



Supplementary instructions

Alu Line Heavy / Heavy Gantry
Assembly of adjustable feet

AL.FS.001.01
AL.FS.002.01

Introduction

If the portal milling machine is to stand on a base other than that offered for the Alu-Line, the set of adjustable feet is highly recommended. The screw feet with the 80 mm plastic plates decouple vibrations, loud droning noises are effectively dampened. The precise horizontal leveling is also greatly simplified by the simple height adjustment. Last but not least, the non-slip feet prevent the notorious „wandering“.

These additional instructions contain supplementary information on the „Assembly instructions for the cutter kit“ for installing or retrofitting leveling feet. The set of adjustable feet supplied is intended exclusively for assembly on the Alu-Line CNC portal milling machines.



Note

*If the leveling feet are subsequently installed on a fully assembled machine, the screw connections on the brackets **50** must be removed or loosened to move them.*

*The aluminum profiles **62** must be screwed in such a way that the threads in the aluminum profiles point outwards.*

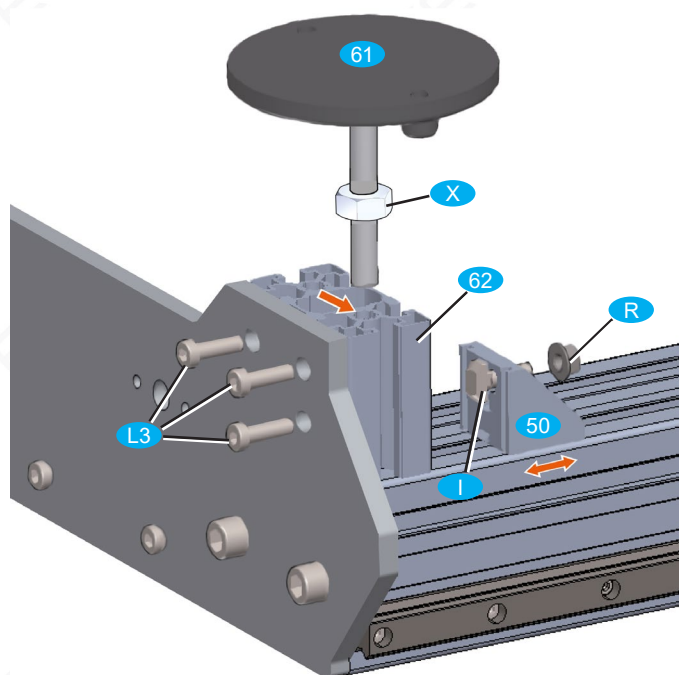
Scope of delivery

Illustration	Designation	Number
61 	Adjustable foot	4
L3 	Flat headed screw ISO 7380 M8 x 20 Allen	12
G2 	Hammer nut Slot 10 M8	12

Illustration	Designation	Number
X 	Hex nut M12	4
62 	Alu-Profile 10 45 x 90	4

Assembly

- Dismantle the corner bracket **50**.
- Equip the front plate **47** bzw. **48** with three screws **L3** and loosely screw on three hammer nuts **G2** on the inside.
- Place the aluminum profile **62** on the face plate; thread the hammer nuts into the T-slot of the aluminum profile. To turn the hammer nuts by 90° in the T-slot, slightly counter-tighten the screws.
- Move the aluminum profile until the face is flat.
- Tighten screws. Tightening torque: 25 Nm
- Equip the bracket **50** with a hammer screw **I** and flange nut **R**.
- Push the bracket against the aluminum profile; thread the hammer screw into the T-slot of the profile.
- Turn the T-bolt 90° in the T-slot and tighten the flange nut. Tightening torque: 25 Nm.
- Screw on the locknut **X** and screw the adjustable foot into the aluminum profile.
- Repeat the steps for the other three leveling feet.
- After leveling the machine, tighten the locknuts.



To mount the adjustable feet, the respective corner bracket must be unscrewed, moved and reconnected to profile 10 **62**.