

Acroloc X & Y GIB Adjustment

Adjusting the X Gib

1. Setup Indicator as shown in figure 1.
2. Loosen all gib bolts, then bring the 3 bolts on either end until just snug.
3. Loosen the 2 middle gib set screws.
4. Pull and push on right side of the table as shown in Figure 3. Check and adjust the table play with the gib set screw on the far right until you have about .0015" play on the indicator.
5. Repeat this on the left side with the indicator setup as shown in figure 2.
6. Now tighten the gib bolts starting with the 3rd one in from the end then the 2nd and then the end bolt.(do this on both left and right sides)
7. Check the table play again it should be about .0005", if too small, repeat steps again but start with to a high value in step 5, if too large, use a smaller value.
8. When you get the desired table play tighten the center set screw up until snug, then tighten the remaining center gib bolts.
9. Recheck the table play.

"Before performing the above steps please read the notes below"

- Note:1 This document refers to the gib adjustment as "table play" but could be referred to as "table shake", "table rock", "gib play" or "gib clearance".
- Note:2 Save time by setting up 2 indicators, one on either end, if possible.
- Note:3 The original specifications for table play was .0002" to .0004". The value of .0005" in step 7 is an arbitrary value, depending on your needs and wear of your table way's this value may have to be altered. X way's generally wear in the middle, the .0005" value may cause the table to be too tight on the ends. You may have to increase the play to accommodate worn ways.
- Note:4 Tighten the gib bolts to about 30 lb/ft. of torque, with exception of the two outside end bolts, tighten these to about 20 lb/ft.
- Note:5 Table play is not how much the indicator moves under pressure but how much it moves and stays when pressure is released.
- Note:6 If you just want to check the gib adjustment skip steps 2 & 3.

Prepared by
MCKENNA SERVICE COMPANY
(847)566-1120
Specializing in Acroloc Parts & Service

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Adjusting the X Gib (Continued)



Fig-1



Fig-2

Prepared by
MCKENNA SERVICE COMPANY
(847)566-1120
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Adjusting the X Gib (Continued)



Fig-3

Adjusting the Y Gib

1. Loosen the gib bolts with a 9/16 long hand thin wrench (see in figure 6).
2. Setup indicator as shown in figure 4 & 5.
3. Tighten all 4 gib adjusting set screws with a long arm 3/16 Allen wrench (see figure 5 & 6).
4. Back off gib adjusting set screw until loose, then bring back up until snug, then back off 1/8 turn. (do this to each set screw one at a time)
5. Check the table play on indicator by pushing and pulling on table as shown in figure 3, it should read about .0002 to .0004"
6. Tighten gib bolts to 25 to 30 lb/ft of torque.
7. Recheck table play again

Note:7 The original specifications for table play was .0002" to .0004". depending on your needs and wear of your table way's this value may have to be altered. Y axis way's generally wear in the front and middle. You may have to increase the play to accommodate worn ways.

(Also see Notes 1,2 & 5 above)

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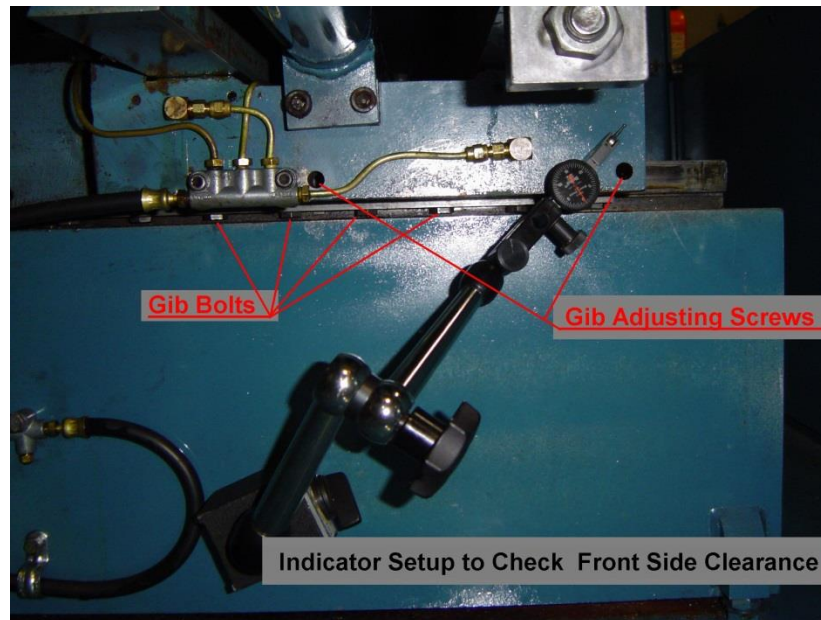


Fig-4

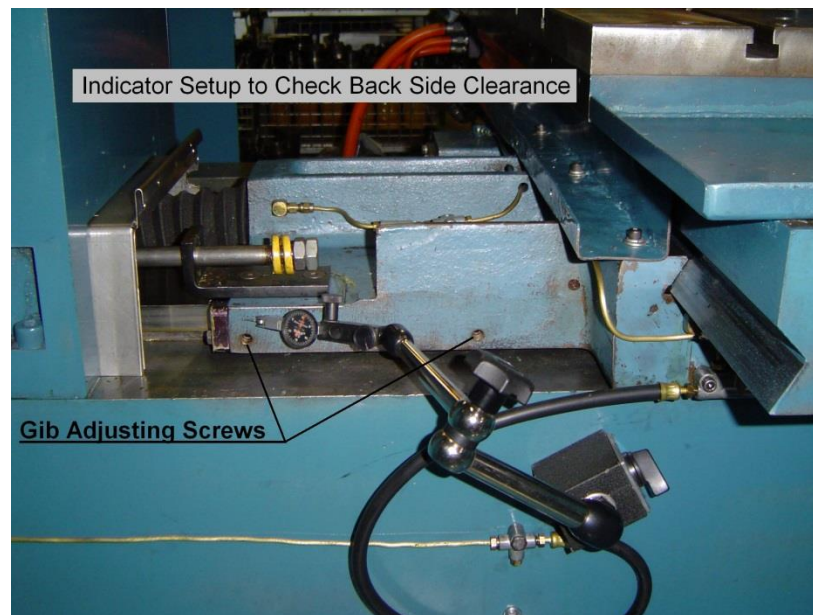


Fig-5

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Adjusting the Y Gib (Continued)

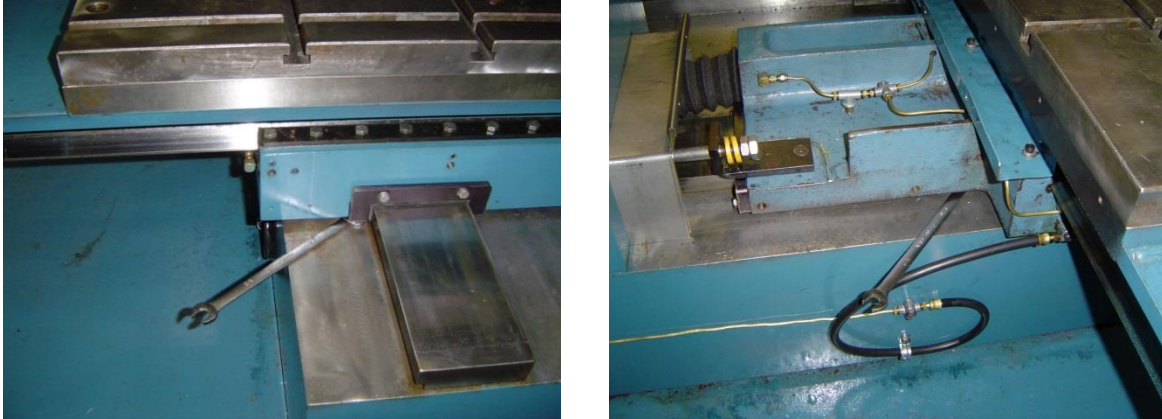


Fig-6

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