

## IN-HOUSE PROCEDURE # \_\_\_\_\_

### PROCEDURE FOR VERIFYING ALIGNMENT DEVICE

Item:

Alignment Device (Guide Bars)

Purpose:

This method provides instructions for checking the perpendicularity and placement of guide bars for use with a capping plate.

Inspection Equipment Required:

1. Ruler or caliper readable to 0.05 in. (1 mm) or better.
2. Square 8 in. (200 mm) or 12 in. (300 mm)
3. Hex key 1/32 in. (1 mm) or 3/64 in. (1.5 mm)

Tolerance:

Equipment shall meet the dimensional tolerances specified in the applicable test method.

Procedure:

1. Align the capping plate with the guide bars.
2. Place the square so that one edge is in contact with both guide bars. Slide the square down to make contact with the capping plate keeping the edge against the guide bars.
3. Try to insert a 1/32 in. (1 mm) hex key for 4 inch capping plates or a 3/64 in. (1.5 mm) hex key for a 6 inch capping plate between the capping plate and the square. If this can be done, the guide bars are not perpendicular to the capping plate and must be adjusted until within 0.5 degrees.
4. Align a cylinder against the guide bars and lower into place. Measure the distance from the cylinder to the top inside edge of the capping plate in at least 4 locations spaced evenly around the cylinder. The maximum deviation between any measurements 0.06 in. (1.6 mm). Adjust the guide bars if centering is off and recheck.