

# TRAK Machine Tools / Southwestern Industries, Inc.

## Site Preparation Guide

### TRL 30120RX

#### Service Manual Link:

[https://www.southwesternindustries.com/media/manuals/29542\\_Manual.pdf](https://www.southwesternindustries.com/media/manuals/29542_Manual.pdf)

#### Programming Manual Link:

[https://www.southwesternindustries.com/media/manuals/29540\\_manual.pdf](https://www.southwesternindustries.com/media/manuals/29540_manual.pdf)

Before an Authorized Field Service Technician can perform the machine's final checkout, the following requirements must be met:

- The machine must be in position and placed on its rest pads
- To offload the machine, the forklift must be capable of lifting ~ 20000 lbs.
- The machine must be leveled (refer to installation and service manual).

#### Space & Weight

- Floor area = 212.6" x 86.61"
- Height = 79.53"
- Net (approx.) Weight = 18920 lbs.
- Shipping (approx.) Weight = 19270 lbs.
- Pallet Size (without chip conveyor) = 223.2" x 92.4"
- Pallet Size (with chip conveyor) = 253.32 x 92.4"
- A 36" clearance from the rear of the machine to the wall is required for repairs in the electrical enclosure.
- A solid and level foundation to maintain approximately 18920 lbs. plus the weight of the work piece is required. Ten leveling screws are provided.
- For best results, it may be necessary to lag bolt the machine in order to remove any small amount of twist.

#### Electrical

- Machine is only available in the 480 VAC configuration (432 to 528 volts is acceptable). A separate 480V, 62 amps, 60 Hz, 3 phase circuit is required.
- Machine tool must be earth grounded.

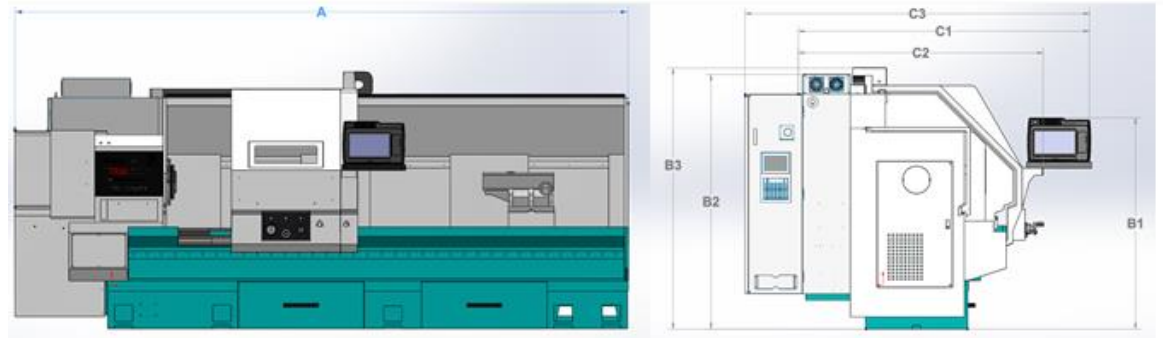
#### Air for Tailstock

- 1/4" NPT Connection
- Air Pressure not to exceed 100 psi

#### Coolant

- Please have coolant available during installation. This machine requires 48 gallons.

- The machine must be wired (refer to the installation and service manual).
- The machine must be cleaned. Remove all grease from the way surfaces.



		No Conveyor	With Conveyor
<b>A</b>	Overall Width	215.75"	272.75"
<b>A</b>	Overall Width with Spindle Motor Left Side Door Open (not shown)	240.75"	297.75"
<b>A</b>	Overall Width with Pendant Not Rotated (right door all the way to the right – not shown)	221.75"	N/A
<b>B1</b>	Height of Machine Base to Top of Pendant	71.5"	71.5"
<b>B2</b>	Height of Machine Base to Top of Electrical Cabinet	86"	86"
<b>B3</b>	Height of Machine Base to Top of Machine	88.25"	88.25"
<b>C1</b>	Depth of Machine with Pendant rotated 90° (door closed)	99"	105"
<b>C2</b>	Depth of Machine Pendant (door closed)	82.75"	88.75"
<b>C3</b>	Depth of Machine with Pendant rotated 90° (door open)	117.5"	123.5"

#### Conveyor Installed



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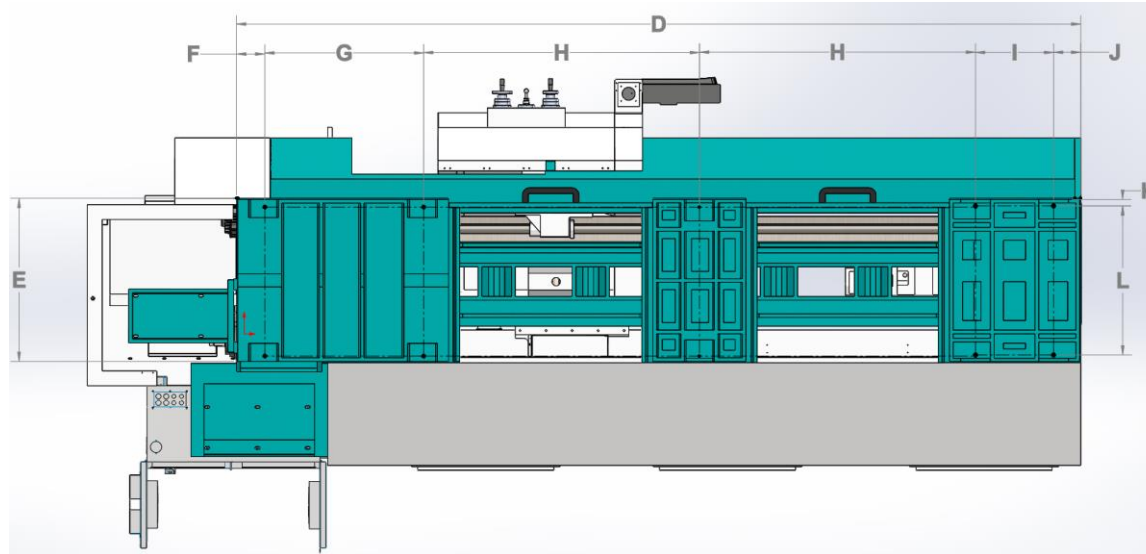


SOUTHWESTERN INDUSTRIES, INC.

2615 Homestead Place  
 Rancho Dominguez, CA 90220-5610 USA  
 T | 310.608.4422 | F | 310.764.2668  
 Service Department: 800.367.3165

E-mail: [sales@trakmt.com](mailto:sales@trakmt.com) | [service@trakmt.com](mailto:service@trakmt.com) | web: [www.trakmt.com](http://www.trakmt.com)

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<b>D</b>	Max Width of Machine Footprint	179"
<b>E</b>	Max Depth of Machine Footprint	34.75"
<b>F</b>	Distance from Left side of machine base to center of leveling pad	5.5"
<b>G</b>	Distance between leveling pads on left side of machine base	33.75"
<b>H</b>	Distance between left side & right-side leveling pads to center leveling pads	58.75"
<b>I</b>	Distance between leveling pads on right side of machine base	16.75"
<b>J</b>	Distance between right side of machine base to center of leveling pad	6"
<b>K</b>	Distance on right side machine base to center of leveling pad	1.5"
<b>L</b>	Distance between center of leveling pads	31.875"

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E-mail: [sales@trakmt.com](mailto:sales@trakmt.com) | [service@trakmt.com](mailto:service@trakmt.com) | web: [www.trakmt.com](http://www.trakmt.com)

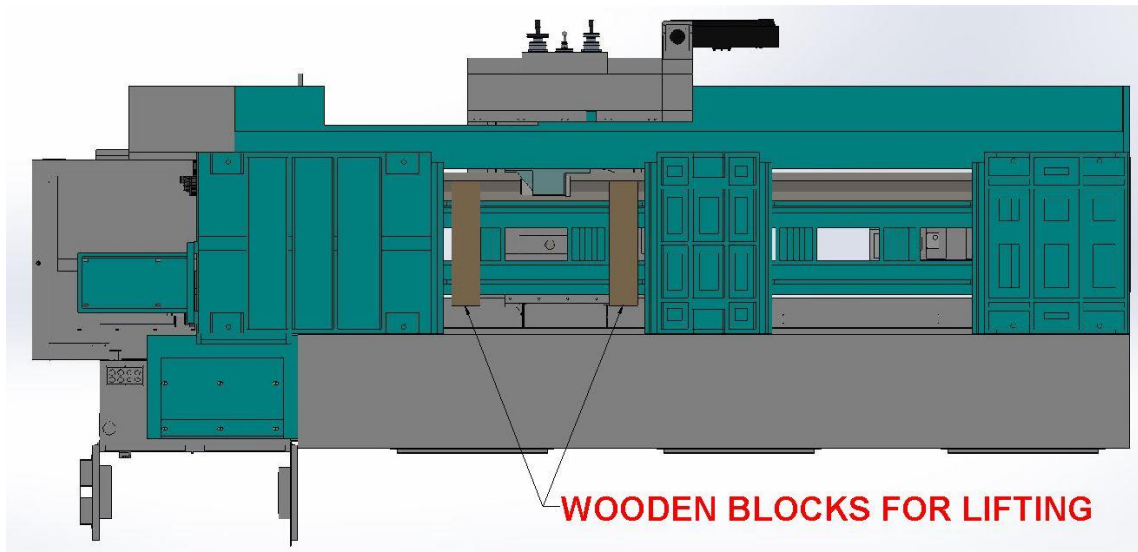
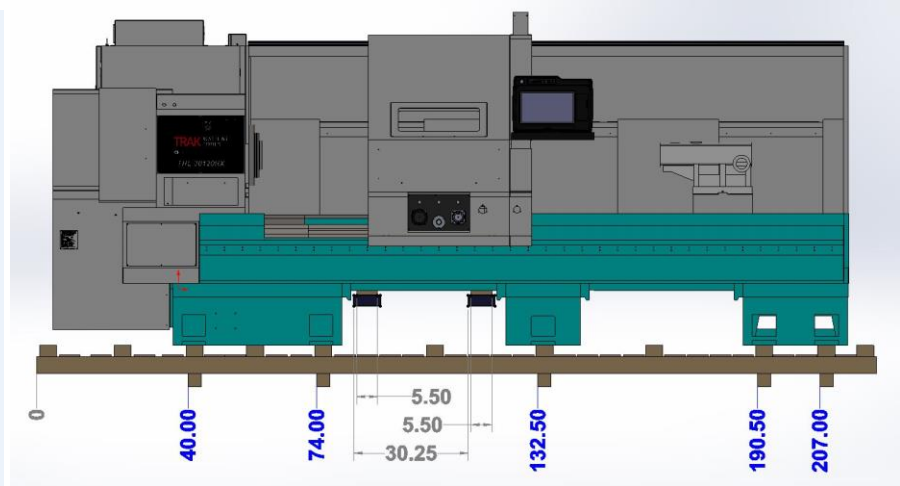
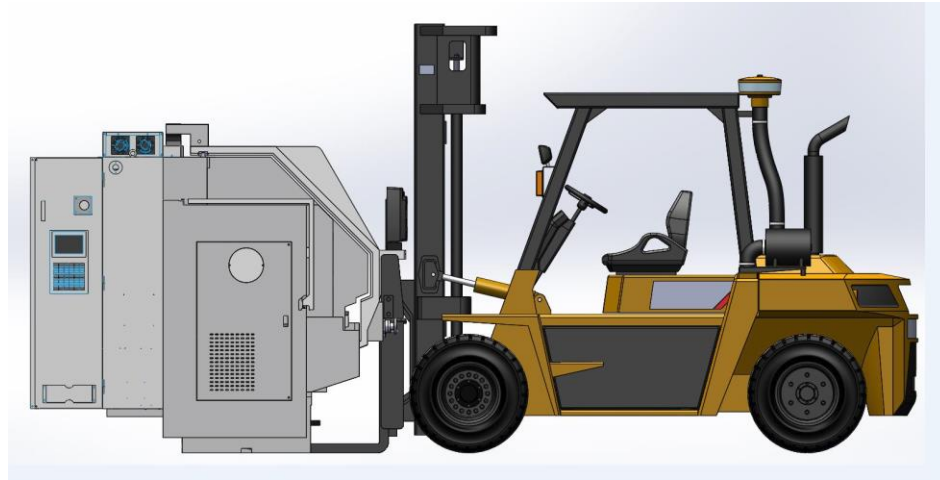
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# Lifting and/or Moving the Machine

## CAUTION!

Proper equipment of sufficient capacity must be used when lifting and/or moving the machine.

To lift machine, use 2 blocks of wood on top of the forklift forks as shown below. Make sure blocks of wood are touching the bed casting of the lathe and not the sheet metal. Place forks as shown in picture below to balance machine when lifting.



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