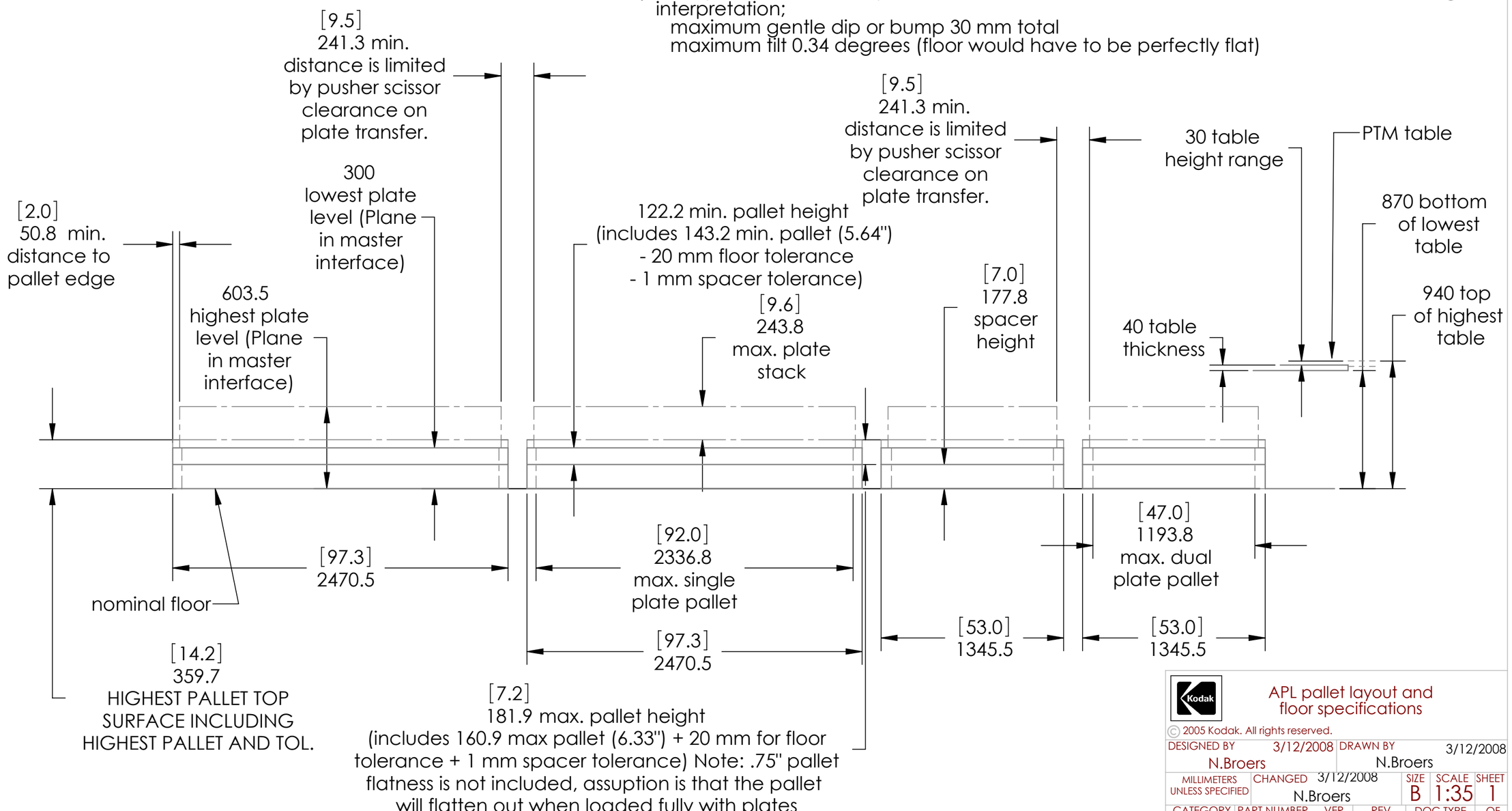
Flatness and Levelness Guidelines for Typical Applications			
Floor Use Category	Examples	Min. Flatness F-Number (FF)	Min. Levelness F-Number (FL)
Commercial/industrial use floors requiring better than average flatness/ levelness	Fork truck aisles, office areas employing modular relocatable partition systems, furniture display areas	30	25

Machine installation:
1) machine feet are adjusted to midrange of their travel (range is +20 mm to -20 mm)
2) machine is installed with feet at their midrange
3) adjustments are made to the feet only to compensate for the flatness of the floor
4) machine horizontal level is specified as 0.34 degrees (2.2" over 30')
5) 0.34 degrees gives a side load on the 300 kg gantry of 1.8 kg
6) the plate table is adjusted to match the base machine height
7) base machinetable range is as noted on the drawing, assumption is that the center foot of base machine is not adjusted, other feet are adjusted to compensate for the floor
8) floor spec for the APL is specified as an ASTM E1155-96 FL25 FF30 which has the following interpretation;
   maximum gentle dip or bump 30 mm total
   maximum tilt 0.34 degrees (floor would have to be perfectly flat)



APL pallet layout and floor specifications

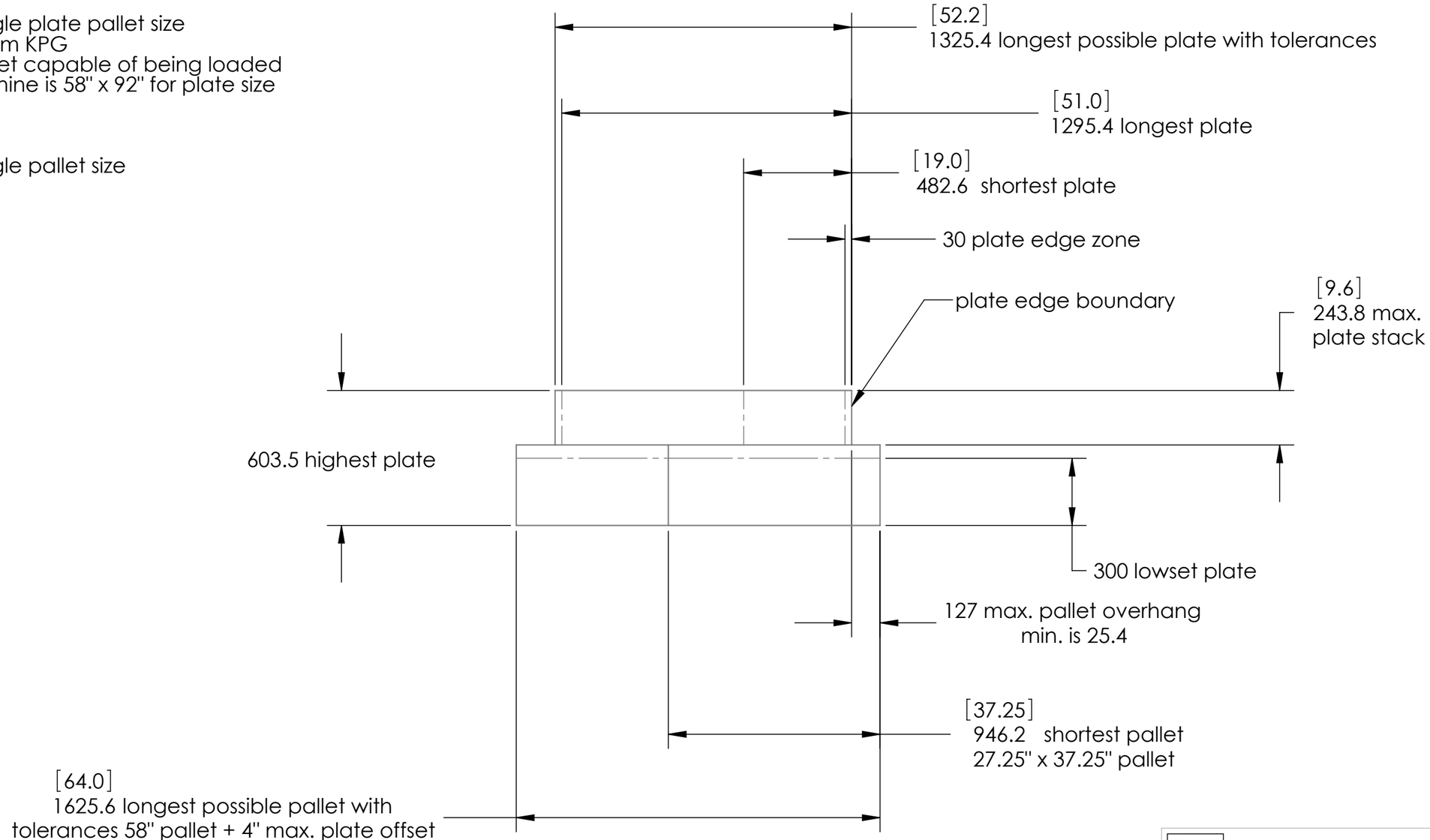
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DESIGNED BY		DRAWN BY				
N.Broers	3/12/2008	N.Broers	3/12/2008			
MILLIMETERS UNLESS SPECIFIED	CHANGED 3/12/2008 N.Broers	SIZE	SCALE	SHEET		
		B	1:35	1		
CATEGORY	PART NUMBER	VER	REV	DOC TYPE	OF	
707 -	00734A -		A	DD	3	

51" APL:
Largest dual plate pallet size
47" x 58" for plates up to 41.875" x 52.875"
largest dual plate is 40.5" x 51"

Largest single plate pallet size
44" x 92" from KPG
largest pallet capable of being loaded
in the machine is 58" x 92" for plate size
51" x 83"

63" APL:
Largest single pallet size
is 68" x 92"



APL Pallet layout and floor specifications

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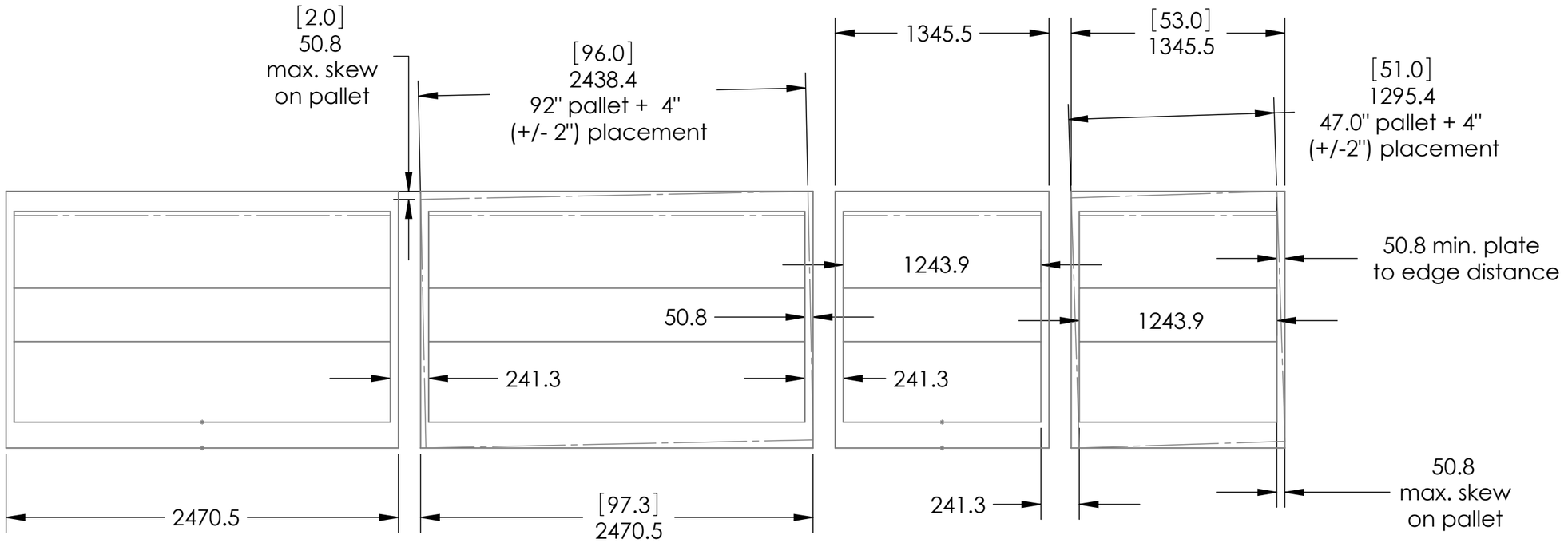
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3/12/2008 N.Broers		3/12/2008 N.Broers	
MILLIMETERS UNLESS SPECIFIED	CHANGED 3/12/2008 N.Broers	SIZE B	SCALE 1:20
SHEET 2			

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	OF
707 -	00734A -		A	DD	3

51" APL:
Largest dual plate pallet size
47" x 58" for plates up to 41.875" x 52.875"
largest dual plate is 40.5" x 51"

Largest single plate pallet size
44" x 92" from KPG
largest pallet capable of being loaded
in the machine is 58" x 92" for plate size
51" x 83"

63" APL:
Largest single pallet size
is 68" x 92"



APL pallet layout and floor specifications

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MILLIMETERS UNLESS SPECIFIED	CHANGED		SIZE	SCALE	SHEET
	N.Broers	3/12/2008	B	1:30	3

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	OF
707 -	00734A -		A	DD	3