

Southwestern Industries, Inc.

Site Preparation Guide

TRAK K3 with KMX Control

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 machine, a 6000 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

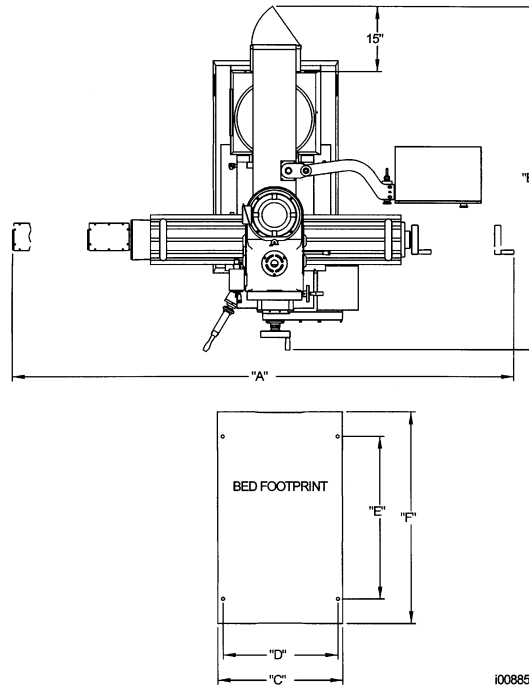
- Floor area = 103" x 70"
- Height = 87"
- Footprint = 24.2" x 38.8"
- Net (approx) Weight = 2800 lbs.
- Shipping (approx) Weight = 3100 lbs.
- Pallet Size = 6' x 6', 8" thick
- Allow clearance at the rear of the mill to open and work on the electrical box.
- A solid and level foundation to maintain approximately 2800 lbs. plus the weight of the work piece (maximum total 3700 lbs) is required. Four leveling screws are provided.

Electrical

- A separate 220/440 VAC, 8.5/4.3 Amps minimum, 60 Hz, 3 Phase circuit is required to maintain proper operation
- A separate 110 VAC, 10 Amps minimum, 60 Hz circuit is required to maintain proper operation.
- Machine tool must be earth grounded.

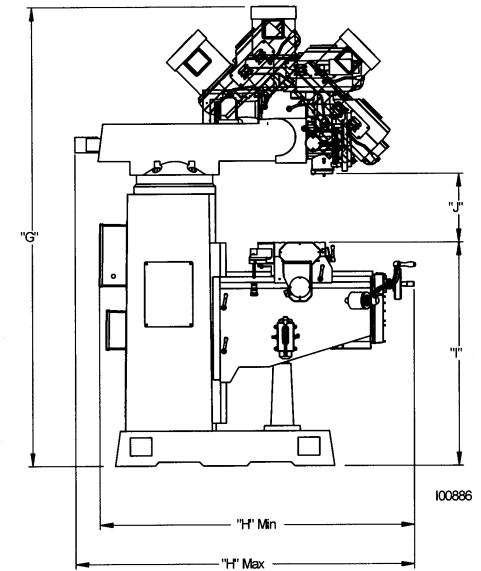
Air (for optional Power Draw Bar)

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



TRAK K3 Machine Footprints

A	Overall width	103"
B	Overall length	70"
C	Bed width	24.2"
D	Bed width between leveling screws	21.9"
E	Distance between leveling screws	29.7"
F	Bed length	38.8"



TRAK K3 Overall Dimensions

G	Height of machine from bottom of base to top of spindle motor	87"
H min	Minimum length of machine	64"
H max	Maximum length of machine	78"
I min	Minimum height of table from bottom of base	38"
I max	Maximum height of table from bottom of base	49"
J max	Maximum distance from spindle nose to table	17"



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2615 Homestead Place

Rancho Dominguez, CA 90220-5610 USA

T | 310.608.4422 | F | 310.764.2668

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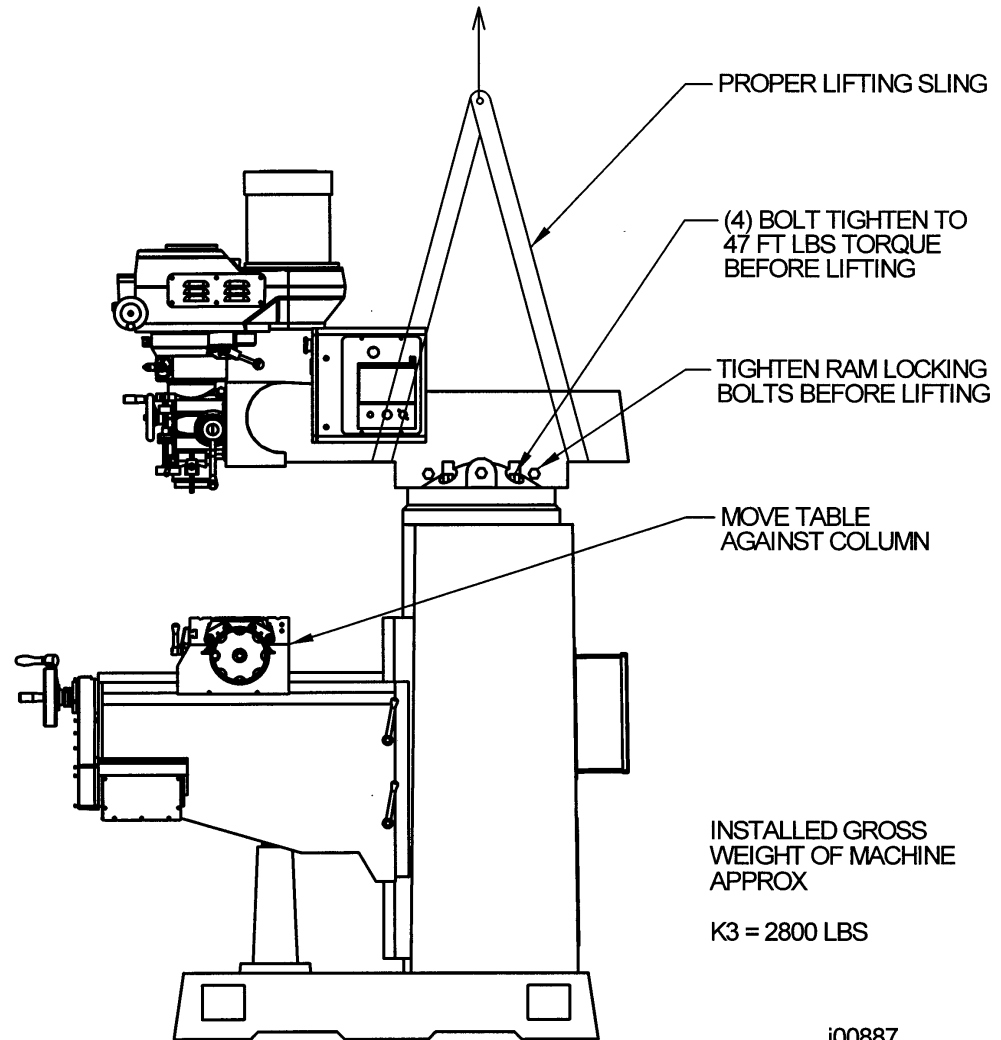
Lifting and/or Moving the Machine

CAUTION!

Proper equipment of sufficient capacity must be used when lifting and/or moving the machine.

(See Figure To Prepare the Mill before Lifting):

1. Using a steel cable with protective sleeving (min 3/4" diameter) or a 3-ton sling, position sling loops on machine as shown in Figure.
2. Use cardboard pieces or other suitable protective sheets on both sides of the machine to prevent scratching.
3. Remove the 4 nuts and screws holding the machine to the wood skid.
4. Lift the machine (the machine should lift approximately level).
5. Insert the 4 screws for leveling pads in their place in the bed.
6. Place the machine in its location (see floor plan and bed footprint drawing). Carefully positioning each leveling pad under each leveling screw.
7. Remove the lifting cable or sling and all protective cardboard.



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