

Southwestern Industries, Inc.
Site Preparation Guide
TRAK DPMSX5P

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 10000 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 have air hooked up if power drawbar is installed (see the installation and service manual).
- The machine must be cleaned. Remove all grease from the way surfaces.

Space & Weight

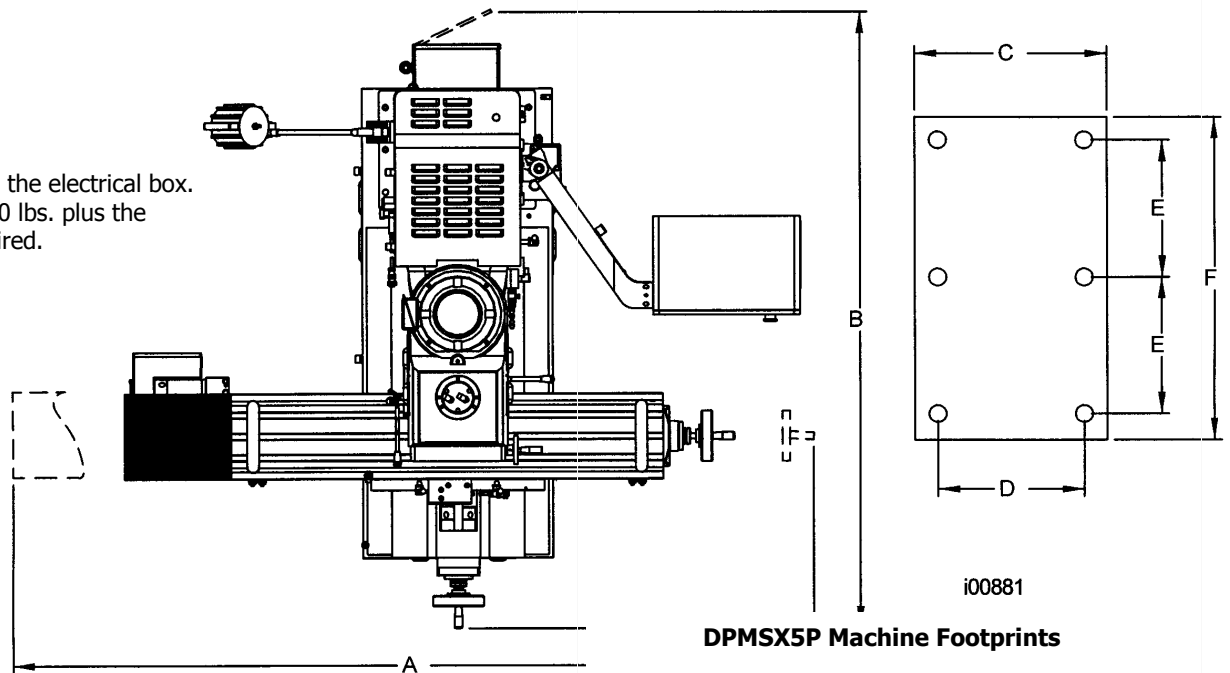
- Floor area = 136" x 71"
- Height = 98"
- Footprint = 24" x 48.4"
- Net (approx) Weight = 4400 lbs.
- Shipping (approx) Weight = 4700 lbs.
- Pallet Size = 6' x 6', 8" thick
- Allow clearance at the rear of the mill to open and work on the electrical box.
- A solid and level foundation to maintain approximately 4400 lbs. plus the weight of the work piece (maximum total 6200 lbs) is required. Six leveling screws are provided.

Electrical

- Machine with Spindle Control Option is only available in the 220 VAC configuration. A separate 220V, 17.5 amp minimum, 60 Hz, 3 phase circuit is required. 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 17.5 amps minimum.
- A separate 110 VAC, 10 Amps minimum, 60 Hz circuit is required to maintain proper operation.
- Machine tool must be earth grounded.

Air (for optional Power Draw Bar)

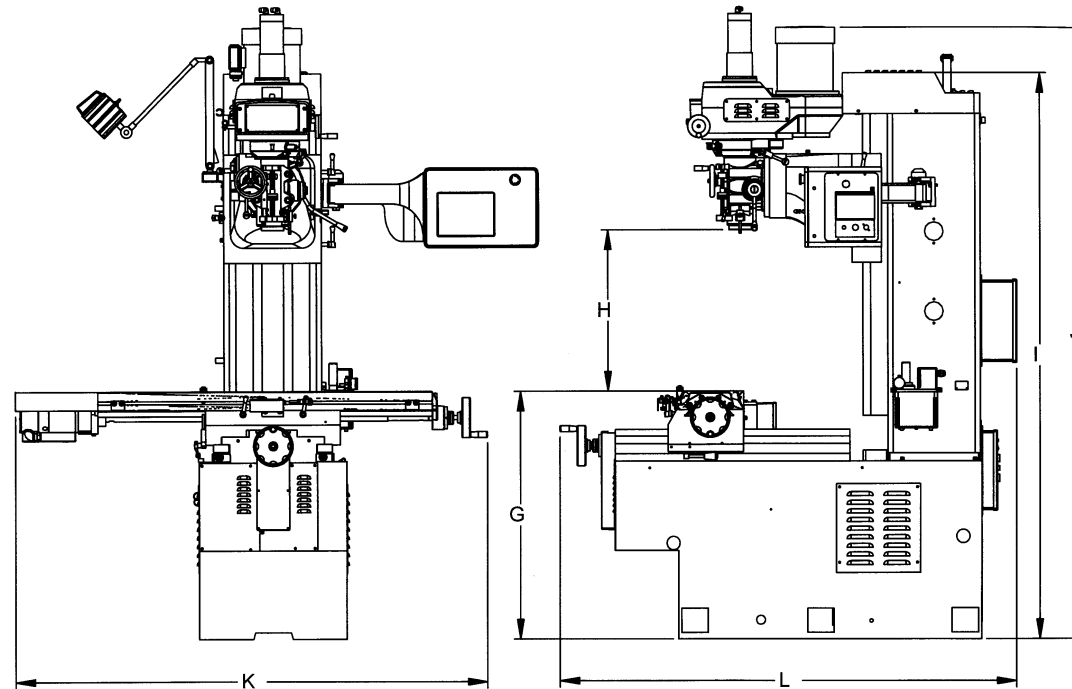
- 1/4" NPT connection
- Air pressure not to exceed 100 psi
- 17.5 SCFM or 2.5 CFM at 90 psi



DPMSX5P Machine Footprints

A	Overall width	136"
B	Overall length	81"
C	Bed width	24"
D	Bed width between leveling screws	21.7"
E	Distance between leveling screws	20.5"
F	Bed length	48.4"

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DPMSX5P Overall Dimensions

G	Height of table from bottom of bed	41"
H	Maximum distance from spindle nose to table	23.5"
I	Height of machine from bottom of bed to top of column cover	87"
J	Maximum height of machine from bottom of bed to top of spindle motor	98"
K	Width of machine including table tray	94"
L	Length of machine with electric box door closed	71"



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@southwesternindustries.com | service@southwesternindustries.com | web: southwesternindustries.com

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Lifting and/or Moving the Machine

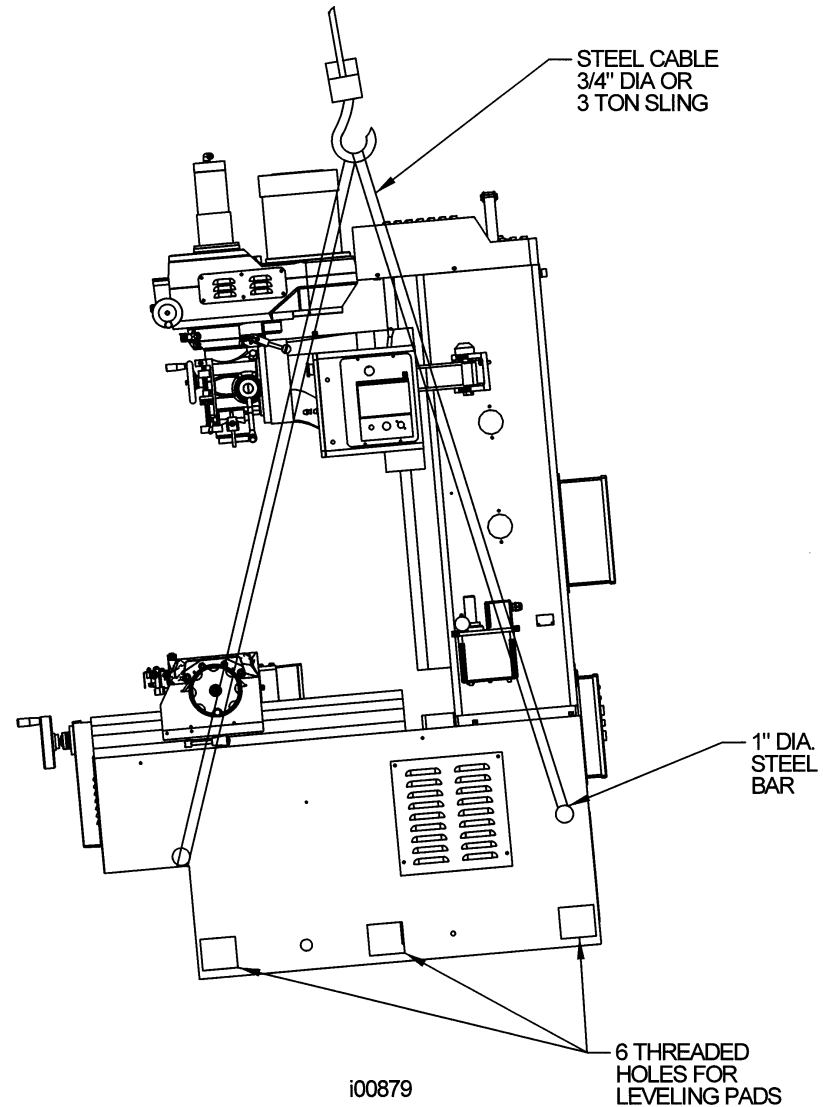
CAUTION!

The DPMSX2, SX3 & SX5 machines weigh approximately 3200, 4100 and 4400 lbs. respectively. Proper equipment of sufficient capacity must be used when lifting and/or moving the machine.

Method 1:

1. Insert a steel bar 1.0" dia x 36" long through the side holes of the bed (under column).
2. Use a steel cable (with protective sleeving) min. 3/4" dia. or a 3 ton sling.
3. Use cardboard pieces or other suitable protective sheets on both sides of the machine to prevent scratching.
4. Remove the 4 nuts and screws holding the machine to the wood skid.
5. Lift the machine (the front side of the machine should be lower than the back side).
6. Insert the 6 screws for leveling pads in their place in the bed. 4 screws for DPMSX2.
7. Place the machine in its location (see floor plan and bed footprint drawing) carefully positioning each leveling pad under each leveling screw.
8. Remove the lifting cable or sling, the steel bar and all protective cardboard.

Method 1



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Lifting and/or Moving the Machine

Method 2 (see Figure):

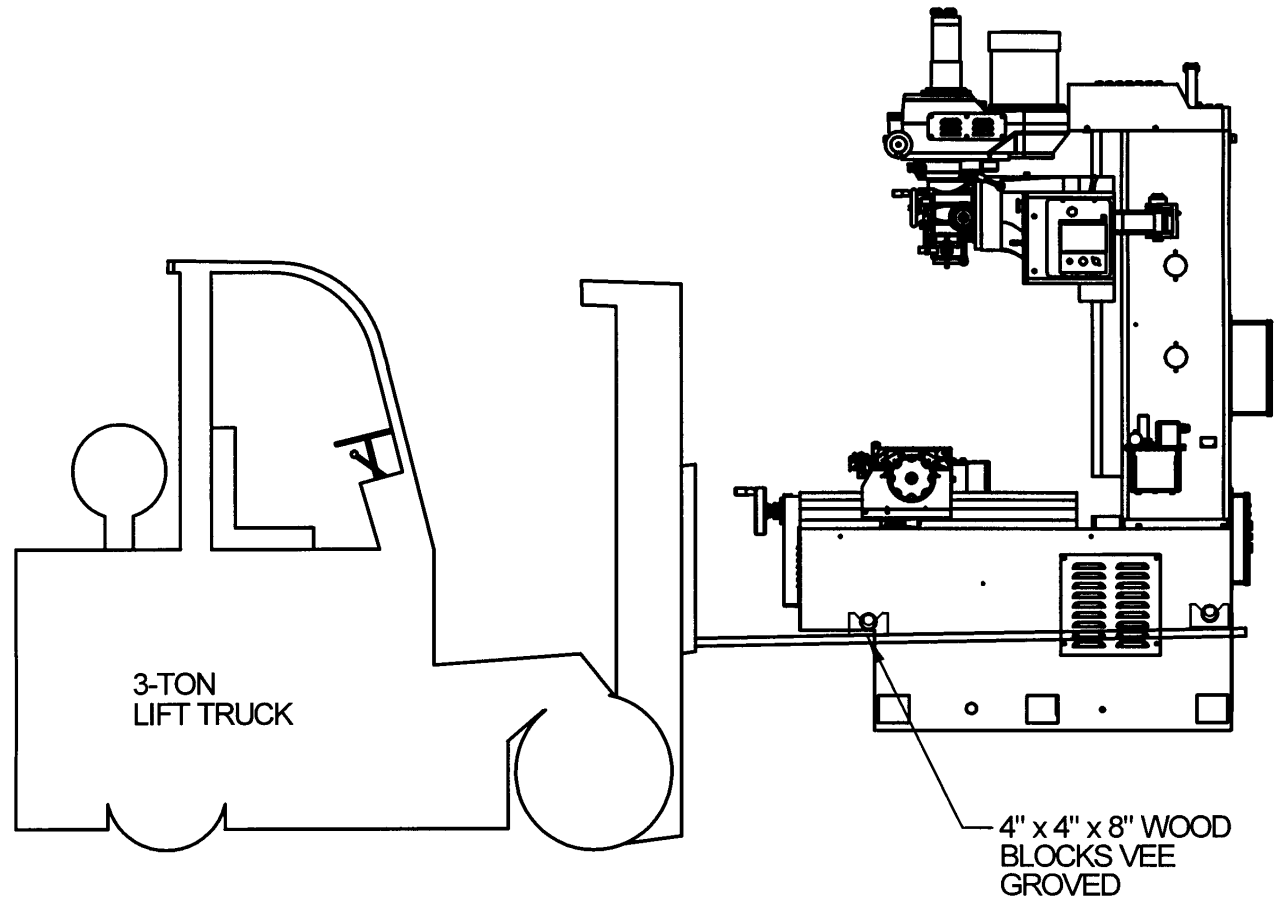
1. Insert 2 steel bars 1" dia x 36" long through both sides in the existing holes in the machine base (front and back).
2. Position 4 (two each side) wood vee blocks under the steel bars and over a suitable lift truck.
3. Lift the machine up (somewhat tilted towards the front) 4-6" from the ground and move it to its floor plan position.

WARNING!

The lift truck must have sufficient lifting capacity (3 tons) and be equipped with suitably long forks.

4. Insert the 6 screws for the leveling pads in their place in the bed.
5. Place the machine in its location (see floor plan bed/footprint) carefully positioning each leveling pad under each leveling screw.

Method 2



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