

Southwestern Industries, Inc.

Site Preparation Guide

TRL 1845SX

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 8000 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 = 94" x 52"
- Height = 73"
- Net (approx) Weight = 3285 lbs.
- Shipping (approx) Weight = 3800 lbs.
- The 94" width dimension above measures to the edge of the pendant arm when it is in the proper position.
- It is recommended to leave at least 24" on the left side of the lathe from the wall to allow some additional rotation of the pendant arm and for service purposes. If you install a collet closer, then approximately 36" of clearance is needed.
- 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 3300 lbs. plus the weight of the work piece is required. Six 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.

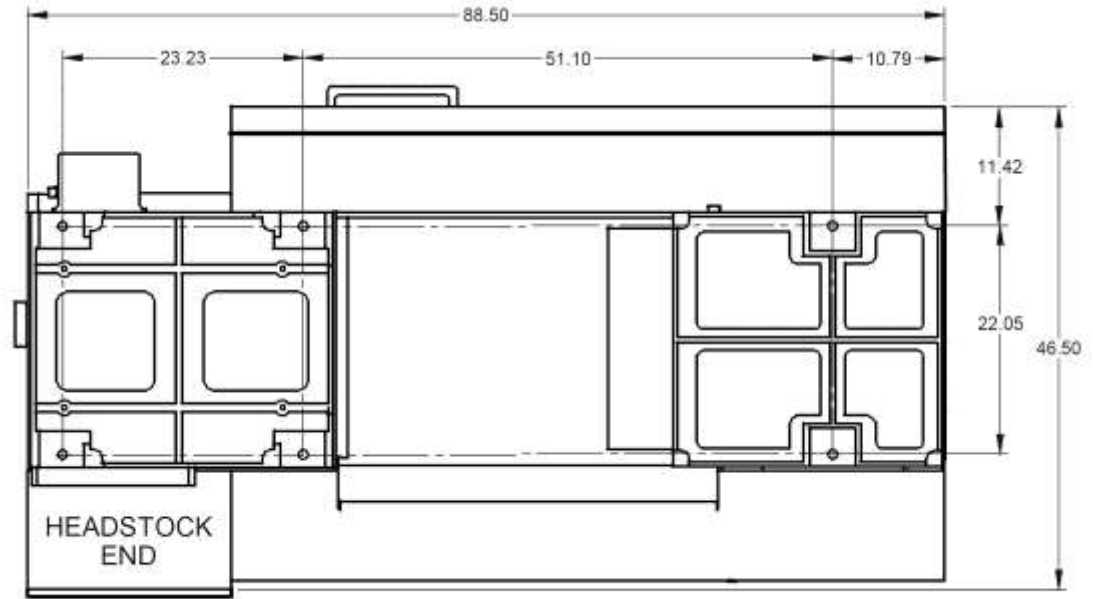
Electrical

- A separate 220 VAC, 33 Amp, 60 Hz, 3 phase circuit is required to maintain proper operation. 208 to 240 volts is acceptable
- 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 33 amps minimum.
- Machine tool must be earth grounded.

Air

- Not required except if an 8-tool indexer is installed.

Bottom View of Lathe – shows the 6 leveling bolts.



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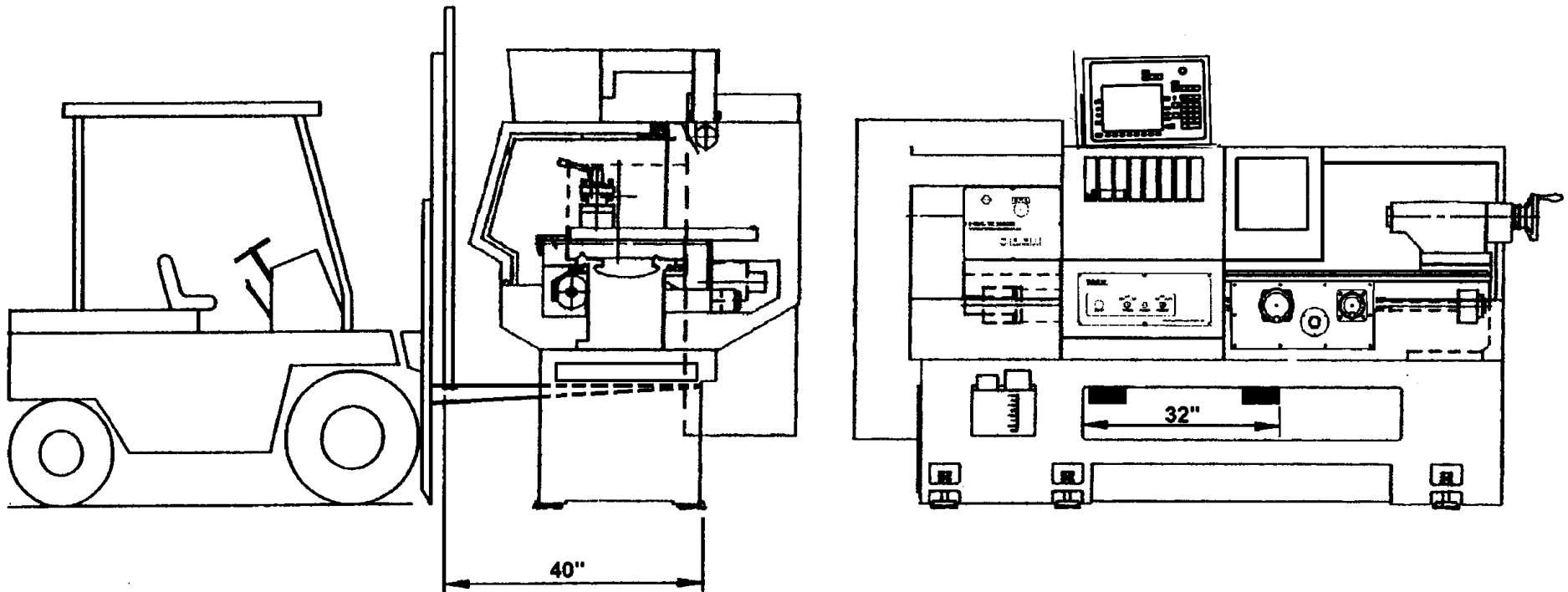
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Lifting and/or Moving the Machine

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. Using 2 blocks of wood (6" high x 18" long), place on forks during lifting, this will prevent forks from damaging sheet metal. Be certain to lift the lathe toward the headstock.



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