

Soft Foot Routine

The V180 can be used to check soft foot. We recommend that you check for soft foot as a preliminary to performing precision alignment.

1. Follow the instructions to set-up the unit as if you were going to perform an alignment. The laser units should be at the 12:00 position.
2. Measure and enter the A, B, and C dimensions.
3. A clock face appears on screen with a blinking dot at the 9:00 position. **DO NOT ROTATE THE SHAFTS.** Instead, push the forward arrow key.
4. The blinking dot now appears at the 3:00 position. Again, **DO NOT ROTATE THE SHAFTS.** Instead, push the forward arrow key.
5. The blinking dot now appears at the 12:00 position. Again, **DO NOT ROTATE THE SHAFTS.** Instead, push the forward arrow key.

The Coupling Value Screen will appear with the results displayed as zero values. Push the “+” button to move from the coupling values screen to the feet values screen. Again, the results will be displayed as zeros.

6. Check for soft foot by loosening each of the moveable machine mounting bolts. (You may start with either the front or back feet, but check both front or both back feet before moving on to the other end of the machine.) Note the values displayed at the feet when each of the bolts is loosened. A reading of greater than 2 thousandths (0.002”) indicates that soft foot is present.
7. Correct soft foot as required. You can toggle back and forth using the forward and back arrow keys to re-zero the values as soft foot is corrected.
8. To perform a precision alignment, it is not necessary to re-enter the A, B, and C dimensions. Use the back arrow key to return to the screen with the clock face and the blinking dot at the 9:00 position. Follow normal procedures, rotating the shafts as required, to perform the alignment.