



# Frame Alignment Kit

631753

## Quick Sheet

### Frame Assembly - Aligning the Nest Row

1. Start at the beginning of the nest row and anchor the feet of the legs attached to the first cross-support to the floor in the correct position, as determined by your layout guide. Then move 40' down the nest and locate the nearest available hole in the vertical face of the front rail. If using ridged front rails, the front of the ridge should be used, as shown in Figure 1. Thread a 5/16-18 nut (010603) all the way onto a 5/16-18 x 4" hex bolt (010678), install in the hole, then secure with a second nut. The bolt should extend at least 3-5/8" from the face of the front rail, as shown in Figure 2. The hex bolt is intended to be a support for a straight line running down the row.

Figure 1 Install bolts only in one of these holes

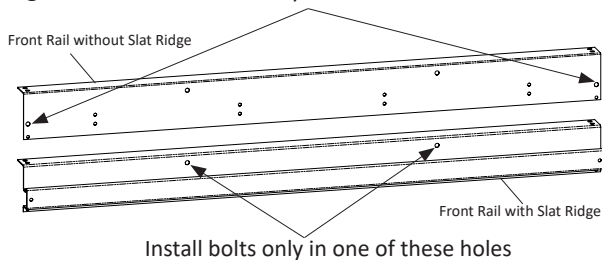
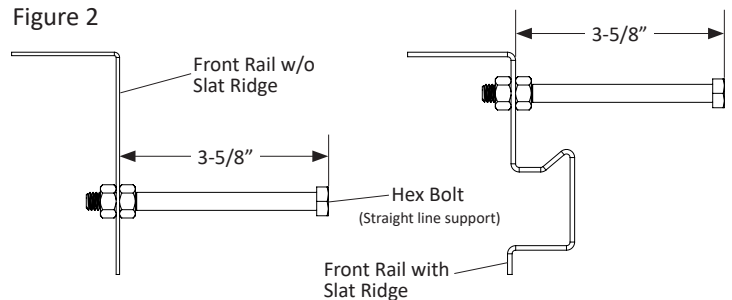
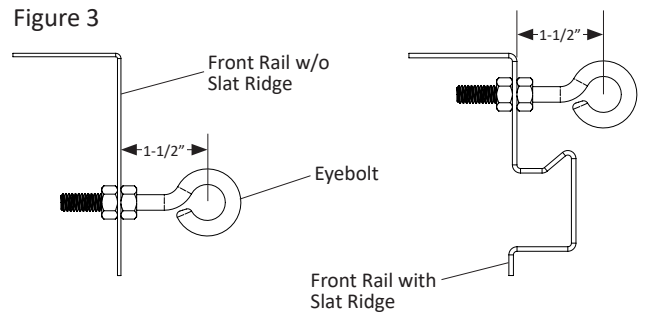


Figure 2



2. Continue another 40' down the nest and repeat step 1. Continue until you reach the end of the nest. Do not place a hex bolt in the final hole along the nest. Then anchor the feet of the legs attached to the last cross-support to the floor in the correct position, as determined by your layout guide line and square.
3. Return to the first frame of the nest and locate the first hole along the front rail. Thread a 5/16-18 nut (010603) onto a 5/16-18 x 2" eyebolt (750431) then install into the hole and secure with a second nut. Adjust the eye of the bolt to be approximately 1-1/2" from the outermost surface of the front rail, as shown in Figure 3.
4. Tie a masonry line (not included) to the eye bolt. Place one of the short sides of the Go/No-Go gauge against the outermost face of the front rail near the eyebolt. Ensure that the knot is located securely on the bolt so that it cannot slip out of position. Adjust the eyebolt's distance from the front rail until the line falls into the center of the gauge.
5. Walk down the row to the end of the nest with the end of the line, resting it on the previously installed hex bolts.
6. Locate the last hole along the front rail of the last frame (the hole furthest from the previously installed eyebolt). Install another eyebolt here, as in step 3. Pull the line as tight as possible, ensuring the line remains above the hex bolts, then tie it off. Ensure that the knot is located securely on the bolt so that it cannot slip out of position. Snap the line once to center.

Figure 3



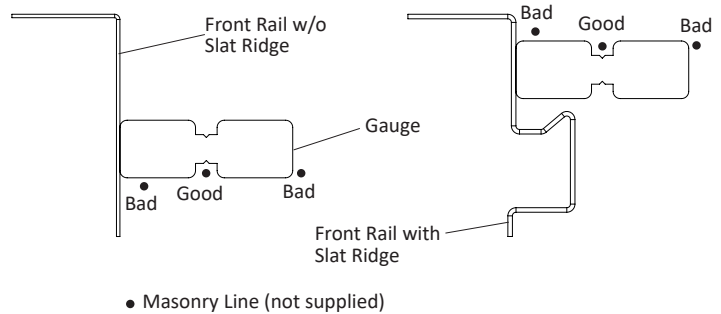
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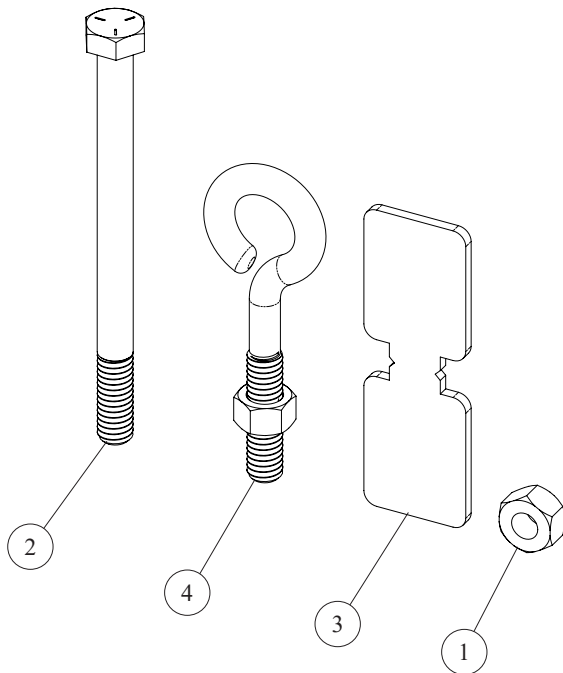
## Frame Assembly - Aligning the Nest Row - continued

7. Using the supplied Go/No-Go gauge (631754), check the line at each cross brace on each side of the system, as shown in Figure 4. The line should fall as close to the center of the gauge as possible. The width of the gauge represents the available tolerance in the belt tracking in either direction; if the line doesn't fall within the gauge the system will experience significant tracking issues, premature belt wear, and possible damage to / failure of equipment. If the line falls out of the gauge, move the frame until the line falls into the center of the gauge. DO NOT anchor the feet of the legs attached to the internal cross-supports to the floor at this time.
8. Continue adjusting until each cross-support is within tolerance. Be aware that making adjustments to a cross-support will affect adjacent cross-supports. Each time you make an adjustment to a cross-support, you must re-check ALL of the previously checked cross-supports to ensure your adjustment did not affect another part of the system.
9. Once the nest row is straight, anchor the remaining feet to the floor to secure the frame in place.

Figure 4



## Frame Alignment Kit (631753) - Parts List



KEY	PART #	DESCRIPTION	QTY
<b>ASSEMBLY</b>			
1	010603	5/16-18 HEX NUT	27
2	010678	5/16-18 X 4" HEX BOLT	12
3	631754	GO/NO-GO GAUGE, FRAME	1
4	750431	5/16-18 X 2" EYE BOLT	2

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