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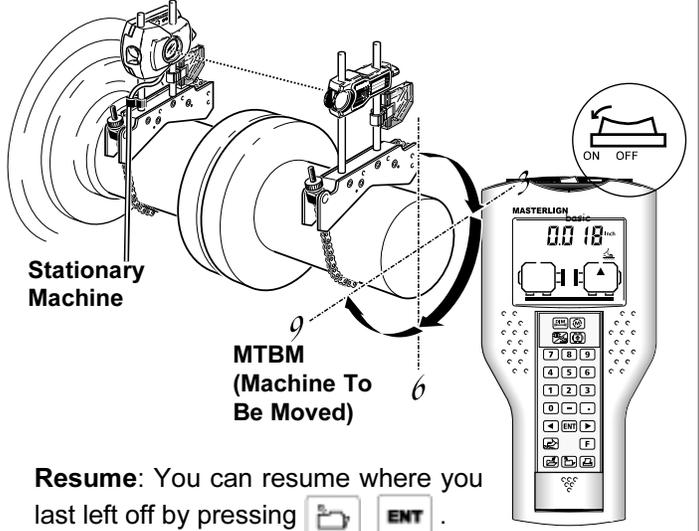
Your local contact — Norm Voelzow

MASTERLIGN® basic

Alignment of horizontal machines

File No. _____ Machine No. Type _____ Operator _____ Date _____

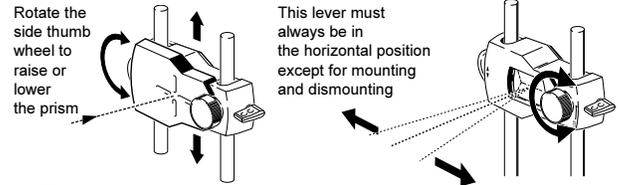
1. Mount MASTERLIGN® basic and switch on



Resume: You can resume where you last left off by pressing **[Resume]** **ENT**.

3. Measure

- Adjust prism so that laser beam strikes center of the prism cap cross hair.



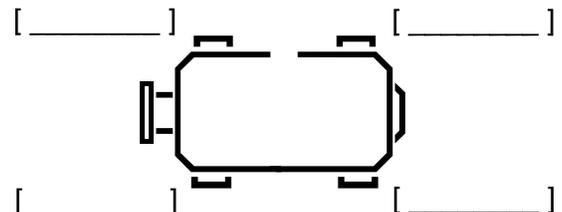
- Remove cap.
 - Adjust prism until coordinates are close to 00.
 - 0369 will appear on the screen.
 - Rotate shaft to the first clock position using the ALI 5.020 external inclinometer.
 - Press the number key of the clock position (e.g. **0** for 12 o'clock) and press **ENT**. Measure at least three of the four clock positions, as viewed towards the stationary machine.
- Go to Step 4a or 4b →**

- If **End** or **off** appear during rotation, turn shafts back until numbers reappear and initiate *InfiniRange*® manually by pressing **F6**.
- Adjust beam close to 00 and press **ENT**.
- Proceed with measurement.

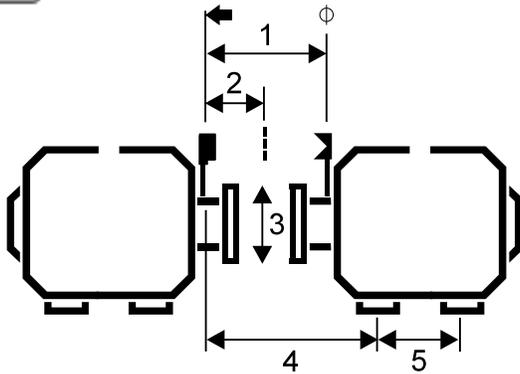
Soft Foot

- Position shafts at either 90° or 270° (±4°).
- Adjust beam close to 00 if necessary. Press **ENT**. (Not necessary if "----" appears.)
- Press **0** then loosen the bolt, press **ENT** to record value then tighten bolt.
- Press **[Left]** or **[Right]** to move to the next foot.

Follow this procedure for all remaining feet and correct soft foot if greater than 0.002".



2. Enter dimensions

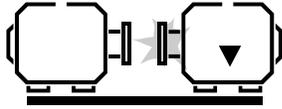


- 1. Laser to prism _____ **ENT**
 (Arrow point to hash mark "φ" on prism)
 (Center-to-center of support posts)
- 2. Laser to center of coupling _____ **ENT**
 (Center of flex planes)
- 3. Working diameter 10" **ENT**
 (Coupling diameter) (Default value)
- 4. Laser to front foot _____ **ENT**
- 5. Front foot to back foot _____ **ENT**



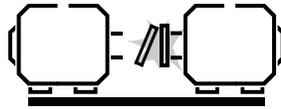
4a. Coupling Results

Vertical Offset



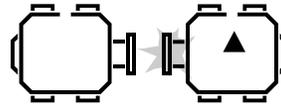
(+) (-)

Vertical Gap



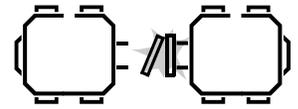
(+) (-)

Horizontal Offset



(+) (-)

Horizontal Gap



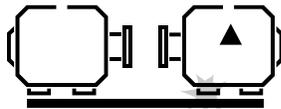
(+) (-)

1. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
2. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
3. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
4. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
5. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____



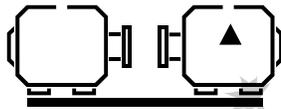
4b. Foot Corrections

Front Foot Shim



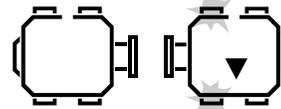
(+) add shims (-) remove shims

Back Foot Shim



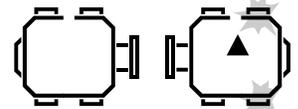
(+) add shims (-) remove shims

Front Foot Move



(+) toward 3 o'clock (-) toward 9 o'clock

Back Foot Move



(+) toward 3 o'clock (-) toward 9 o'clock

1. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
2. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
3. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
4. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____
5. _____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____	<input type="button" value="▶"/>	_____



5. Move

- Turn shafts to the 1:30 clock position (45°) using the external inclinometer
- Adjust beam close to
- When *Enter* appears press
- Loosen bolts.
- Move machine horizontally into alignment.
- Retighten bolts.

Tolerances for Shaft Alignment

RPM	Offset (mils)		Gap (mils/10")		Spacer Shaft (mils/inch)	
	Excellent	Acceptable	Excellent	Acceptable	Excellent	Acceptable
600	5.0	9.0	10.0	15.0	1.8	3.0
900	3.0	6.0	7.0	10.0	1.2	2.0
1200	2.5	4.0	5.0	8.0	0.9	1.5
1800	2.0	3.0	3.0	5.0	0.6	1.0
3600	1.0	1.5	2.0	3.0	0.3	0.5
7200	0.5	1.0	1.0	2.0	0.2	0.3

All Speeds: Maximum Soft Foot Reading 2 mils.
Use OEM or in-house tolerances if available.