



15150 – 25th Avenue North, Minneapolis, MN 55447-1981
 Phone 763-476-8600 Fax 763-476-4092 Visit us at: www.productivity.com
 Service Dept: (MN) 763-476-4191 (IA) 319-632-4288 (NE) 402-330-2323
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Productivity Inc®

Citizen A20 PRE-INSTALLATION CHECKLIST - Rev 11/2008

Installation of your new Citizen A20 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 technician arriving for installation.**

- Power Requirements for your machine: 208v/3 phase/6kVa 20 Amps
 Proper voltage per machine specifications should be ready at machine site. **Do NOT power up the machine.**
 NOTE: Voltage must not exceed 215V or a transformer is required to bring down to 208v.

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

ITEM	CAPACITY	FLUID TYPE
Cutting Oil	30 Gallons	Hangsterfers Hardcut 5318
Way Lube	.8 litre (0.21 gal)	Mobil Vactra #2

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.

Air pressure and air flow rate for pneumatic devices	0.5 MPa · 70 NI/min (Maximum 100 NI/min)
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- If a Bar Feeder is to be installed with the machine, make sure you have the collets and guide bushings on hand for both the machine and bar feeder, to properly check the accuracy of the machine/bar feeder operation.
- 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 and barfeed 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.
- **The machine should be off loaded using a forklift with a capacity of at least 6,000#, and forks 8' in length. Upon arrival of your machine, unpack/uncrate and immediately check for visible damage.**

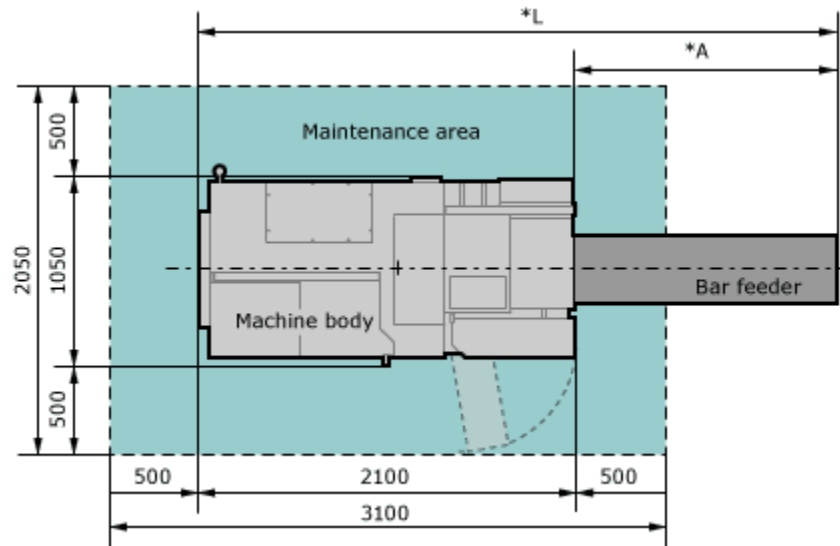
SHIPPING WEIGHT	SHIPPING DIMENSIONS OF MACHINE
5,160# (Machine in crate)	7'8" L x 4'4" W x 6'8" H (crated)
340# (Accessory Crate)	3'10" L x 3'10" W x 2'7" H (crated)
2,300 # (Optional C320)	20' L x 3' W x 6' H (C320 crated)
See attached layout for floorspace and placement information.	

- 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.

A20 Floor Space Dimensions/Layout

A20 Floor layout



Maximum height: 1,750 mm (68.9") including mount

*A and L dimensions vary depending on bar feeder type

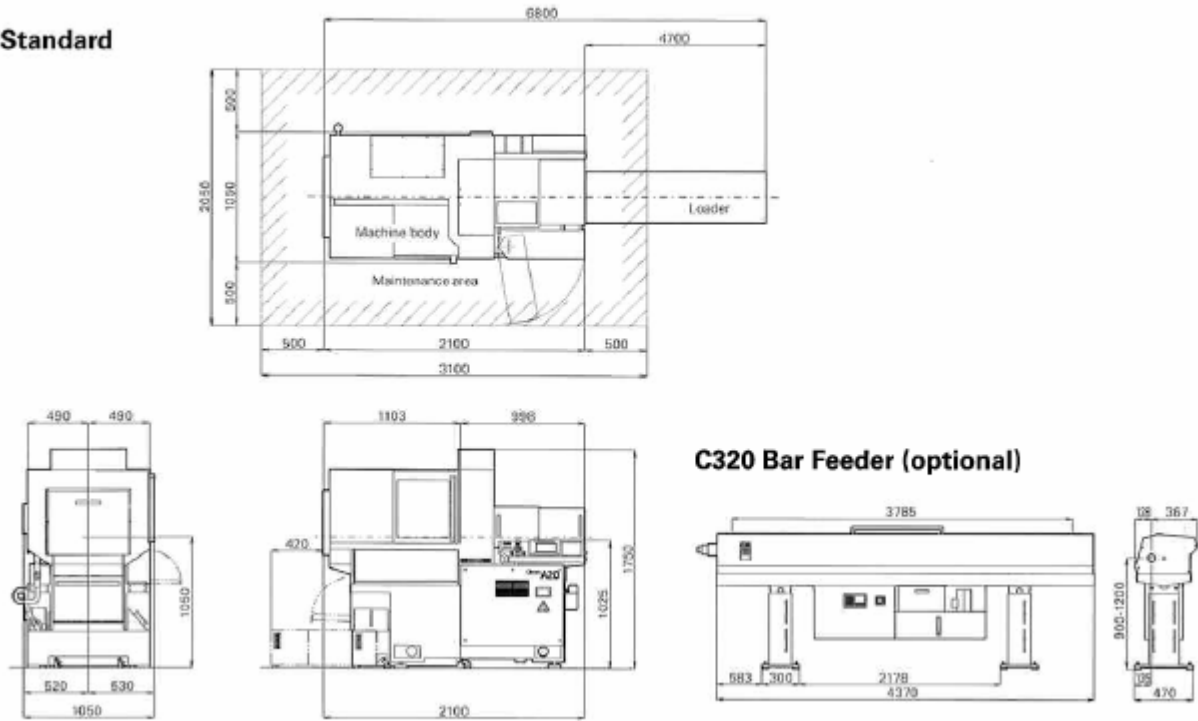
All specifications are subject to change without prior notice.

If ordering a High Pressure Coolant System:

The new 3-Line HPC Units will require a separate 30 Amp power drop/source. The 5-Line or 10-Line HPC Unit will require a separate 40 Amp power drop/source. The units take up approximately 5' L x 4' W of floor space and is generally placed just to the right of the machine and behind the bar feeder. For more information or other questions regarding the High Pressure Coolant Systems, please contact your salesperson or our Service Dept at 763-476-4191 (MN), 319-632-4288 (IA) or 402-330-2323 (NE).

Machine Layout

Standard



With Options

