

## Site Preparation Guide

### TRL 2470RX

**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, 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 = 129.13" x 84"
- Height = 69.13"
- Net (approx) Weight = 6500 lbs.
- Shipping (approx) Weight = 6900 lbs.
- Pallet Size = 134.4" x 66"
- 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 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

- Machine is only available in the 208 VAC configuration (200 to 240V is acceptable). A separate 208V, 73 amps, 60 Hz, 3 phase circuit is required. For shops with 440 VAC, a step-down transformer to 208 VAC must be used. The transformer must be sized to carry a load of 73 amps.
- Machine tool must be earth grounded.

### Air for Turrets

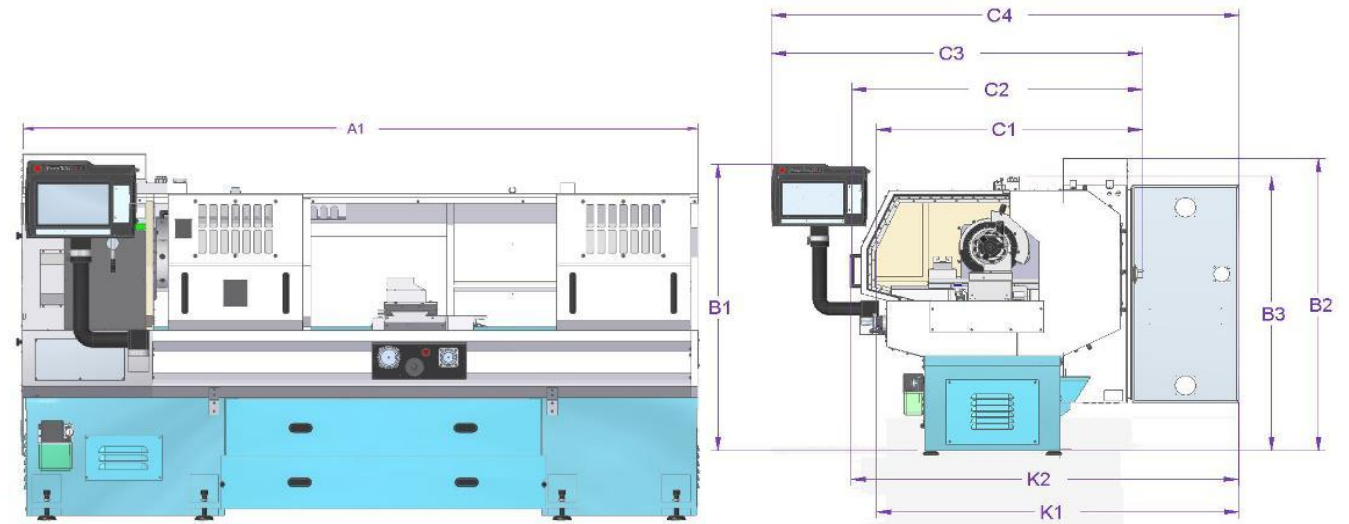
- 1/4" NPT Connection
- Air Pressure not to exceed 100 psi

### 8 Tool TRAK CNC Turret

- 11 SCFM or 1.83 CFM at 80 psi

### 4 Tool TRAK CNC Turret

- 15 SCFM or 2.1 CFM at 90 psi

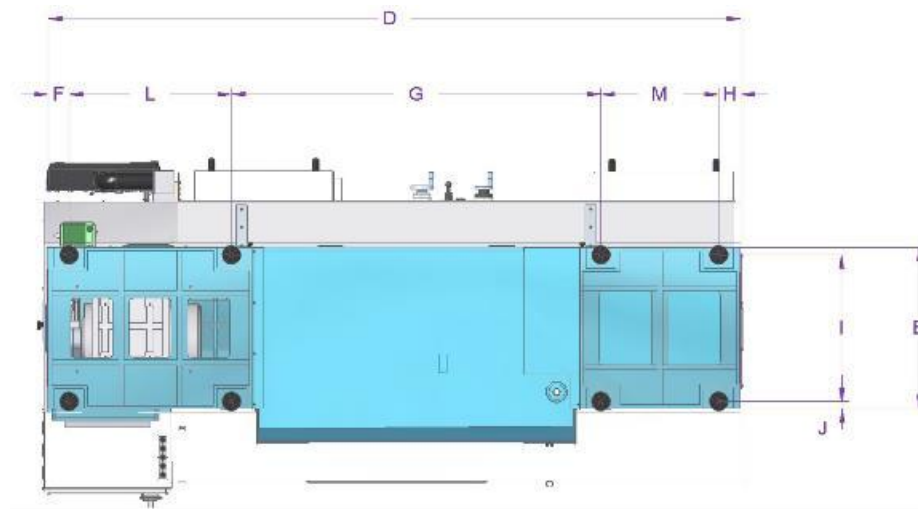


<b>A1</b>	Overall Width	129.125"
<b>A2</b>	Maximum Width of Machine (Pendant arm retracted)	89.9375"
<b>B1</b>	Height of Machine Base to Top of Pendant	67.6875"
<b>B2</b>	Height of Machine Base to Top of Machine	69.125"
<b>B3</b>	Depth of Machine with Pendant swung out (door closed)	64.875"
<b>C1</b>	Depth of Machine with Pendant retracted (door closed)	82"
<b>C2</b>	Depth of Machine with Pendant retracted (door closed)	64.75"
<b>C3</b>	Depth of Machine with Pendant swung out & rotated 90° (door closed)	84"
<b>C4</b>	Depth of Machine with pendant swung out & rotated 90° (door open)	103.375"
<b>K1</b>	Depth of Machine with Pendant retracted (door open)	103.5"
<b>K2</b>	Depth of Machine with Pendant swung out (door open)	88.3125"

### Coolant Option

- If you have purchased the coolant pump option, please have coolant available at installation. This machine requires 15 gallons.

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<b>D</b>	Max Width of Machine Footprint	129.062"
<b>E</b>	Max Depth of Machine Footprint	30"
<b>F</b>	Distance from Left side of machine base to center of right leveling pad	3.875"
<b>G</b>	Distance between leveling pads across machine	68.625"
<b>H</b>	Distance between center of left leveling pad to left side of machine base	4.125"
<b>I</b>	Distance between front and back leveling pads	27.1875"
<b>J</b>	Distance between back leveling pad and back of machine base	1.625"
<b>L</b>	Right machine base: distance in between leveling pads (width)	30.3125"
<b>M</b>	Left machine base: distance between leveling pads (width)	21.8125"

## 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 void damaging the machine's sheet metal.

