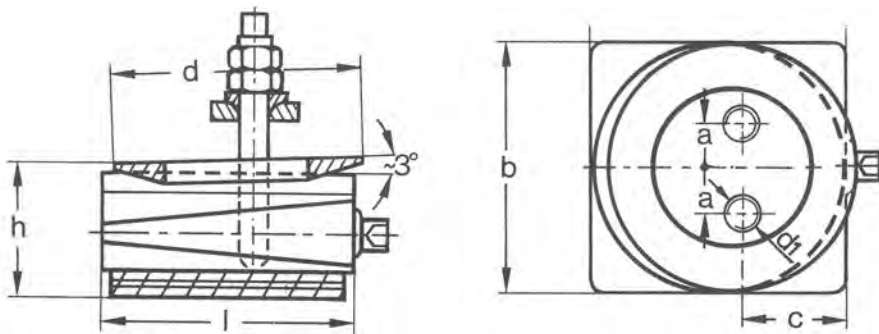
* cementable pad

VRKC COMPACT BOLT-ON WEDGMOUNTS

For use on machines with uneven floor supporting areas. Note horizontal surfaces are compensated up to 3 deg. For all VRKC Levelers with spherical seat and conical socket, an upper set is also required.

One Type P - Stud is necessary for one VRC Precision BOLT THRU Wedgmount Leveler. The threaded hole should be selected to place the Wedgmount in the ideal position with regard to the machine base.

VRKC - Compact with spherical seat, BOLT - ON



Type VRKC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d (ins.)	bore hole (mm.)	Height (h) per / pad type			Level- ing Range (ins.)	Max. Load Cap per Wedgmount in lbs			
							4 (ins.)	0 / 6 / 6C* (ins.)	HD (ins.)		4 (lbs.)	0 (lbs.)	50 (lbs.)	6 / 6C* (lbs.)
202-VRKC/*	4.57	4.57	1.07	2.28	4.57	26	2.62	2.58	3.02	+0.16" -0.20"	2300	3400	5600	9000
203-VRKC/*	5.50	5.50	1.07	2.78	4.57	26	2.82	2.78	3.22	+0.24" -0.24"	3400	5000	8500	13500
204-VRKC/*	6.75	6.75	1.07	2.70	5.50	26	3.30	3.26	3.69	+0.20" -0.32"	5000	7400	13400	18000
205-VRKC/*	7.15	9.13	1.07	3.57	5.50	26	3.65	3.61	4.05	+0.36" -0.36"	7200	10800	18000	27000

ORDER EXAMPLE : 204 -VRKC / 6

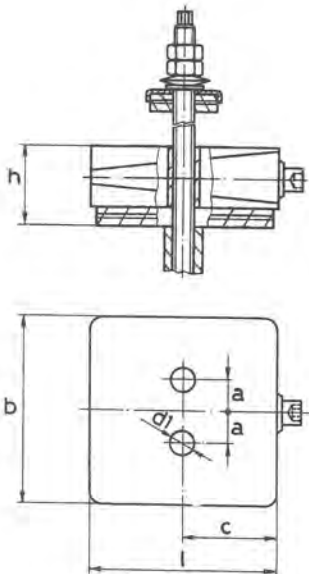
* cementable pad

Recommended - Stud type - P

VRC COMPACT BOLT- THRU WEDGMOUNTS

The upper side is plain and is used where the machine must be anchored to the floor e.g. machines with changing loads or one-sided and high dynamic forces. Isolation is accomplished due to the bolting system : disc spring , isolation cap , isolation tube.

One type S - stud is necessary for one VRC Precision BOLT --THRU Wedgmount Leveler. The threaded hole should be selected to place the Wedgmount in the ideal position with regard to the machine base.



1. Select the size of the anchoring bolt and the pretension force of the disc springs.

2. Isolation washers are furnished with the Bolt - Thru wedgmounts.

3. Anchoring normally done with an chor bolts or capsule anchors which must be ordered separately.

4. Disc springs , isolation tube, upper spherical seat and conical socket , must also be ordered separately

VRC - Compact BOLT - THRU , studs type S

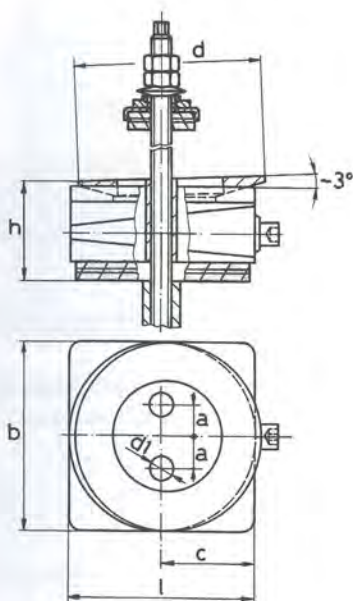
Type VRKC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d1 inner Thd (mm.)	Stud size	Ht h W 0 / 6 pad (ins.)	Level- ing Range (ins.)	Max. Load in Lbs w / pretension force	
									0 (lbs.)	6 (lbs.)
212-VRC/*	4.57	4.57	1.07	2.28	0.87	M16	2.18	+0.16" -0.20"	3400	9000
213-VRC/*	5.50	5.50	1.07	2.78	0.87	M16	2.38	+0.24" -0.24"	5000	13500
214-VRC/*	6.75	6.75	1.07	2.70	1.03	M24	2.66	+0.20" -0.32"	7400	18000
215-VRC/*	7.15	9.13	1.07	3.57	1.03	M24	3.02	+0.36" -0.36"	10800	27000

ORDER EXAMPLE : 214 -VRC / 6

VRKC COMPACT BOLT-THRU WEDGMOUNTS

For use on machines with uneven sfloor upporting areas. Note horizontal surfaces are compensated up to 3 deg. For all VRKC Levelers with spherical seat and conical socket , an upper set is also required

One type S - stud is necessary for one VRC Precision BOLT THRU Wedgmount Leveler. The threaded hole should be selected to place the Wedgmount in the ideal position with regard to the machine base.



1. Select the size of the anchoring bolt and the pretension force of the disc springs.

2. Isolation washers are furnished with the Bolt - Thru wedgmounts.

3. Anchoring normally done with an chor bolts or capsule anchors which must be ordered separately.

4. Disc springs , isolation tube, upper spherical seat and conical socket , must also be ordered separately

VRKC - Compact with spherical seat , BOLT - THRU studs type S

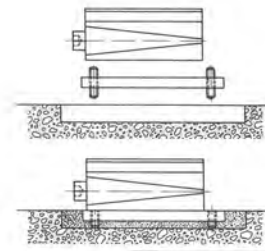
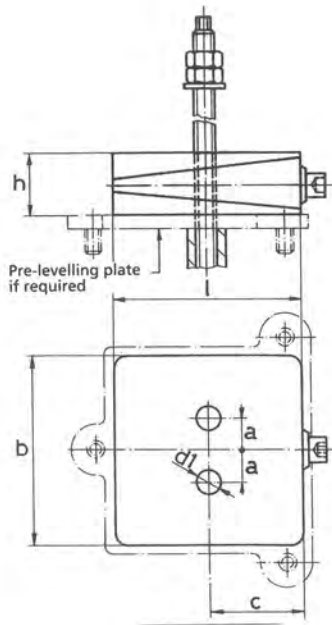
Type VRKC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d1 inner Thd (mm.)	d dia wshr (mm.)	Stud size	Ht h W 0 / 6 pad (ins.)	Level- ing Range (ins.)	Max. Load in Lbs w / pretension force	
										0 (lbs.)	6 (lbs.)
212-VRKC/*	4.57	4.57	1.07	2.28	0.87	4.57	M16	2.18	+0.16" -0.20"	3400	9000
213-VRKC/*	5.50	5.50	1.07	2.78	0.87	4.57	M16	2.38	+0.24" -0.24"	5000	13500
214-VRKC/*	6.75	6.75	1.07	2.70	1.03	5.56	M24	2.66	+0.20" -0.32"	7400	18000
215-VRKC/*	7.15	9.13	1.07	3.57	1.03	5.56	M24	3.02	+0.36" -0.36"	10800	27000

ORDER EXAMPLE : 214 -VRKC / 6

KSC PRECISION LEVELERS W/O PADS

KSC Wedgmount Precision Levelers (without Pads) are used under equipment or machinery where leveling only is required .

stud type S recommended



**Pre-Levelling Plate
(If necessary)**

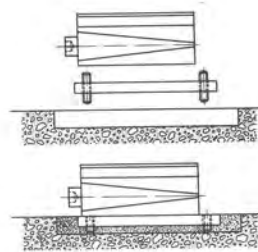
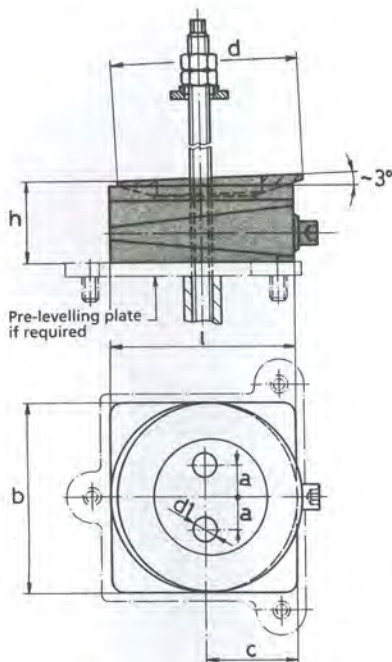
KSC - Leveler only , BOLT - THRU

Type VRKC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d1 inner Thd (mm.)	Ht h (ins.)	Level- ing Range (ins.)	Max. Load per Wedgmount (lbs.)	Max. Total Load per Wedgmount (lbs.)
2120-KSC	4.57	4.57	1.07	2.28	0.87	1.63	+0.16" -0.20"	9000	18000
2130-KSC	5.56	5.56	1.07	2.78	0.87	1.83	+0.24" -0.24"	11200	22400
2140-KSC	6.75	6.75	1.07	2.70	1.03	2.10	+0.20" -0.32"	13500	27000
2150-KSC	7.15	9.13	1.07	3.57	1.03	2.46	+0.36" -0.36"	22500	45000

ORDER EXAMPLE : 2140 -KSC

KSKC Wedgmount Precision Spherical washer Levelers (without Pads) are used under equipment or machinery installed on uneven floors and leveling only is required.

stud type S recommended



**Pre-Levelling Plate
(If necessary)**

With spherical seats you are independent from:

- Foundation Level
- Deformation through creeping and

shrinking of concrete

- Quality of surface of foundation
- Spherical seat and conical socket to be ordered separately.

KSKC - Leveler only (with spherical seat) , BOLT - THRU

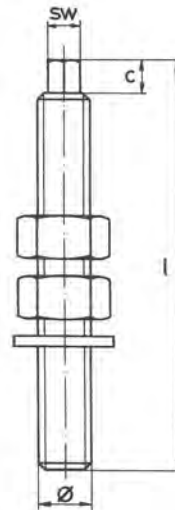
Type VRKC	l (ins.)	b (ins.)	a (ins.)	c (ins.)	d (ins.)	d1 inner Thd (mm.)	Ht h (ins.)	Leveling Range (ins.)	Max. Load per Wedgmount (lbs.)	Max. Total Load per Wedgmount (lbs.)
2120-KSKC	4.57	4.57	1.07	2.28	4.57	0.87	2.02	+0.16" -0.20"	9000	18000
2130-KSKC	5.56	5.56	1.07	2.78	4.57	0.87	2.22	+0.24" -0.24"	11200	22400
2140-KSKC	6.75	6.75	1.07	2.70	5.56	1.03	2.70	+0.20" -0.32"	13500	27000
2150-KSKC	7.15	9.13	1.07	3.57	5.56	1.03	3.06	+0.36" -0.36"	22500	45000

ORDER EXAMPLE : 2140 -KSKC

Torques & Type " P " Studs for Precision Wedgmounds

Torque (ft / lbs)

Type Wedgmound	Torque max. [ft/lbs]
1-VRC	11
2-VRC	30
3-VRC	49
4-VRC	101
5-VRC	71
6-VRC	116
7-VRC	150
8-VRC	98
9-VRC	124
10-VRC	188
11-VRC	353
12-VRC	750
202-VRC	38
203-VRC	49
204-VRC	49
205-VRC	101
212-VRC	38
213-VRC	49
214-VRC	49
215-VRC	135
2120-KSC	30
2130-KSC	45
2140-KSC	49
2150-KSC	83
100-PVR	15
100-PVR SS	15



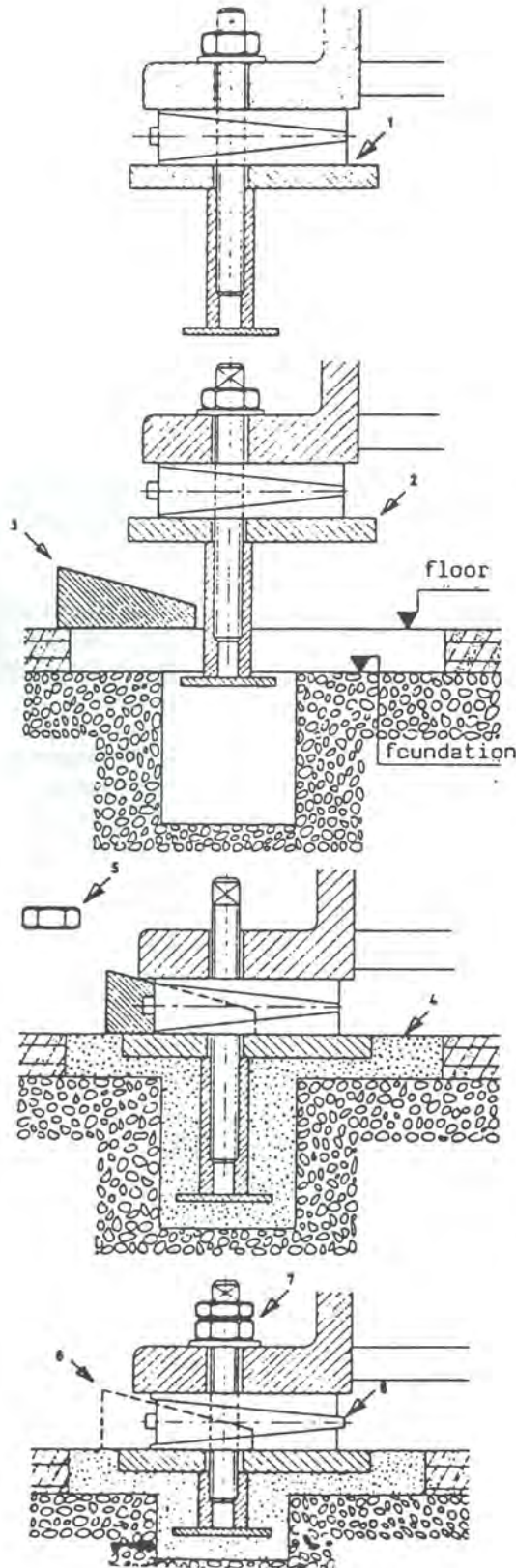
Type " P " STUDS (galv)

Dimensions (mm)

Dia x Lgth	sw	For
M 16 X 150	10	202-VRC/VRKC
M 16 X 200	10	203-VRC/VRKC
M 20 X 150	13	204-VRC/VRKC
M 20 X 200	13	205-VRC/VRKC

AIR-LOC RIGID CLAMP LEVELING AND ANCHORING SYSTEM

FIXED TO MACHINE BASE



1] Put the Wedgmount including plate and dowel with stud on the machine foot and fix provisionally with nut.

2] Place machine into proper location.

3] Lower machine on mounting wedges until levelling plate and floor are in line.

4] Pour concrete mix from one side until it reaches the lower level of the plate. Wait for approx. 6 hours until concrete dried up.

5] Remove nut and fill completely with concrete and ensure smooth surface.

6] Lift machine slightly with Wedgmounts and remove mounting wedges. Machine to be properly levelled.

7] Put washer and tighten with nut. Second nut for countering. Machine is now ready for operation.

AIR-LOC VCR MOUNTS LEVEL BIG MACHINES WITHOUT LIFTING !

YOU DONT HAVE TO TAKE THE LOAD OFF WHEN YOU'RE LEVELING BIG PUNCH PRESSES , STAMPING OR METAL FORMING MACHINES.

YOU CAN LEVEL - UP OR DOWN - AND HAVE THE VIBRATION CONTROL NEEDED.

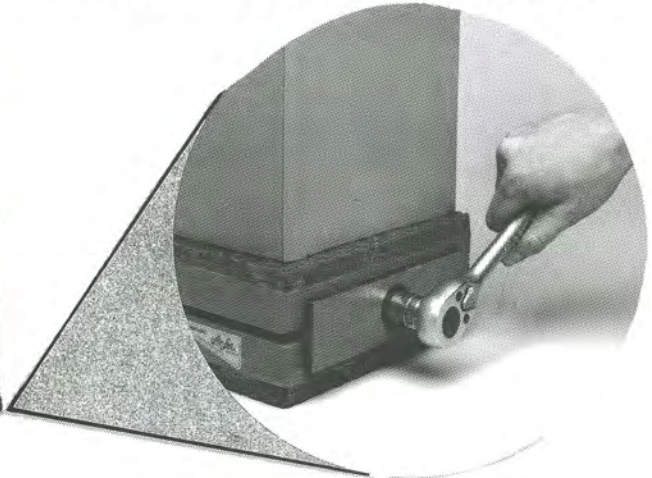
DESIGNED SPECIFICALLY FOR HIGH IMPACT MACHINES , IT IS EASY TO LEVEL HEAVY MACHINES IN MINUTES WITH A SIMPLE RATCHET WRENCH.

VRC MOUNTS GIVE OTHER IMPORTANT ADVANTAGES :

- 1. ISOLATING DESIRED AMOUNT OF VIBRATION BY CHANGING THE PAD STYLE OR TYPES.**
- 2. UNIQUE HORIZONTAL ADJUSTMENT DESIGN HAS NO VERTICAL SHAFT OR THREADS THAT CAN STRIP DURING LEVELING.**
- 3. 100% SURFACE BEARING AND EQUAL WEIGHT SUPPORT AT ALL MOUNTING POINTS TO PREVENT MACHINE SHIFTING OR CRAWLING.**

SAVE PRODUCTION TIME AND MAINTENANCE COSTS WHILE PROTECTING CAPITAL EQUIPMENT AT THE SAME TIME.

VRC MOUNTS WILL KEEP YOUR BIG MACHINES RUNNING - LONGER , MORE QUIETLY AND MORE ACCURATELY.



AIRLOC

**INSTALLATION
RECOMMENDATIONS**

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INSTALLATION RECOMMENDATIONS

JACMOUNTS / PRECISION WEDGMOUNTS

The following instructions for the installation of AIR-LOC PRECISION WEDGMOUNTS and JACMOUNTS should be carefully followed for a successful installation.

GENERAL

The contact surface of both the machine and floor should be thoroughly cleaned and must be free of any oil or grease, for maximum non-skid conditions.

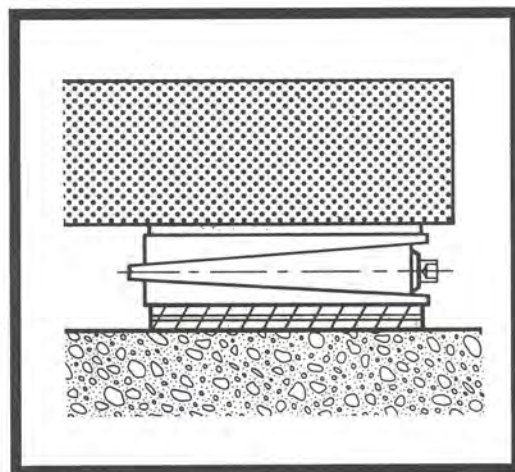
Best isolation and non-skid results are attained only when the adjustments and placing of the precision Wedgmounds and/or Jacmounts are carefully carried out during the installation. If there are any questions as to where the mounts should be located, please call our technical department toll free for application assistance. Accurate supporting loads on each Wedgmound or Jacmount are most important.

FREE STANDING PRECISION WEDGMOUNTS

The AIR-LOC pads placed on the wedges of the type/4 wedgmounds are of different thickness. The thin non-skid pad should be always on the upperside.

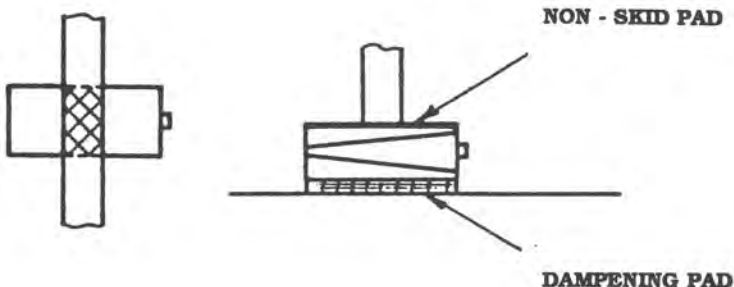
The wedgmounds level range is always put in the mid-position as the machine is placed on them. The machine is then leveled in accordance with good leveling procedures.

Should the leveling range be insufficient due to an uneven floor, then we recommend shim holding pads SO = 5 (3/16") or SP-O = 2 (1/16") These are friction pads only.

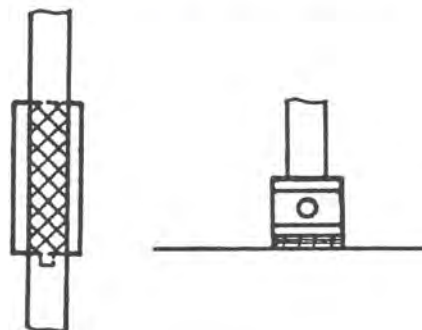


THE LOADS ON WEDGMOUNTS MUST ALWAYS BE PROPERLY DISTRIBUTED AS SHOWN BELOW.

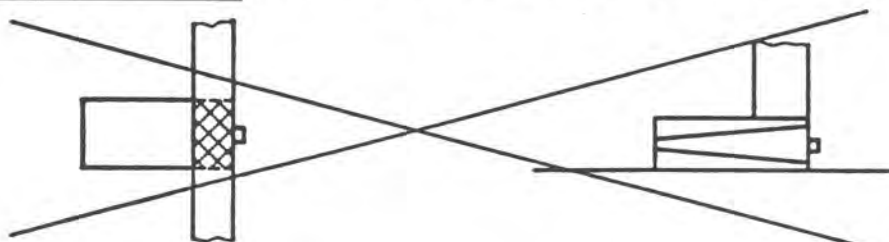
CENTERED



IDEALLY ALWAYS FULL AREA



NEVER ONE-SIDED BECAUSE OF DANGER OF TIPPING OVER.

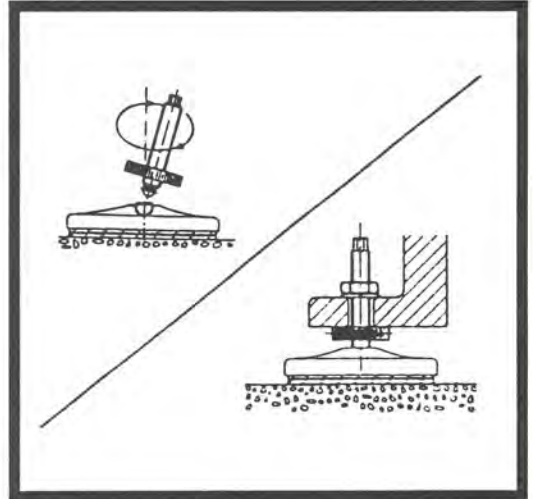


PR JACMOUNTS

PR JACMOUNTS - equalize slanting surfaces.

The leveling stud is firmly attached to the base plate. Insert the PR mount from the bottom into the machine base opening. The mount base is now directly below the steel washer and toothed nut, respectively.

Once all the mounts are properly located, then the adjusting is made from the hexagonal head and finally counter-screwed. The machine is now ready for operation.

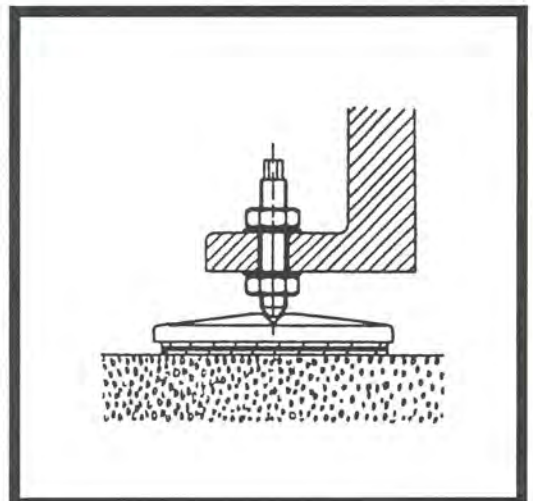
**GLV JACMOUNTS**

Lift machine and place AIR-LOC base plate under machine. Put adjusting screw (without supporting nut) into the bored hole of the machine base (from top to bottom) .

Then turn by hand (from bottom) the supporting nut w/washer until it reaches the base plate. Repeat this procedure at all supporting points.

Then place machine carefully down and level on the hexagonal nut of the adjusting screw.

Hold down the supporting nut with a wrench ; once adjusting is finished, screw on upper washer with counter nut and tighten it.

**CAUTION :**

FREE STANDING WEDGMOUNTS AND JACMOUNTS SHOULD NOT BE USED FOR TOP HEAVY MACHINES. THESE SHOULD BE BOLTED TO THE FOUNDATION.

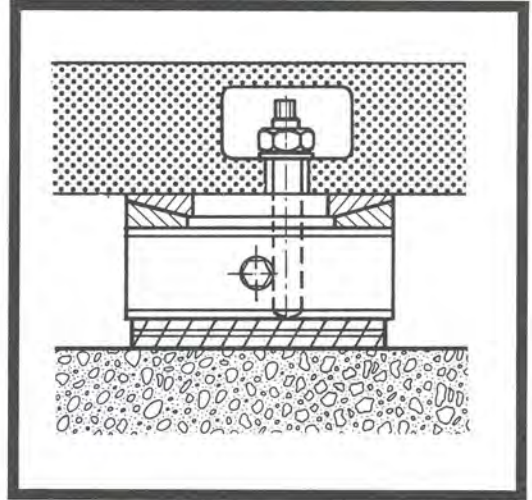
BOLT - ON PRECISION (VERTICAL RISE) WEDGMOUNTS

These wedgmounds with pocket hole inside thread can be bolted on to the machine base by a threaded stud.

The fixing has to be made at one of the threaded holes only - preferably as far away from the machines center as possible. This gives higher stability.

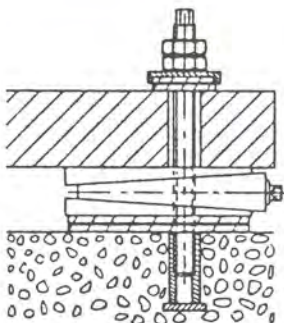
Only adjust when the vertical stud is loosened. Tightening takes place when leveling is complete.

A pad can be used on top of spherical washer in place of a stud.

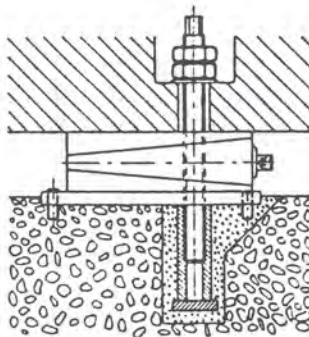
**BOLT - THRU PRECISION (VERTICAL RISE) WEDGMOUNTS**

These wedgmounds are used only where anchoring to the floor is necessary.

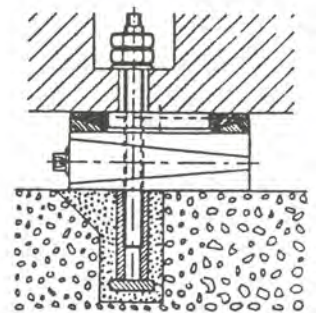
AIR-LOC / ACORN furnishes installation instructions on all these type mounts.



STANDARD ANCHORING



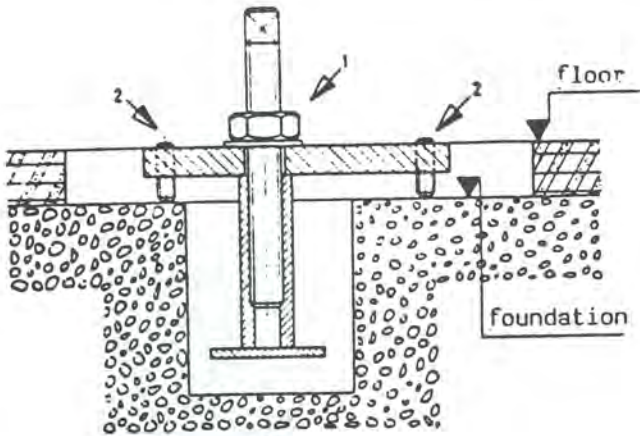
PRE-LEVELING PLATE



SPHERICAL WASHER

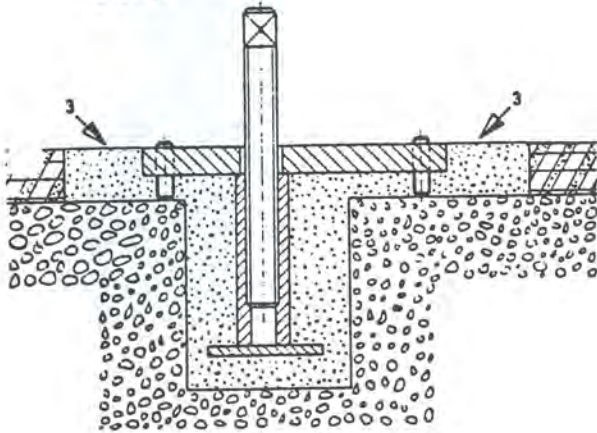
AIR-LOC RIGID CLAMP LEVELING AND ANCHORING SYSTEM

WITH PRE-LEVELING PLATE

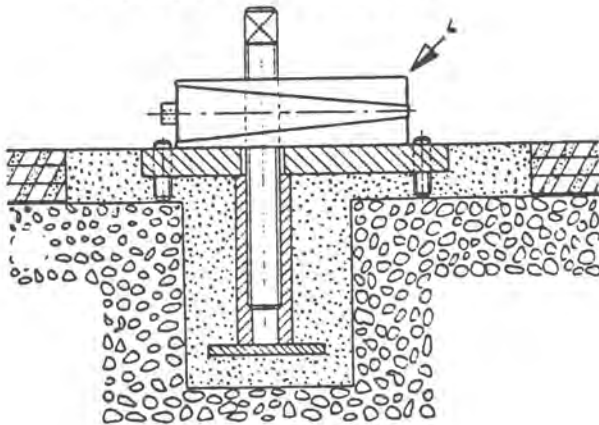


Checking of the foundation according to the foundation plan of the machine tool manufacturer.

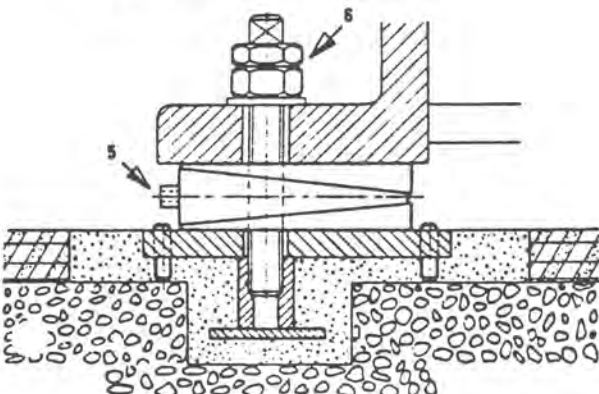
- 1] Stud to be screwed into dowel through prelevelling plate (machined part on top and to be provisionally fixed with nut.
- 2] Prelevelling plate together with fixed on dowel to be put in proper location and to be levelled with the three leveling screws.



- 3] Concrete mix to be poured in from one side until it reaches the lower level of the prelevelling plate. Wait for 6 hours until concrete dried up. Remove nut and check prelevelling plate with water level again. If o.k. fill up completely with concrete and ensure smooth surface.



- 4] Place Wedgmount and prelevelling plate. Depending on need use one of the holes. All Wedgmounts to be levelled at the same height (middle position). The machine can now be put on.



- 5] Proper levelling of machine.
- 6] Put washer and tighten with nut. Second nut for counteracting. Machine is now ready for operation.

RECOMMENDED FOR HEAVY MACHINES