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Productivity Inc®

**M<sup>3</sup>20y PRE-INSTALLATION CHECKLIST** - Rev 03/2008

Installation of your new Citizen M<sup>3</sup>20y 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/8kVa 25 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	36 Gallons	Hangsterfers Hardcut <b>5318</b>
Way Lube	½ Gallon	Mobil Vactra #2
Grease (As needed)	Varies as needed	Mobil SC100

*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 air-driven equipment	0.4 MPa · 50 NI/min
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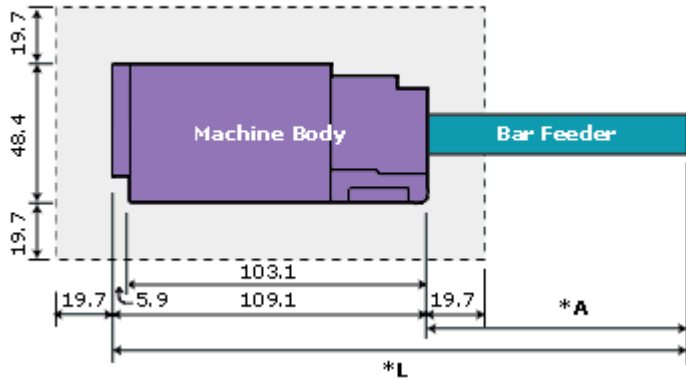
- *If a Bar Feeder is to be installed with the machine, make sure you have the collets and guide bushings on hand for both the machine and bar feeder, to properly check the accuracy of the machine/bar feeder operation.*
- Machine location should be planned to allow enough room for access panels to be 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 8,000#, and forks 8' in length. Upon arrival of your machine, unpack/uncrate and immediately check for visible damage.**

SHIPPING WEIGHT	SHIPPING DIMENSIONS OF MACHINE
6,500# (Machine Crated)	11' L x 6' W x 7' H (Crated)
500# (Accessory Crate)	8' L x 5' W x 3' H (Crated)
<i>Operational Dimensions: See attached for layout/floor space requirements. (Allow an extra 13' on the right side of the machine for a Spego Barfeeder. The 7' Width includes the necessary required maintenance area behind the lathe.)</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.**

## M20/32 FLOOR LAYOUT



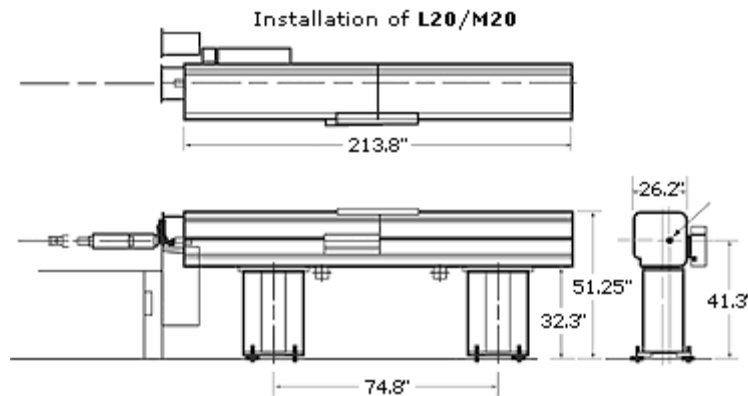
\*A and L dimensions vary depending on bar feeder type

Units in inches

Maintenance Area

All specifications are subject to change without prior notice.

### *If purchasing a Citizen Magazine Barfeeder:*



Control	Operation and synchronous control by NC lathe	
Power source	AC200/220V, 50/60Hz (supplied from the NC lathe)	
Weight (without oil)	2400 lbs.	
	<b>C16/M16</b>	<b>L20/M20</b>
Bar diameter range	.078" ~ .625"	.078" ~ .75"
Oil	ISO VG68/351	ISO VG68/451

### ***If ordering a High Pressure Coolant System:***

***The 3-Line HPC Unit requires a separate 30 Amp power source/drop. 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 barfeeder. For more information or other questions regarding the High Pressure Coolant Systems, please contact your salesperson or our Service Department at 763-476-4191 (MN), 319-632-4288 (IA) or 402-330-2323 (NE).***