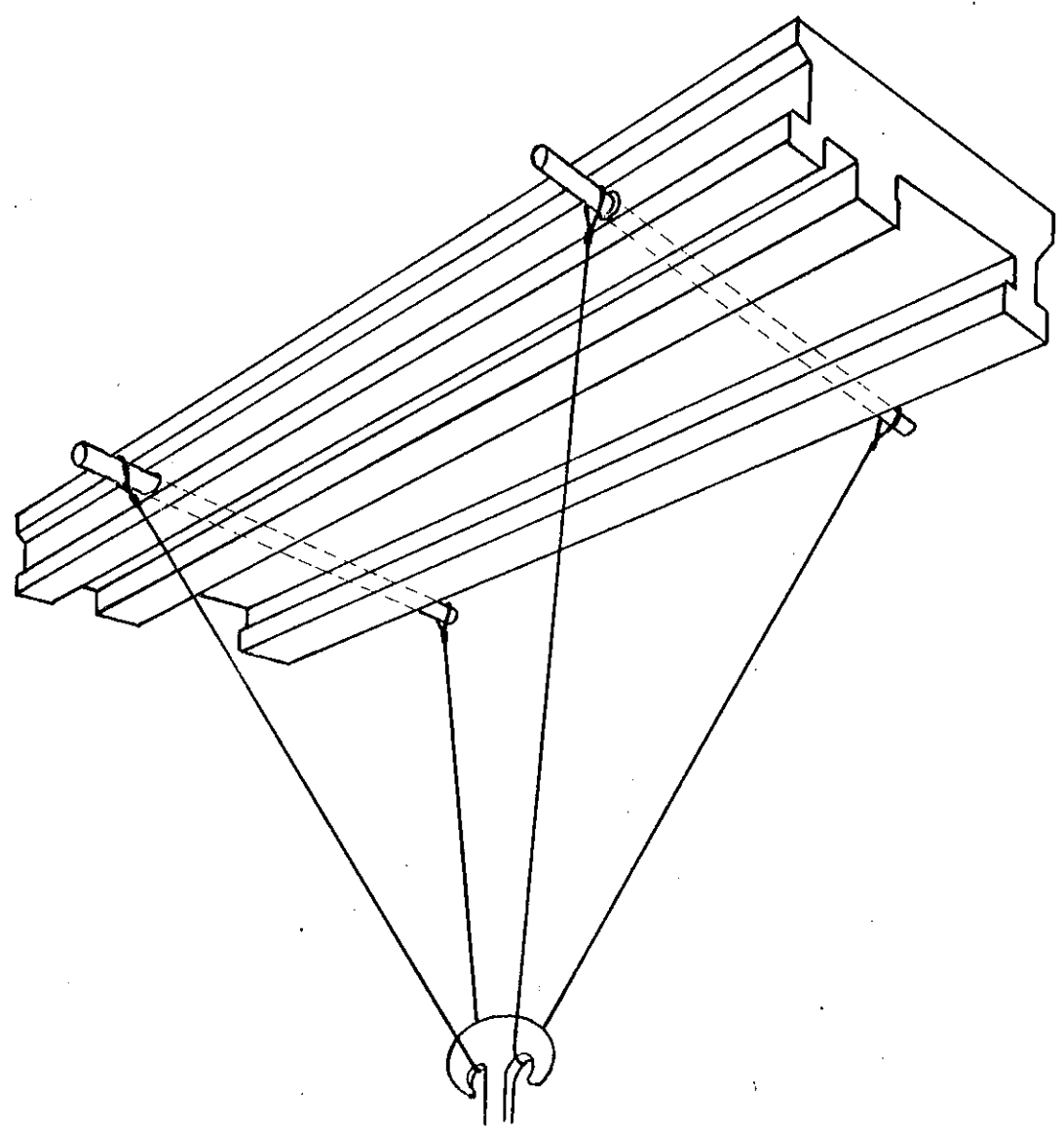


Weights of the main assemblies of the Milling and Boring Machine, Type FB

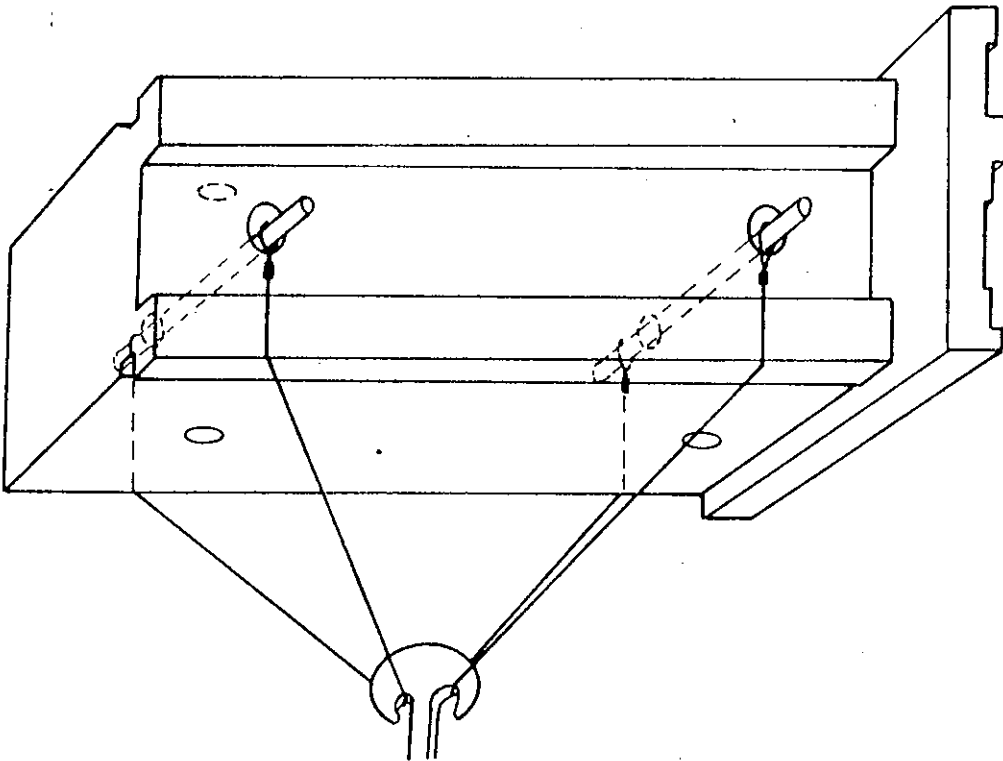
[illegible]



Example of lifting the bed

Weights see page 2.1 - 2

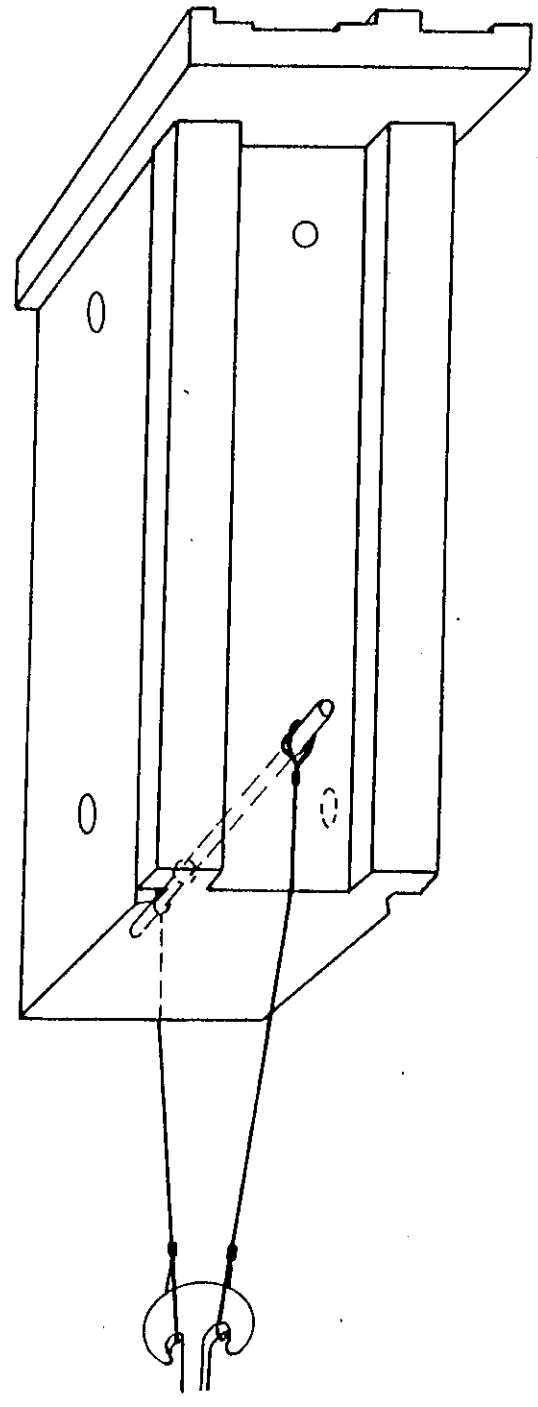
Weights see page 2.1 - 2



Example of lifting the column

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FBM

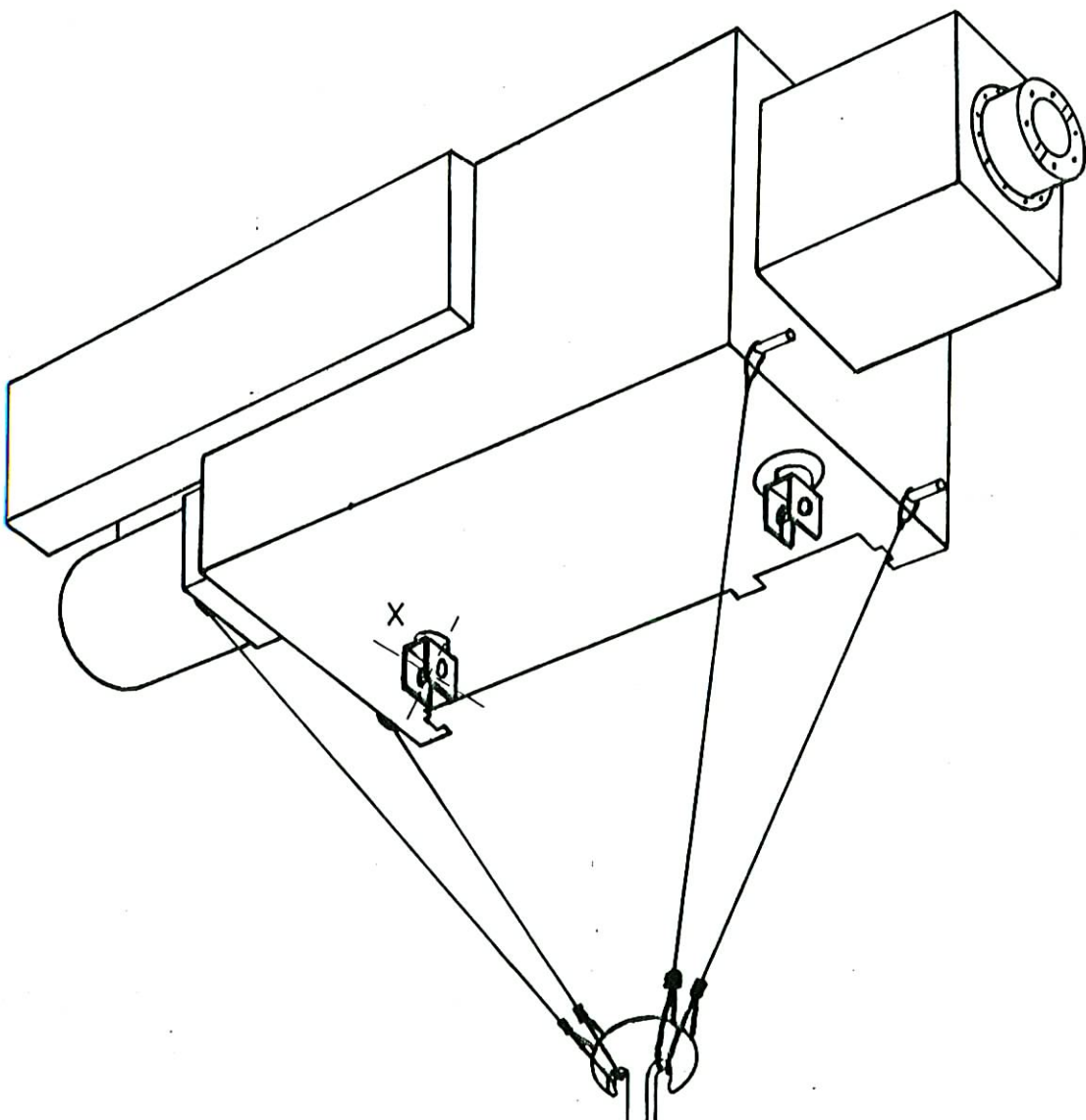
Weights see page 2.1 - 2



Example of lifting the column

SCHIESS FRORIEP	ERECTION Transport	2.1 - 5 A 1
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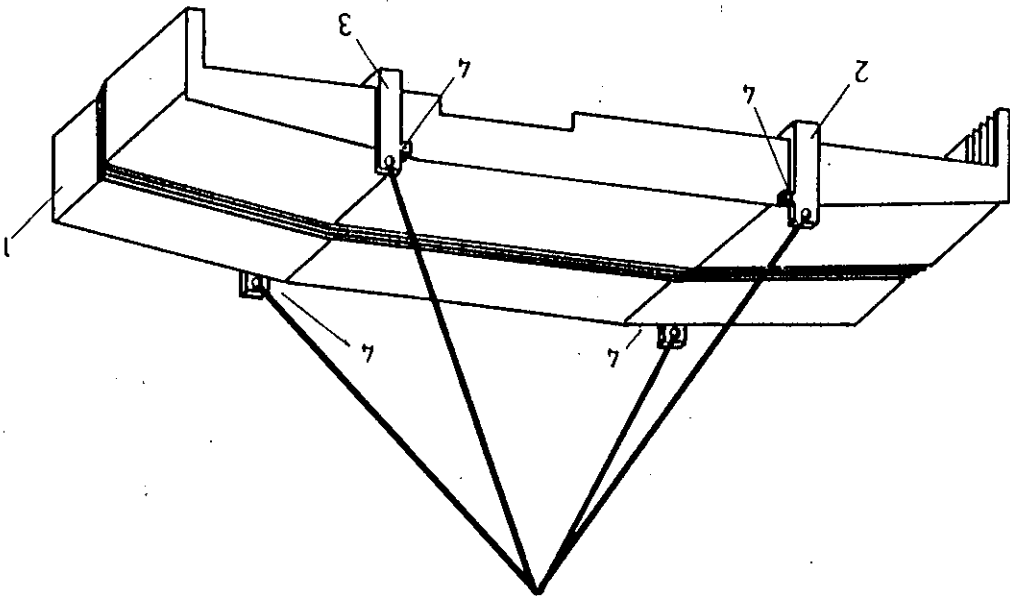
Example of lifting the column saddle with headstock



Weights see page 2.1 - 2

ATTENTION! The rear chain-fixture (pos. X) must not be used for lifting the column saddle and headstock assembly as this will cause damage to the balance-weight rope strain gauge.

The slideway covers must only be transported using the sling fixtures (2) and (3). These fixtures are slid under the covers and secured with the screws (4). The ropes are then fastened by means of shackles.



Typical example of lifting the telescopic slideway covers

SCHIESS FRORIEP	ERECTOR Transport	2.1 - 7 A 1
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SCHIESS FADRIER	ERECTION Foundation	2.2 - 1 A 1
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The foundation must be built according to the foundation plan using steel-reinforced concrete. The depth depends largely on the local sub-soil conditions. The foundation should preferably be erected on grown soil. If there is any doubt as to the load carrying capacity of the sub-soil, an expertise must be obtained beforehand. Additionally it is advisable to install an insulating layer around the foundation in order to prevent the transmission of vibrations from crane stanchions or from other machines. The accuracy of the machine depends largely on the insulation and the quality of the foundation.

The foundation concrete must be completely set before the machine is erected. This also applies to the mortar used for grouting the anchor bolts and the aligning elements.

The layout of the cable channels and the recesses for the anchoring bolts must be taken from the foundation drawing.

Safety at the machine

If there is a foundation pit close to the machine, such pits must be permanently protected with safety railings or a similar provision to prevent personnel falling into the pit (§ 33 (2) UVV 1.0). This may be achieved by suitable covers, railings around the pit or by preventing access to the entire area from the operating section.

Suitable anchoring points for such guard railings should be provided as part of the foundation.

Such guards are not part of our delivery.

SCHIESS FRÖRIEP	ERECTION Erection of Machine	2.3 - 1 A 1
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The machine should preferably be erected on adjustable alignment elements (Fixators). They have the advantage that the machine may be re-aligned at any time without damaging the foundation. A pre-requisite however for the exact positioning of the machine is the precise location of the fixators on the foundation. The order of fitting of the various types of fixators may be seen from the following pages.

Please chose the description relevant to the type of fixators used on your machine.

PLEASE NOTE ! Before the fixators are bolted onto the bed of the machine, ensure that they are adjusted to the same height. The standard adjustment on delivery is approx. 1 mm higher than the bottom-most position.

A cement-mortar is used for grouting-in the anchoring bolts and for packing under the fixators which consists of

- 1 volume of fine sand (grain size: 0 - 3 mm)
- 2 volumes coarse sand (grain size: 0 - 7 mm)
- 1 volume of cement type Z 350

The quantity of water to be added must be chosen such that the mortar is soft for grouting-in the anchoring bolts and stiff (damp) for packing under the fixators. After pouring the mortar into the recesses of the anchoring bolts, agitate the mortar until no more air bubbles are seen to rise to the surface.

The stiff mortar must be pushed under the fixators in such a manner as to prevent the formation of cavities. To this end it is advisable to apply the mortar to one side only until it emerges from the other side. Before the mortar is applied, the recesses and areas under the fixators must be soaked for some time.

If Embecco or some other Patent Grouting is used, the instructions of the manufacturer must be followed precisely.