

TRAK Machine Tools

Site Preparation Guide

TRAK DPMRX7

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 move the machine while on the pallet, a 15000 lb. forklift with a 24" load center & 6' fork extensions is required. Depending on the load center or rating of the forklift, a larger fork lift may be required. The center of gravity (CG) of the machine while on the pallet is 42" from the edge of the pallet. Please see the manual for more information about lifting the machine.
- 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

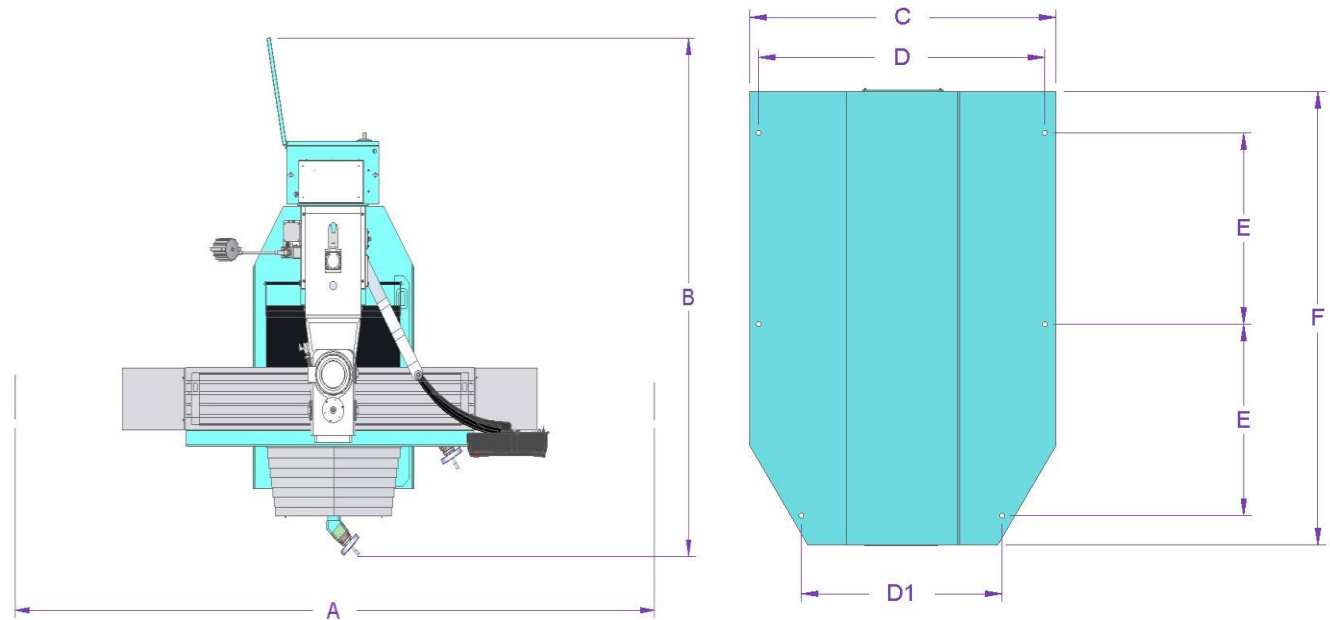
- Floor area = 168.5" x 119"
- Height = 87.875"
- Footprint = 42.52 x 63"
- Net (approx.) Weight = 7480 lbs.
- Shipping (approx.) Weight = 7700 lbs.
- Pallet Size = 91 x 84"
- Allow clearance at the rear of the mill to open and work on the electrical box.
- A solid and level foundation to maintain approximately 7480 lbs plus the weight of the workpiece (maximum total 9680 lbs) is required. Six leveling screws are provided.

Electrical

- Machine is only available in the 208 VAC configuration (200 to 240V is acceptable). A separate 208V, 42 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 42 amps minimum.
- Machine tool must be earth grounded.

Air (for optional Power Drawbar)

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

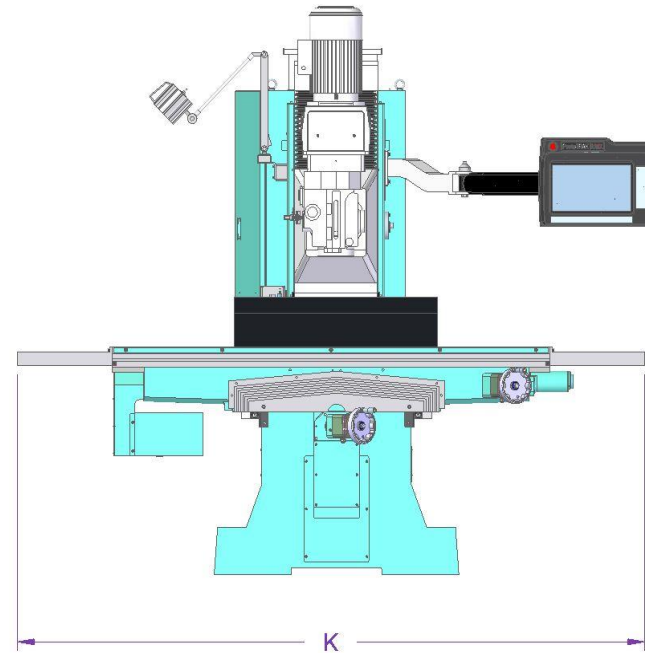
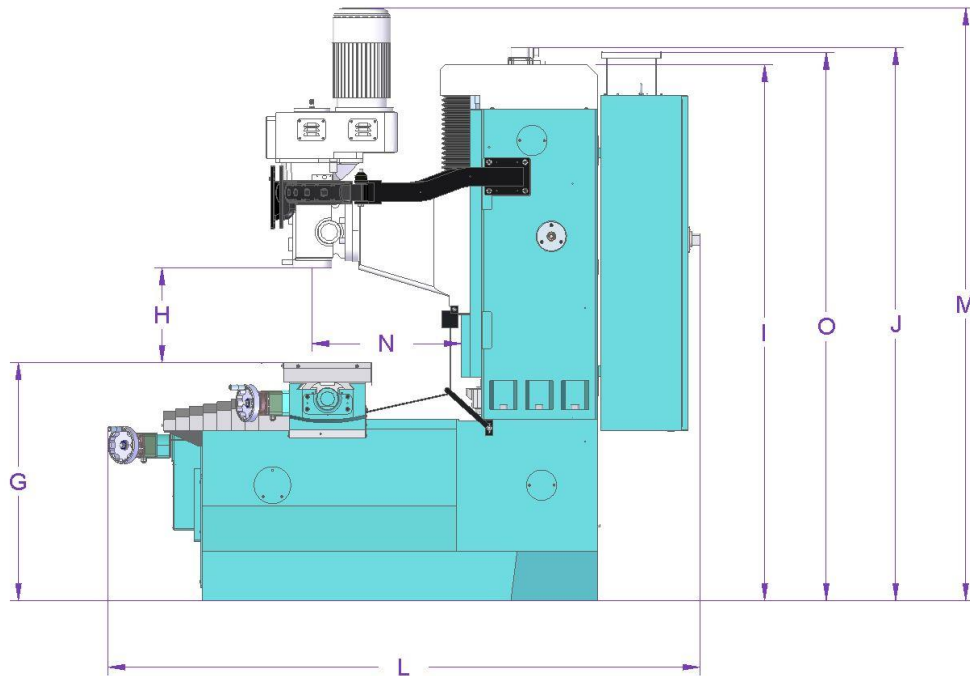


DPMRX7 Machine Footprints

Dimension	Description	Value
A	Overall Width	168.5"
B	Overall Length	119"
C	Bed width	42.52"
D	Bed width between leveling screws	39.76"
D1	Bed width between leveling screws	26.57"
E	Distance between leveling screws	26.57"
F	Bed length	63"



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DPMRX7 Overall Dimensions

G	Height of table from bottom of bed	38.75"
H	Maximum distance from spindle nose to table	24.25"
I	Height from bottom of bed to top of column cover	85.0625"
J	Max. height from bottom of bed to top of Z-axis motor	87.875"
K	Width of machine (including table tray)	110"
L	Length of machine with electrical cabinet closed	94.5"
M	Max. height of machine from bottom of leveling pads to top of spindle motor with the head all the way up	107.625"
N	Spindle center to column face	24"
O	Bottom of Bed to Top of Electrical Cabinet	87.25"

Note – Removing the z-axis motor, z-axis motor cover, resistor housing, resistor housing lid, and unscrewing the top resistor from its bracket and placing it to the side results in a height of 80.4375" from the bottom of base to the top of the Z-Axis ball screw. With the head all the way down, this is the minimum clearance needed to move the machine through doors.

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 SOUTHWESTERN INDUSTRIES, INC.

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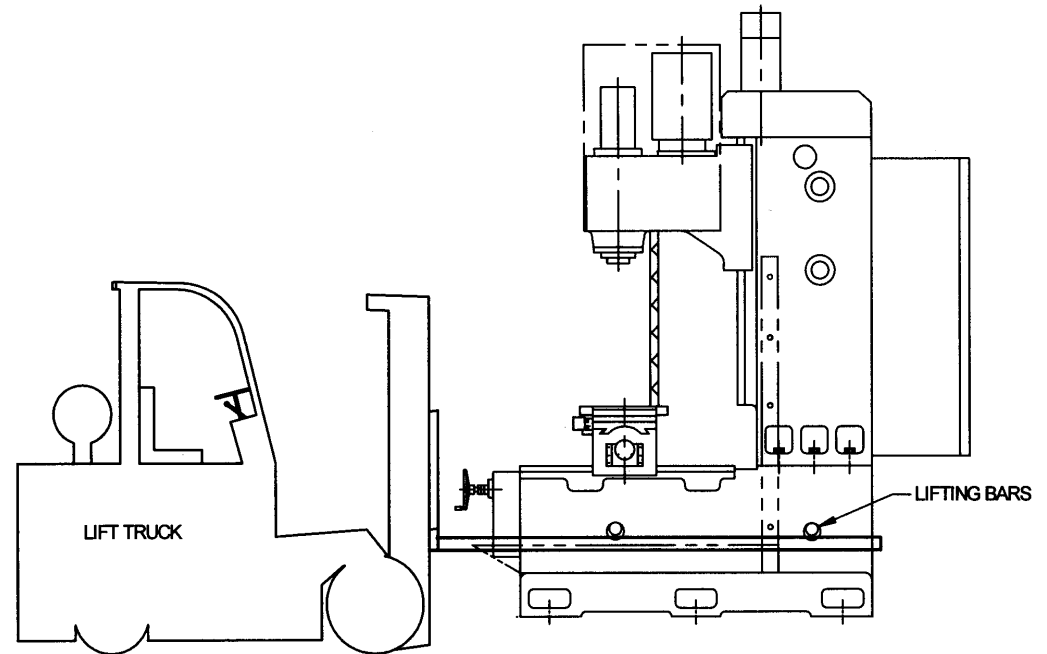
Lifting the Machine

1. Using the recommended size forklift, lift the pallet with the machine on thru the fork pocket. (**Note** – The center of gravity (CG) of the machine while on the pallet is 42" from the edge of the pallet.)

WARNING!

The DPMRX7 machine weighs approximately 7500 lbs. The lift truck must have sufficient lifting capacity (15000 lbs.) with a 24" load center or equivalent, and be equipped with 6 ft. extension forks.

2. Using (4) pieces of 4" x 4" x 6" high steel block. Equally, position the steel blocks to the front, back and side of the machine base.
3. Gradually lower the lift and let the machine base rest on the (4) steel blocks. (**Note** – Machine weight must be equally distributed and well supported by the (4) steel blocks.) Please make sure that the position of the blocks does not obstruct the skid.
4. Remove forklift from steel pallet.
5. Remove the (4) bolts securing the machine base to the pallet and let the steel pallet rest on the floor.
6. Carefully lift the machine thru the fork access cut out on the side of the machine.
7. Remove steel pallet under the machine.
8. Insert the (6) leveling screws into place.
9. Position and lower the machine to its location (see floor plan bed/footprint). (**Note** – Make sure to position each leveling pads under each leveling screws.)



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* **Note** – Lifting bars are NOT supplied with the DPMRX7. If they are needed, the size should be 2" x 5 ft long.

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