

TRAK Machine Tools / Southwestern Industries, Inc.

Site Preparation Guide

TRL 1630SX & 1630HSSX

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, a 6000 lb. forklift with 6' extension is required.
- The machine must be leveled (refer to installation and service manual).
- The machine must be wired (refer to the installation and service manual).
- The machine must be cleaned. Remove all grease from the way surfaces.

Space & Weight

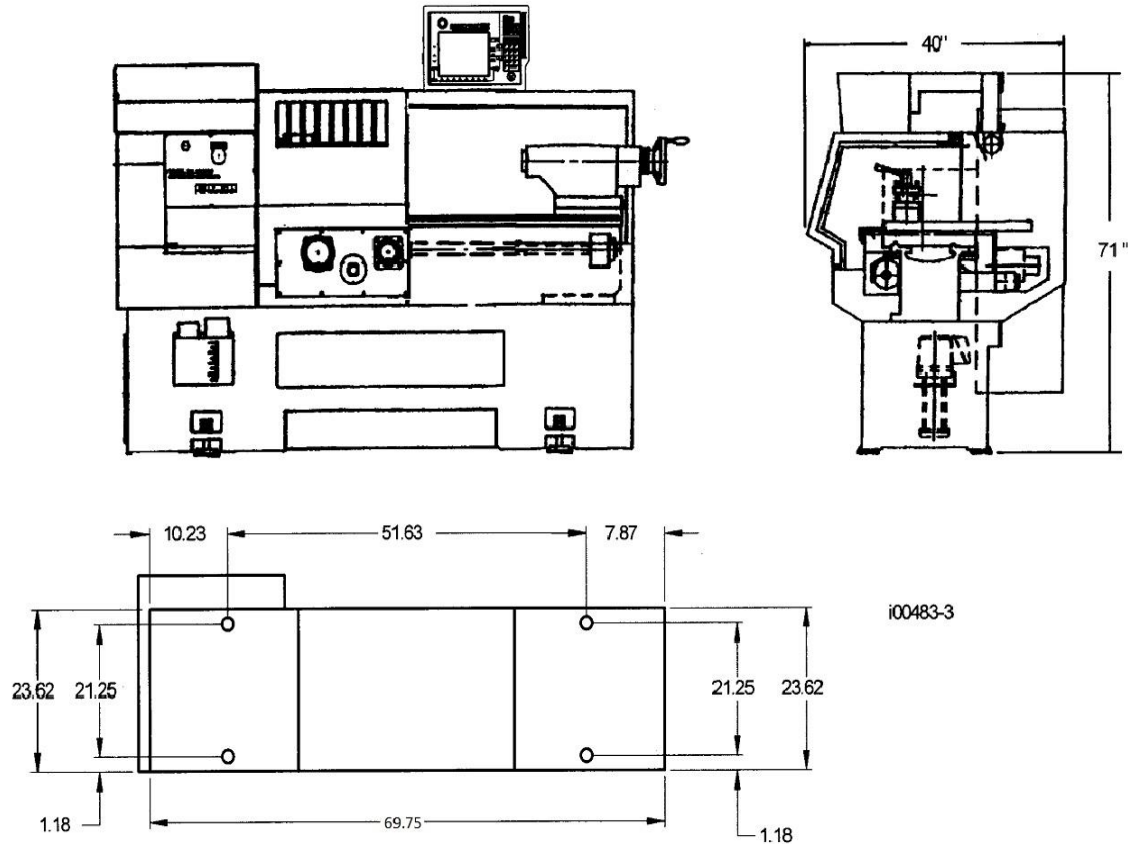
- Floor area = 84" x 40"
- Height = 71"
- Net (approx) Weight = 2875 lbs.
- Shipping (approx) Weight = 3420 lbs.
- A 36" clearance from the rear of the machine to the wall is required for repairs in the electrical enclosure.
- A solid and level foundation to maintain approximately 3420 lbs. plus the weight of the work piece is required. Four 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

- A separate 220 VAC, 25 Amp, 60 Hz, 3 phase circuit is required to maintain proper operation.
- A separate 110 VAC, 12 amps minimum, 60 Hz circuit is required to maintain proper operation.
- For shops with 440 VAC, a step-down transformer to 220 VAC must be used. The transformer must be sized to carry a load of 25 amps minimum.
- Machine tool must be earth grounded.

Air

- Not required



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 SOUTHWESTERN INDUSTRIES, INC.

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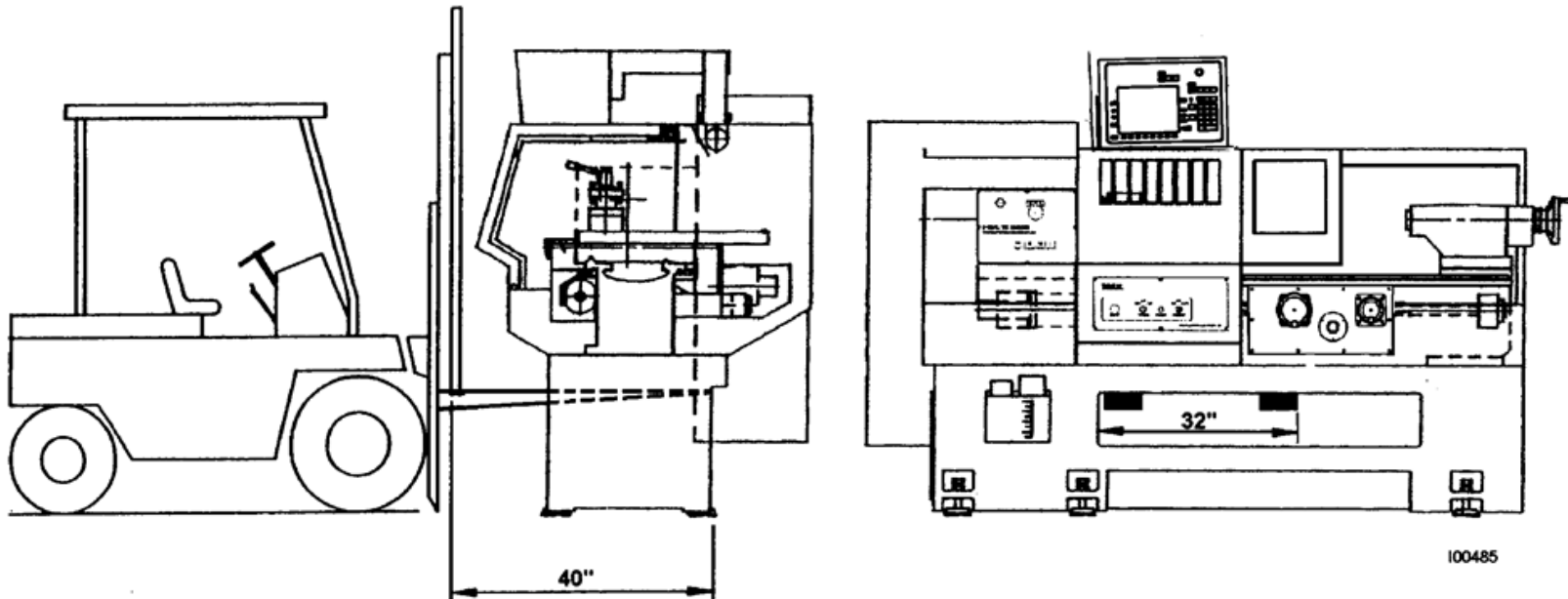
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Lifting and/or Moving the Machine

CAUTION!

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

To lift the machine, remove the chip pan. Place the forks of the forklift at least 32" apart as shown in the figure below. Be certain to lift the lathe toward the headstock. Use 2 blocks of wood (~6" high x 18" long) on forklift forks during lifting and make sure they contact the bed casting. This will avoid damaging the machine's sheet metal.



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