



Productivity Inc®

Hermle C20U PPRE-INSTALLATION CHECKLIST - Rev 01/2009

Installation of your new Hermle C600/C20U can be smooth and rapid if preparations are made prior to the delivery of your machine. Any questions regarding machine installation should be directed to our service department for clarification. We hope this checklist will aid in a rapid installation of your new machine. **NOTE: The following must be completed prior to our service technician arriving at your facility.**

- Power Requirements for your machine: 230v/3ph/37kVa* 120 Amps (460v w/Trsfrmr 60 Amps)
 Proper voltage per machine specifications should be ready/wired to the machine. **Do NOT power up machine. A separate earth ground wire of the same conductor size as the input power must be connected to the chassis of the machine; must be supplied from the main plant ground. A local cold-water pipe or ground rod is not sufficient.** *NOTE: A 45kVa transformer is supplied from Hermle.
- Customer should furnish and have available the proper supply and types of lubricants required for machine operation. *See attached Hermle Technical Specifications for more info.*

ITEM	CAPACITY	FLUID TYPE
Coolant	79 gallons	Water Soluble, synthetic
Grease	5 liters (supplied with mach)	OLIT CLS000 Lithium based (Hermle carries)

- Air lines should be routed/connected to the machine and operational for proper air pressure.

The Hermle requires a minimum of 90 PSI at 6-10 cfm at the input to the pressure regulator on the back of the machine.

- Machine location should be planned to allow enough room for access panels to be opened and serviced with ease. A minimum of 36" clearance around the machine is required.
- Weight requirements should be checked to insure that the surface below the machine will have sufficient strength for support and stability. The machine must be set on a solid, sound and stable, steel bar-reinforced concrete slab poured directly on the grade. In general, the 6" concrete floor on industrial buildings is suitable for machine placement.
- **NOTE: The machine is on a composite base and needs to be handled carefully to avoid damage to the casting. Contact our Service Department for any questions or concerns. THE HERMLE IS BEST MOVED ON/OFF THE TRUCK USING A FORKLIFT (IN A CRATE). However, when removing from the skid, it is best to use an overhead crane, as the machine is below the level of the skid. Upon arrival of your machine, unpack and immediately check for visible damage.**

SHIPPING WEIGHT	SHIPPING DIMENSIONS OF MACHINE
16,975# (Machine skidded)	9.2' L x 9.18' W x 9.58' H (Crated)
1,212# (Accessory Crate)	7.5' L x 4.25' W x 4.20' H (Crated)
<i>Operational Dimensions: 125"L x 98"W x 108"H (Floor Space/Operational, not including Coolant Pan/Chip conveyor chute) Weight 14,000# NOTE: (Optional) Barfeeder will take an additional 5' W x 7' L and installs on left side.</i>	

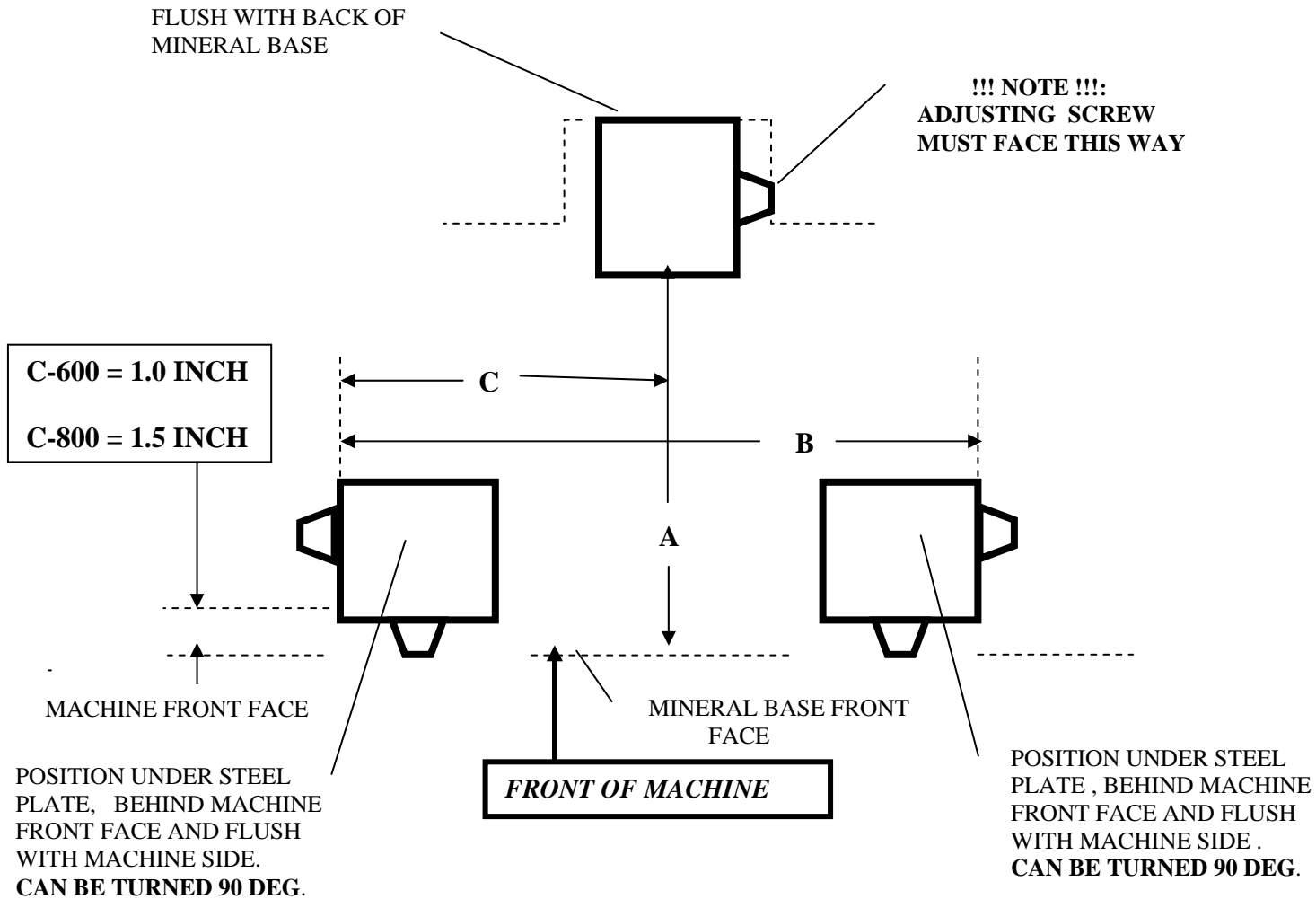
- Remove as much preservative from the machine as possible without having to power up (tables – slides, pulleys, etc.). We recommend mineral spirits to clean. Apply oil when finished to prevent rust.

PLEASE FORWARD THIS TO THE APPROPRIATE PERSON. THANK YOU.

C-600 & C-800 MACHINE LEVELING AND FACILITY REQUIREMENTS

ALL DIMENSIONS ARE APPROXIMATE

NOTE: RAISE THE LEVELING PADS ALL THE WAY BEFORE SETTING THE MACHINE ON TOP OF THEM.
IT'S EASIER TO LOWER THE MACHINE THEN IT IS TO RAISE IT.



	A	B	C
C600	51 IN.	56 IN	28 IN
C800	55 IN	63.75 IN	31.875 IN

NOTE: CUSTOMER RESPONSIBILITY:

- HAVE THE RIGGERS LEVEL THE MACHINE. IF THE FLOOR IS PITCHED A LOT, THE LEVELING PADS WILL NOT PROVIDE ENOUGH TRAVEL AND SCHIMMS WILL BE NEEDED TO BRING THE MACHINE TO LEVEL. YOU WILL HAVE TO CALCULATE THE SCHIMM THICKNESS AND MAKE THEM 7IN x 7IN. SQUARE .THE RIGGERS WILL HAVE TO LIFT THE MACHINE UP TO PLACE THE SCHIMMS. (TOTAL LEVELING PAD TRAVEL = +/- ¼ INCH)
- AIR REQUIREMENT = (6-10 CFM) A ½ IN. LINE @ 90 PSI LESS THAN 50 ft Long , BROUGHT TO PNEUMATIC PANEL. IF MACHINE IS EQUIPPED WITH WORKPIECE BLOW OPTION AN ADDITIONAL ½ LINE IS REQUIRED.
- ELECTRICAL REQUIREMENT = A 45KVA TRANSFORMER IS PROVIDED BY HERMLE MACHINE CO. YOU ARE RESPONSIBLE FOR CONNECTING THE PRIMARY WINDING TO YOUR LINE AND THE SECONDARY WINDING TO THE MACHINE. USE 5 WIRES #6 AWG FOR THE SECONDARY CONNECTION. MAKE SURE THE X0 NEUTRAL IS BONDED TO GROUND AT THE TRANSFORMER.