

INSTALLATION the SLT turning centers

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Machine type: **SLT** Serial number: Customer: PH: Contact: FX: **A. Before power ON**

- 1 Machine arrival, check it all around for physical damages, accessories.
2. Place leveling pads under each leveling screw, make sure the tip of the screws are in the counter bore of the pads.
Tighten the screws until they are in touch with the pads.
- 3 Remove the shipping bracket from the end of the Z ball screw (tailstock end) and the chip guard doors (top of the doors)

4. Fill up the hydraulic tank. Oil quality:

ISO	HM 46
SHELL	Tellus 46
ESSO	Nuto H46
BP	HLP 46

Quantity: 12 Gal. (45 l.)
(min. 3/4 of the level indicator.)

5. Check the oil level at the gearbox and the central lubrication tank.
Gearbox oil: ISO VG68,
6. The door and switch-keys are behind the CRT operator panel.
7. Check the electrical components inside the electrical cabinet for damages.
Pull off the main switch after the 4 pcs. of M4 nuts are removed.
Connect the main power lines to it. Connect the ground wire to PE.
8. Check and record the Input Power: R-S R-T S-T

NOTE: Max. input power is $208 + 10\% = 228.8 \text{ V}$

B. POWER ON

9. Turn on the main switch. The machine light and the fans should be on.
Check PHASE rotation. The fan of the main spindle motor should blow the air OUT of the motor !!
10. Push the CNC ON button on the machine control panel. The CRT will be ON.
Record the version numbers: Servo: PMC:

The hydraulic unit should be ON Hydraulic pressure:
If there is no hydraulic pressure, check the phase rotation !

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11. In MPG mode, move the turret in +X direction, with med. feed.
Remove the wooden shipping block underneath the cross slide.
12. Connect the footswitch to the outlet, which is behind the main hydraulic tank.
Turn the selector switch to the CHUCK position, close the jaws.
You might have separate foot switch for the chuck
13. Move the axis to the HOME position. See EXCEL op.manual pg. 2-2.
If there is an over travel alarm (5...), move the axis off the home by 2 ",
turn off the control, push P and CAN buttons together, while power ON
the machine again. Repeat the HOME move.
14. Level the machine.
Clamp the supplied ground level plate into a OD toolholder, which is in the
horizontal position. (SL-320 and SL-400)
Put the level on the leveling plate and check the machine position on the
whole stroke area. Start leveling the SL-500 first only with the 4 corner
leveling bolts, then adjust the middle bolts.(put the level on top of the Z way)
See the Accuracy test report for permissible leveling error.
15. Install the chip conveyor, set the right height with the leveling bolts.
Connect the cables of the chip conveyor and the coolant pump.
Connect the green-yellow ground wire to the grounding lug of the conveyor.
Install the chip guard covers inside the machine. (SL-500 only)
Adjust the sliding chip guard at the SL-320 and SL-400 chip conveyor.
16. Test the interlock of the cover door, and show the customer.
Close the door, turn ON the door interlock key-switch, turn on the spindle.
The door lock should be engaged and keep the door shut.
Turn off the spindle, the lock will be disengaged, the door can be opened.
17. With the machine running, press the emergency stop button.
The machine should stop running !
18. Check all the manuals. Make copy of the FANUC data sheet and
send it to Marathon Machine Tools with the
installation report.
19. Check and show the customer the operation of each unit, chuck, tailstock
turret, chip conveyor, coolant supply, central lubrication and hydraulic.

Signature Date