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BW-Fixatoren®

Instructions for the mounting of
machinery on BW-Fixators RK series



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BWF
...the best for accuracy.

1. BW-FIXATORS, when received on site, will all have the same vertical adjustment.
2. BW-FIXATORS have been given an anti-corrosion treatment (do not wipe with grease).

Preparations

1. The foundations with recesses for the anchor bolt holes should be cast in one operation and at least one month before the machine is to be erected.
2. Level variations in the finished foundations should not exceed ± 10 mm. The strength of concrete must be consistent with DIN Standard No. 1045 (Foundations).
3. Free the foundations from dust and oil and thoroughly clean out the anchor bolt holes and recesses, doing away with formwork splinters and other foreign matter.
4. Keep the anchor bolt holes and recesses well wet before starting the grouting work.
5. Make the BW-FIXATORS ready as described.
6. Clean the sole of the machine bed.
7. Keep grouting frames in readiness if the BW-FIXATORS are to be grouted on top of the foundations.

Grouting

Such compounds are setting relatively quickly (3 days), non-shrinking, resistant to oil, offering high early and final strength and easy to handle. Follow the supplier's instructions carefully. Our recommendation: PAGEL V1.

Installation procedures

Positioning BW-FIXATORS by...

- ... pre-installation
- ... attaching to the machine
- ... levelling procedure

Pre-installation

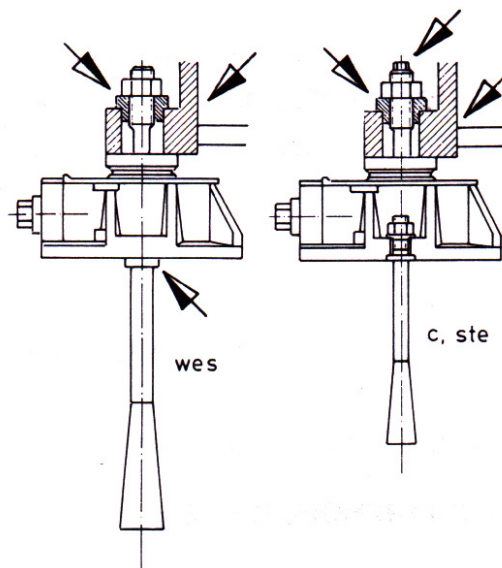
See prospect **Installation Service**.

Attaching to the machine

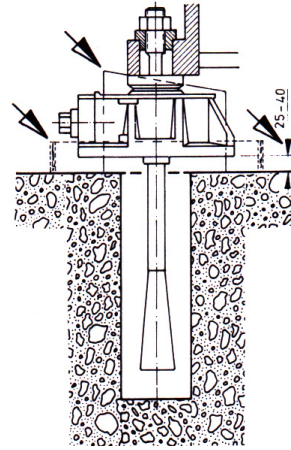
Adjust the fixation bolts to the level of the machine bed feet, using the set ring and grub screw in the "wes" variety, and by turning the expansion bolt into or out of the FIXATOR bottom in the "ste" variety.

Fix the anchor bolts to the BW-FIXATORS (type "c") and attach the latter with centering sleeves to the machine.

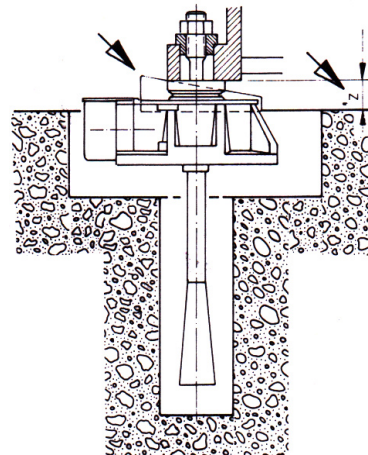
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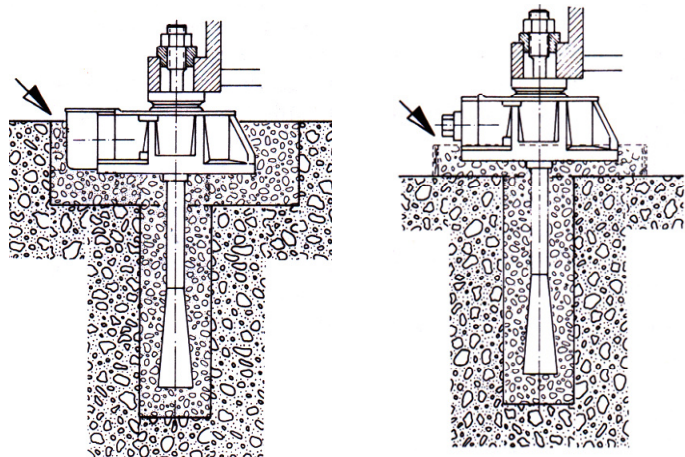
Place grouting frames around the anchor bolt holes. Lower the machine, with BW-FIXATORS attached, upon the makeshift wedges and use the latter for pre-levelling to $\pm 0,5$ mm.



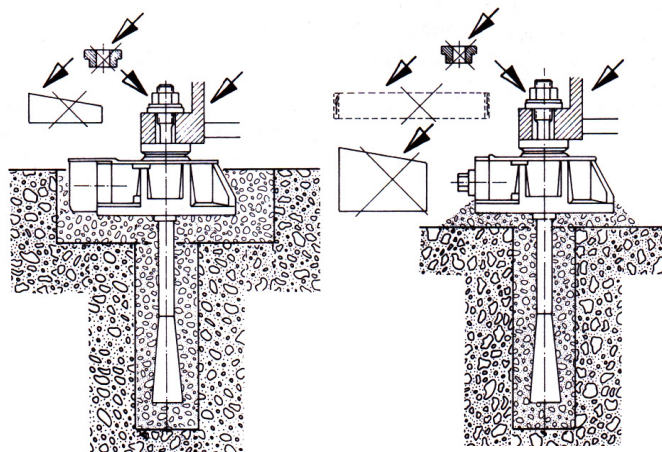
No frames will be required for grouting flush with the foundations, but the dimension "z" (listed in the catalogue and depending upon the BW-FIXATOR size) must be adhered to.



Grout the anchor bolts and BW-FIXATORS flush with or on top of the foundations.



Remove the centering sleeves, makeshift wedges and grouting frames when the grouting has set. Replace the centering sleeve by a variety "p" set (spherical washer and pan).



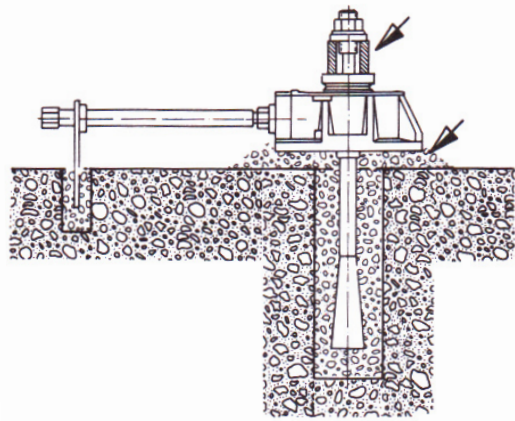
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How to proceed on central rows

If there are BW-FIXATORS that cannot securely be grouted from the outside, first grout the anchor bolts only*).

When the grouting has set, raise the machine again. Use a clamping sleeve to bind the BW-FIXATOR against the set collar of the anchor bolt and then grout upon the foundations.

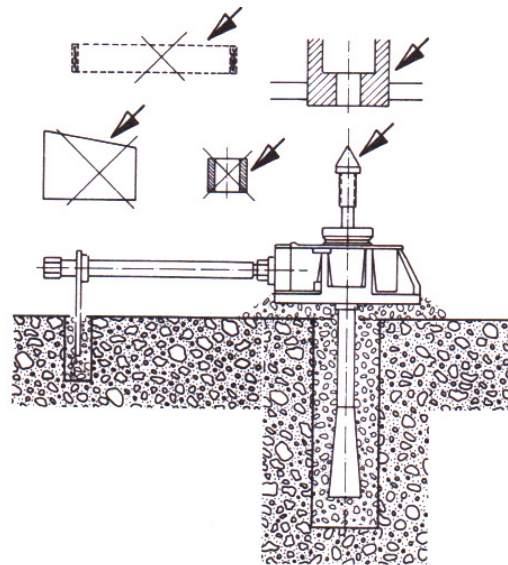
*) If neither the BW-FIXATOR nor the anchor bolt can be grouted from the outside, pour the grouting in such places before the machine is lowered.



Remove the clamping sleeves when the grouting in the centre rows has set.

Before lowering the machine again upon the BW-FIXATORS, provide a number of fixation bolts with end caps to protect the treads from damage.

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When the machine is down in place, remove the bolt end caps, install a variety "p" set (spherical washer and pan) and the anchor bolt nuts.

