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Productivity Inc®

**STW-40 PRE-INSTALLATION CHECKLIST** - Rev 06/2008

Installation of your new Nakamura STW40 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 to install the machine.**

- Power Requirements for your machine: \*220v/1 phase/170 kVa Amps: 446 Amp  
 Proper voltage per machine specifications should be ready at machine site. **Do NOT power up the machine.**  
**\*NOTE: Other power sources such as 440v or 480v require an external stepdown transformer. An additional power source for options requiring either AC110v/1ph or AC220v/1ph may need to be provided in addition to the main power to the machine control cabinet. Some of these options are bar feeders, part unloaders, etc. A separate earth ground or cold water pipe ground is required (conduit-type ground does not provide sufficient noise immunity). Please contact Productivity Service Department with any questions or concerns.**

- Customer should furnish and have available the proper supply and types of lubricants required for machine operation.

ITEM	CAPACITY	FLUID TYPE
Coolant	106 Gal	Water Soluable, Synthetic
Way Lube	1 Gal	Mobil Vactra #2
Hydraulic Oil	15 Gal	Mobil DTE Light
Spindle Oil Cooler	15 Gal	Mobil Velocite #6

**You will need to have these lubricants on hand at time of installation.**

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

300NI/min
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- Machine location should be planned to allow enough room for access panels to be opened and serviced with ease. *Allow an extra 36" behind the machine for maintenance, and an additional 40" to the right side of the machine if optional Chip Conveyor is purchased.*
- 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 6-12" concrete floor on industrial buildings is suitable for machine placement. Bolting the machine to the floor is not required. See foundation drawings.
- **The Nakamura STW40 Turning Center is best moved using a forklift. Upon arrival of your machine, unpack and immediately check for visible damage.**

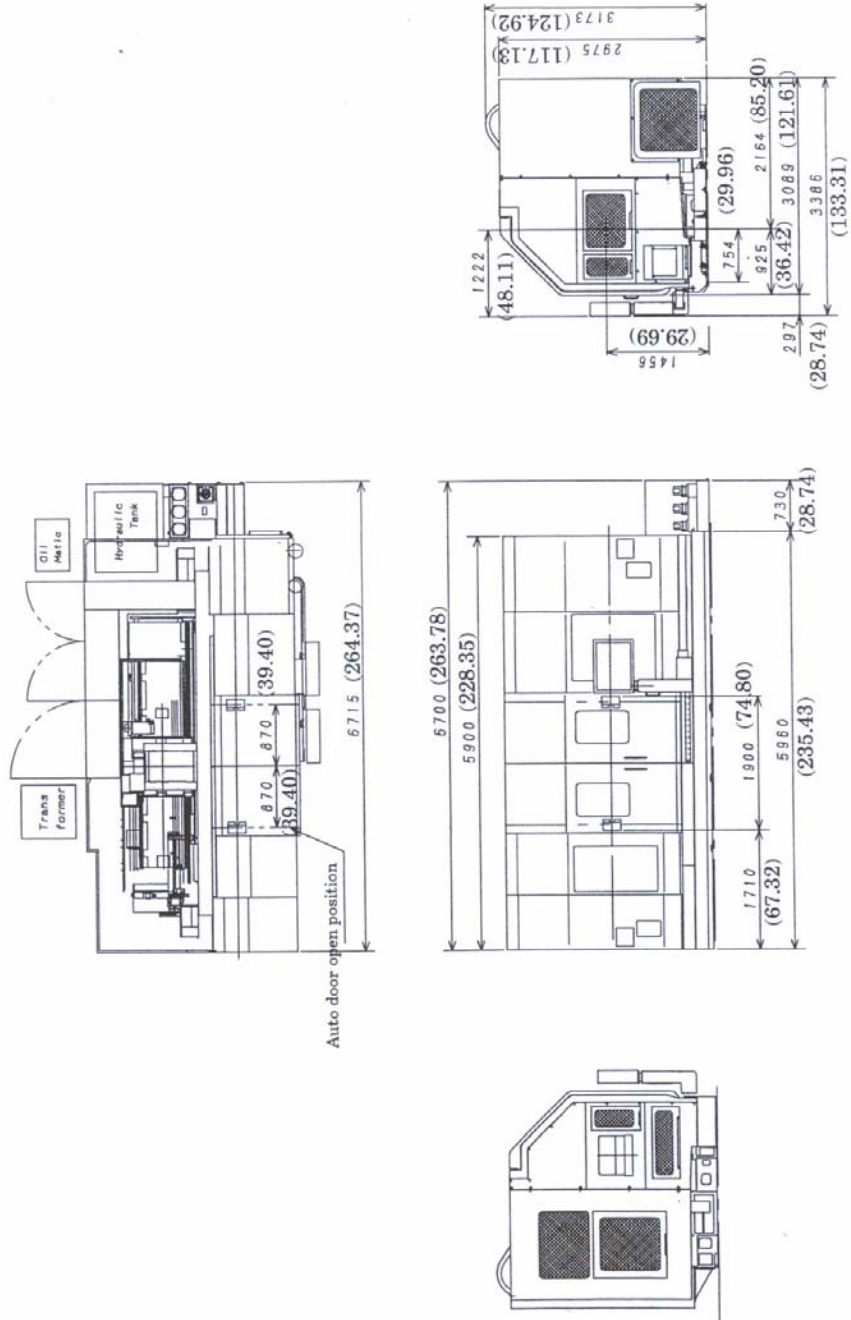
SHIPPING WEIGHT	SHIPPING DIMENSIONS OF MACHINE
66,800# (Machine & Acc Crate)	20'3" L x 11'5" W x 11' H (Machine)
(Mach 60,627# and Acc 6,172#)	23'7" L x 7'2" W x 5'9" H (Accessory Crate)
<i>Operational Dimensions (Floor Space): 264" L x 134" W x 125" H NOTE: Allow for maintenance around machine (40") See attached layout for dimensions/requirements.</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.

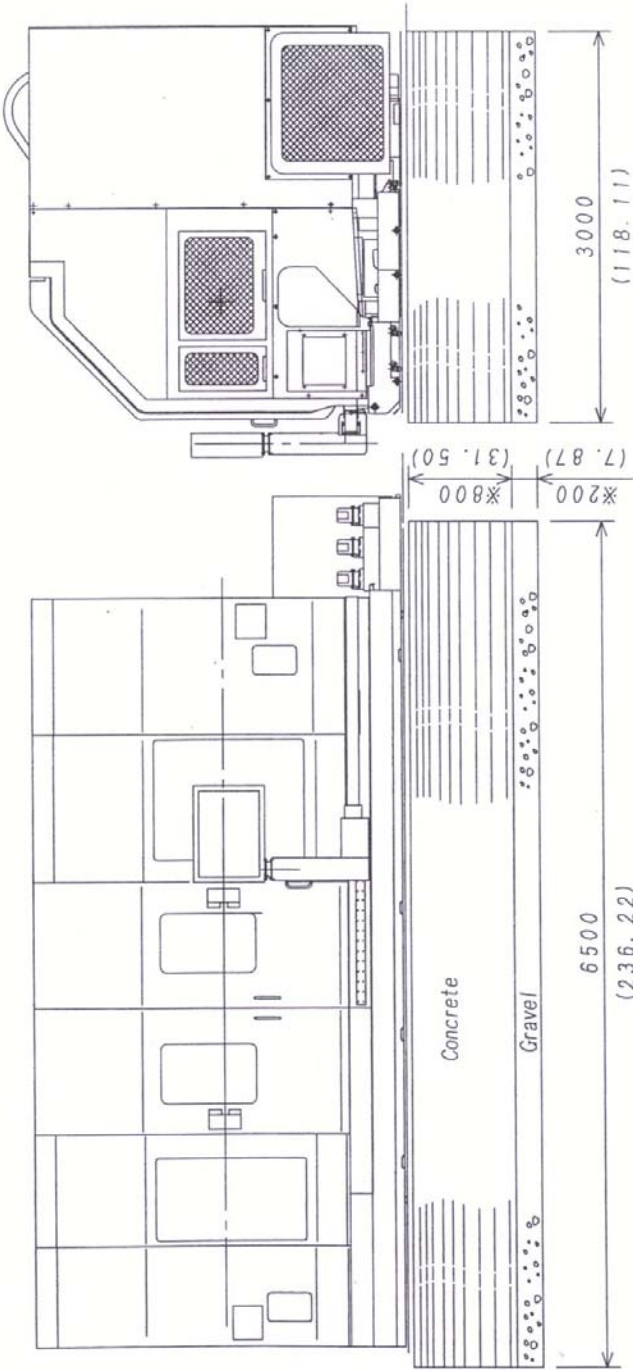
**PLEASE FORWARD THIS TO THE APPROPRIATE PERSON. THANK YOU.**

2. MACHINE DIMENSIONS

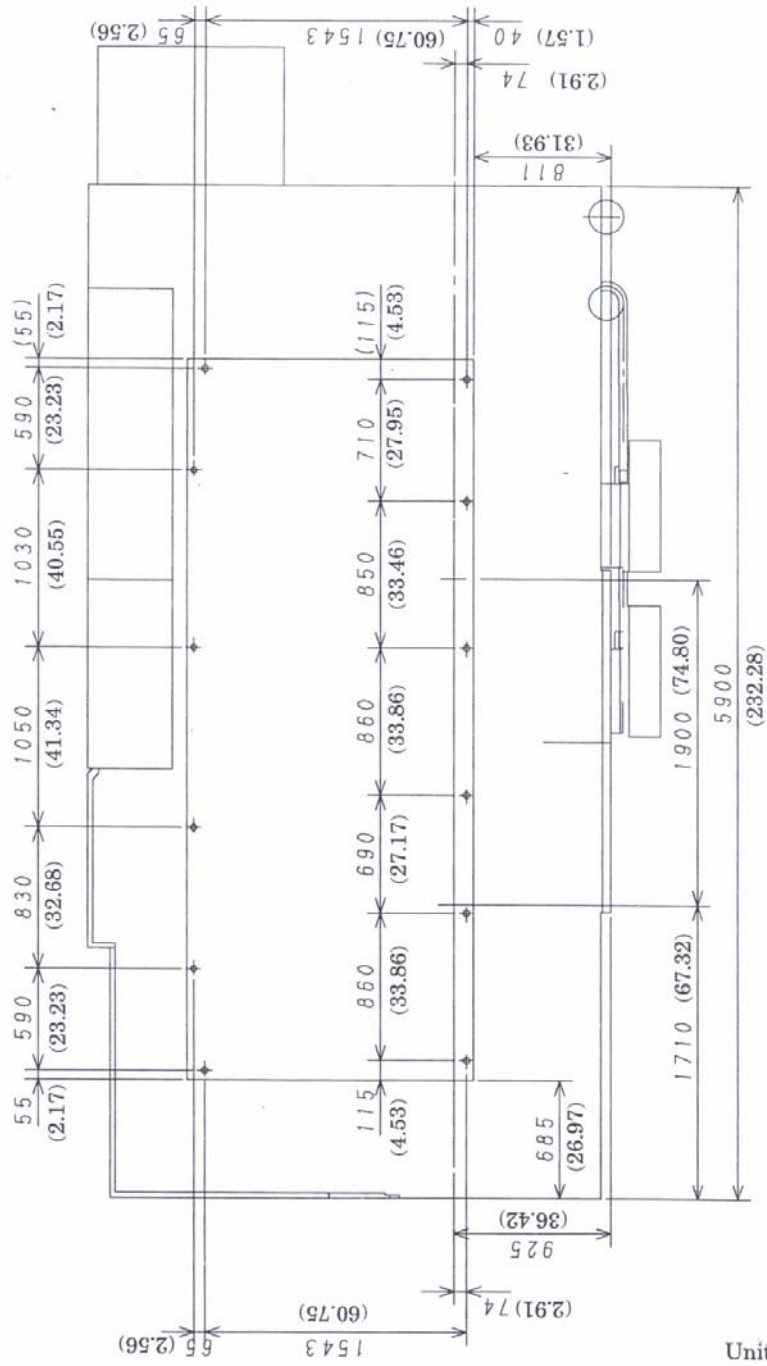
2-1 Front and Side Views of STW-40



2-3 Foundation Plan of STW-40



2-5 Machine Leveling Positions



2-4 Floor Space of STW-40

