

Southwestern Industries, Inc.

Site Preparation Guide

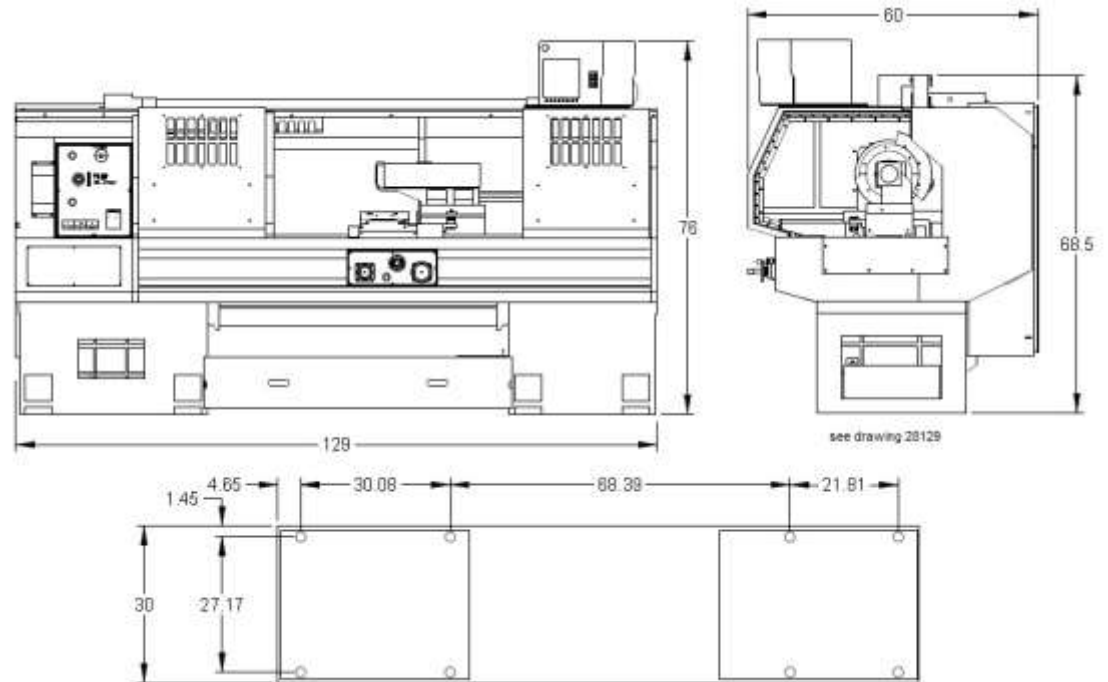
TRL 2470SX

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 15000 lb. forklift with 8' 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 = 129" x 60"
- Height = 76"
- Net (approx) Weight = 6500 lbs.
- Shipping (approx) Weight = 6900 lbs.
- Pallet size = 134" x 66"
- A 36" clearance from the rear of the machine to the wall is required for repairs in the electrical enclosure. The electrical cabinet door extends ~24" when open.
- A solid and level foundation to maintain approximately 6500 lbs. plus the weight of the work piece is required. Eight 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, 42 Amp, 60 Hz, 3 phase 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 42 amps minimum.
- If you order a 220 to 110 volt transformer option, then full load amps is 46.
- A separate 110VAC, 15 amp min, 60 Hz circuit is required to maintain proper operation.
- Machine tool must be earth grounded.

Air

- Not required unless a 8 tool indexer option is ordered.



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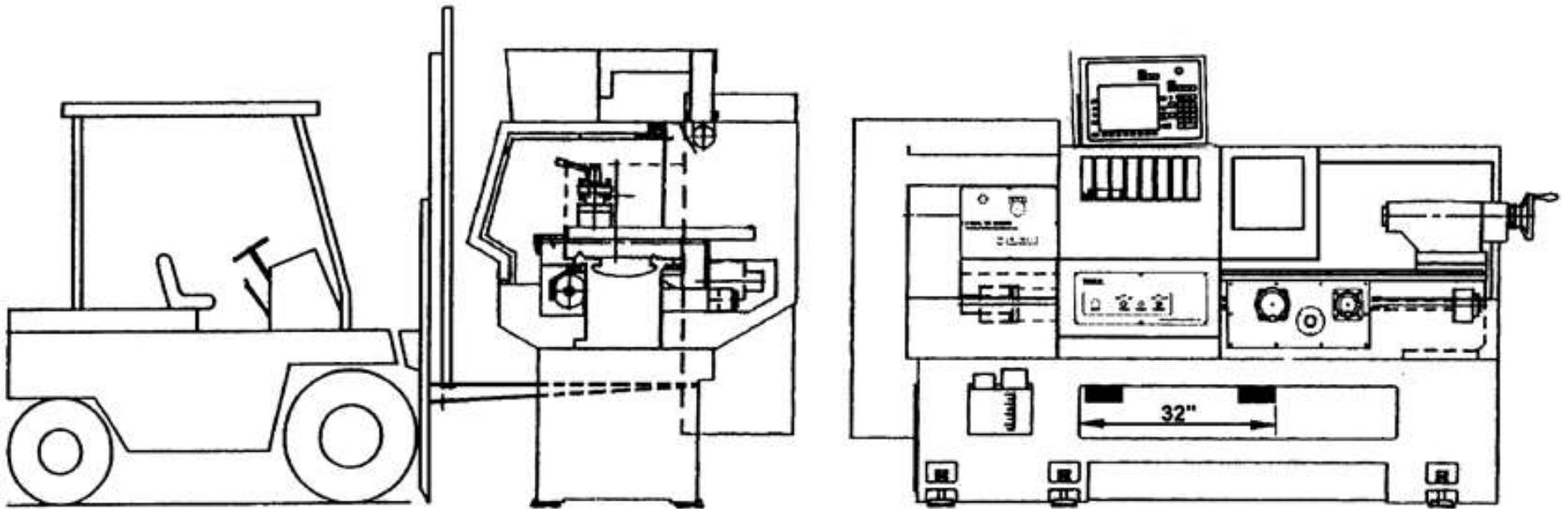
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Lifting and/or Moving the Machine

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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