

# Site Preparation Guide

## TRAK 2 OP M11 Milling Machine

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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 its leveling pads installed.
- To move the machine while on the pallet, a 5000 lb. forklift with a 24" load center & 6' fork extensions is required. Depending on the load center or rating of the forklift, a larger forklift may be required. The center of gravity (CG) of the machine while on the pallet is ~24" from the edge of the pallet. Please see the manual for more information about lifting the machine.
- If you are lifting the machine along its length, the mill should be lifted from side of the pallet where the column is located. See the lifting photo's below.
- The 2 OP mill can be lifted from the pallet from the side and back of the machine. Once the machine is lifted from the pallet, the leveling pads must be threaded into the leveling spacers. See picture.
- A pallet jack is provided with each machine so the user can move the machine around the shop as required. See programming or service manual for detail instructions on how to move machine.
- The machine must be wired (refer to the installation and service manual for additional information).
- The machine must have air hooked up. We strongly recommend that a water separator or air dryer be installed upstream of the 2 OP air supply.

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### Space & Weight

- Floor area = 30.5" x 52"
- Height = 101"
- Footprint = 30.5" x 52"
- Net (approx.) Weight = 2825 lbs.
- Shipping (approx) Weight = 3175 lbs.
- Pallet size = 35" x 78"
- A solid and level foundation to maintain approximately 2825 lbs. plus the weight of the workpiece is required.
- Minimum doorway width and height the 2 OP can fit through is 31" x 79". The 79" dimensions requires the following parts to be removed: servo cabinet, Z motor, Z motor bracket, status light, leveling feet and Z cable carrier needs to be collapsed. The Z ballscrew will now be the highest point of the machine. The 79" dimension is 92" if the servo cabinet is left on the machine.

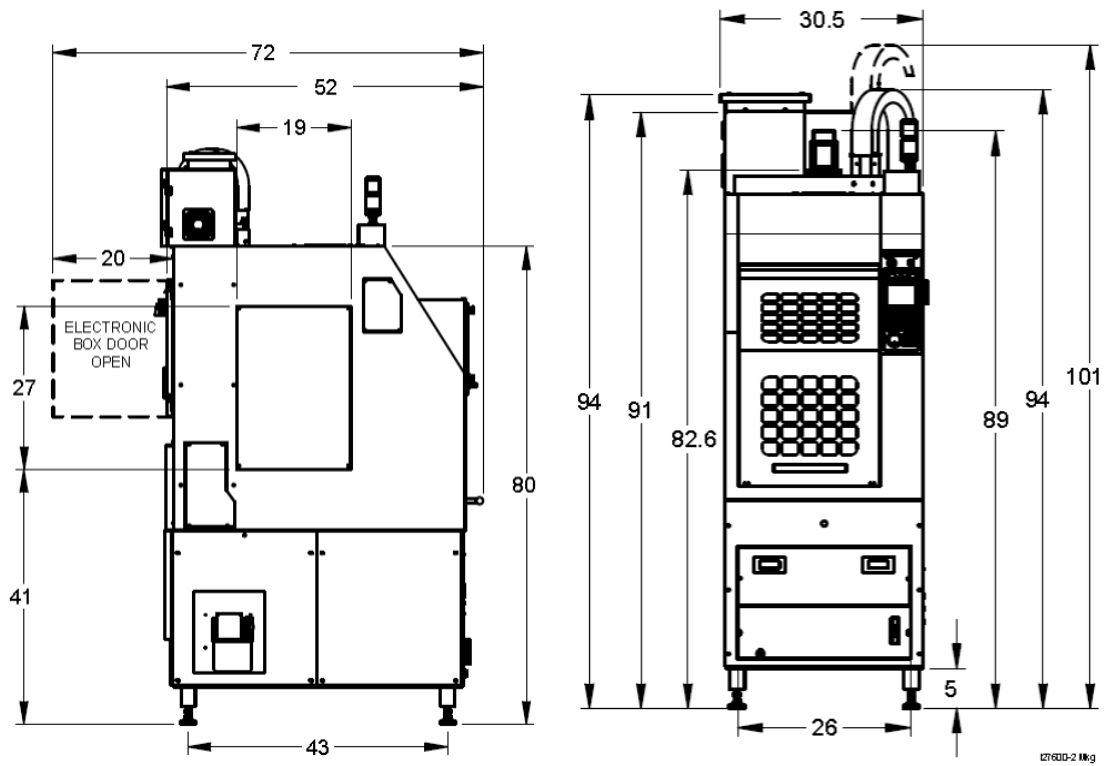
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### Electrical

- A separate 220 VAC (208 to 240 V is acceptable), 30 amp minimum, 60 Hz, 3 phase circuit is required or 440 VAC (400 to 460 V is acceptable 15 amp minimum, 60 Hz 3 phase circuit.
- Machine can be run on single phase 220 volt but cutting capacity is reduced by 40%.
- Machine comes standard with 220 Volts. 440 volts is optional and strongly recommended it be installed at factory.
- This machine is meant to be moved around the shop so the appropriate quick disconnect drops should be installed in the shop locations where the machine may be moved. See pictures below the male plugs we provide. Female equivalent plugs are to be provided by the user.

### Air

- ½" ID minimum air connection is required.
- Air pressure must be a minimum of 90 psi.
- CFM and SCFM max - 2.5 and 18 respectively



**Figure 1 – Overall Dimensions of 2 OP M11**



**Figure 2 – Lifting the 2 OP**



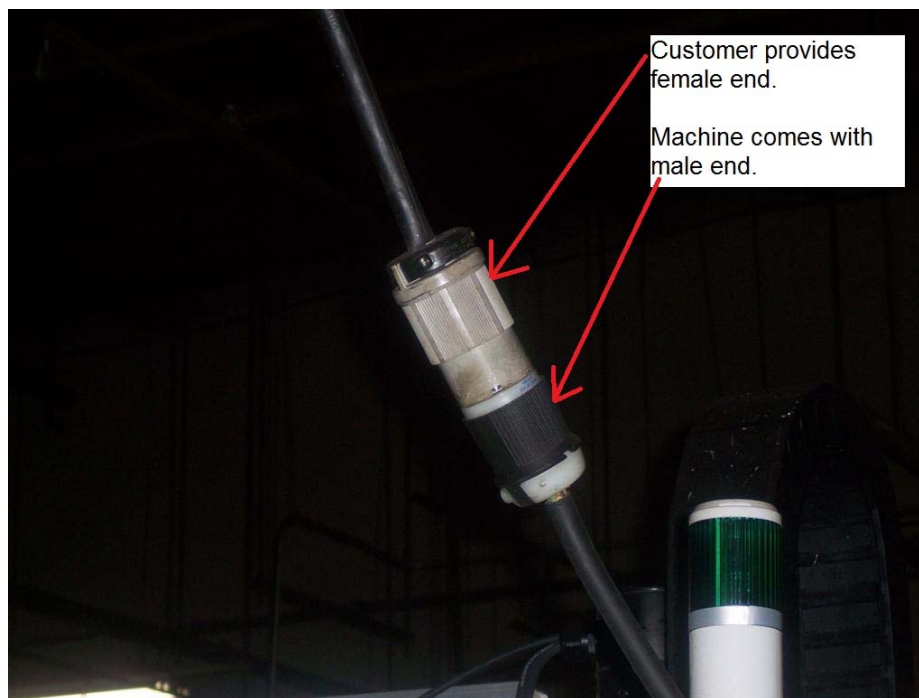
**Figure 3 – Installing Leveling Pads**



**Figure 4 – Moving with Pallet Jack**



**Figure 5 – Electrical Quick Disconnect Plugs (Male)**



**Figure 6 – Power cable example**



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