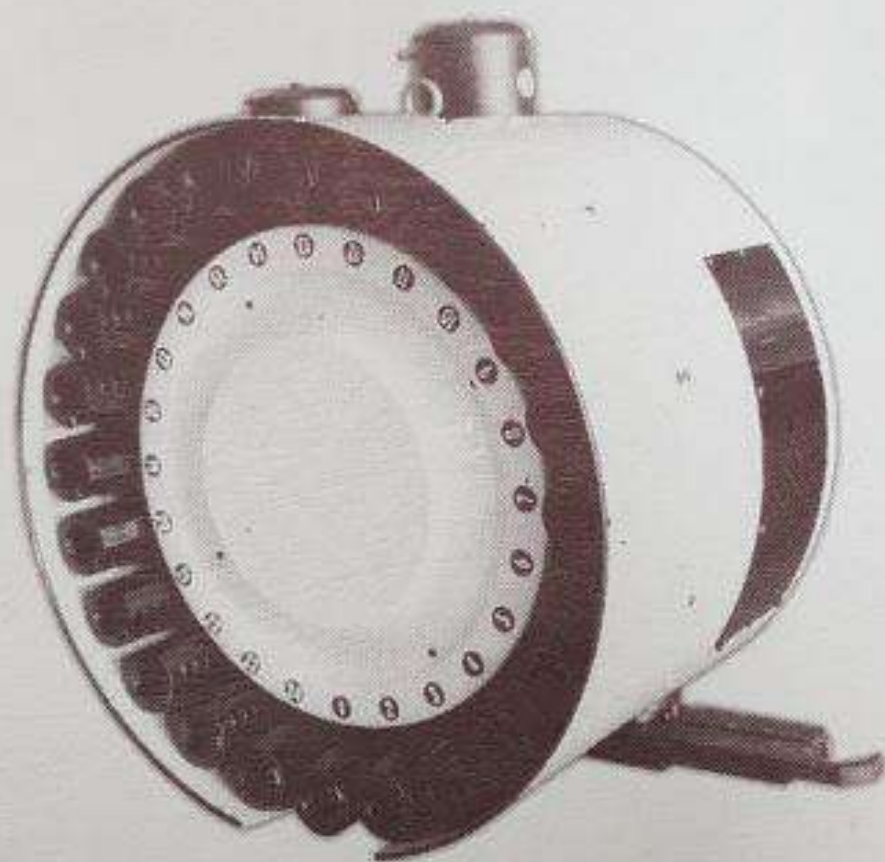


# 40#-24T(20T) TOOLS DISK TYPE MAGAZINE INSTRUCTION



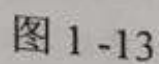
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this model – BT40



B: Machine outlook dimensions :

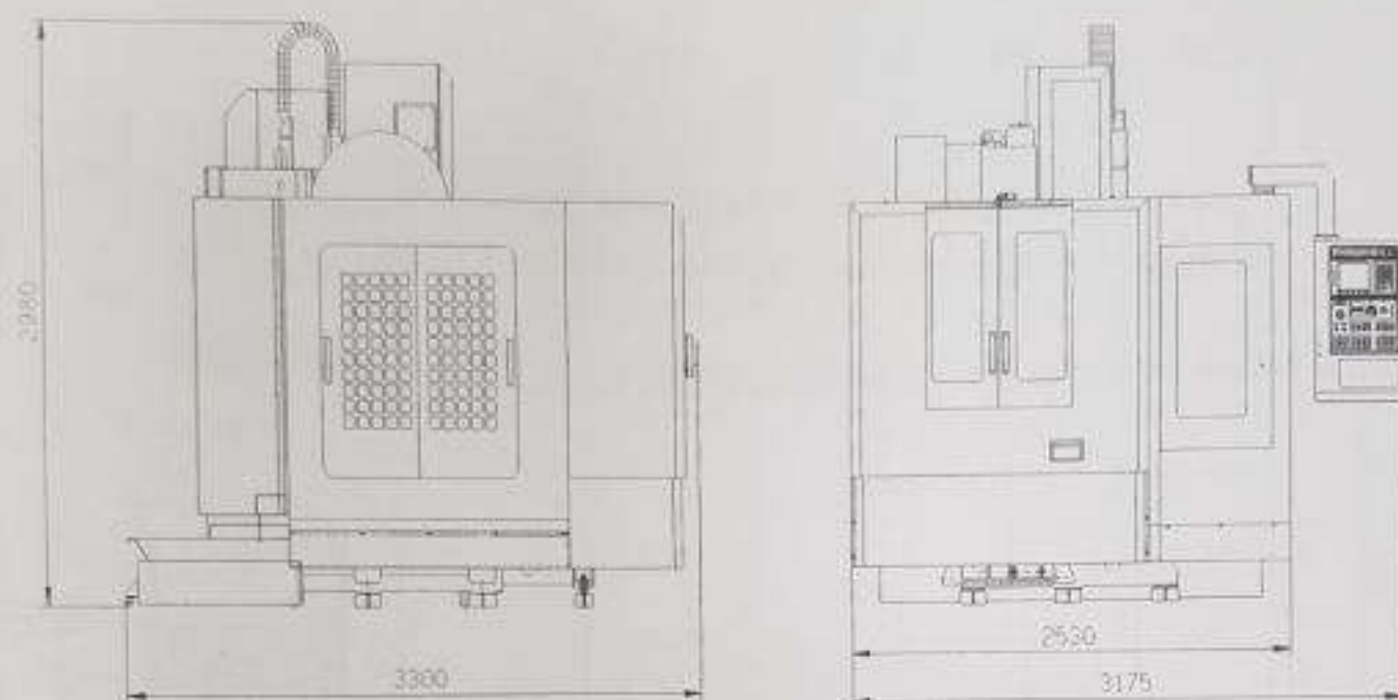
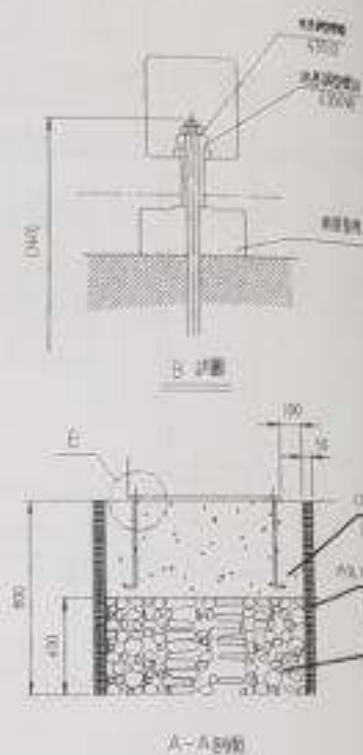


diagram 1-1

C: Minimum space needed around the machine for easy operation and maintenance & service:

Position	Open Space Required around the Machine	
	Position of Open Space	Space Needed
Left and Right	Left and Right	1,000mm
Height	Above the machine body	500mm
Length	Back	1,000mm





C. Diagram of operator's position, refer to Diagram 2-7.

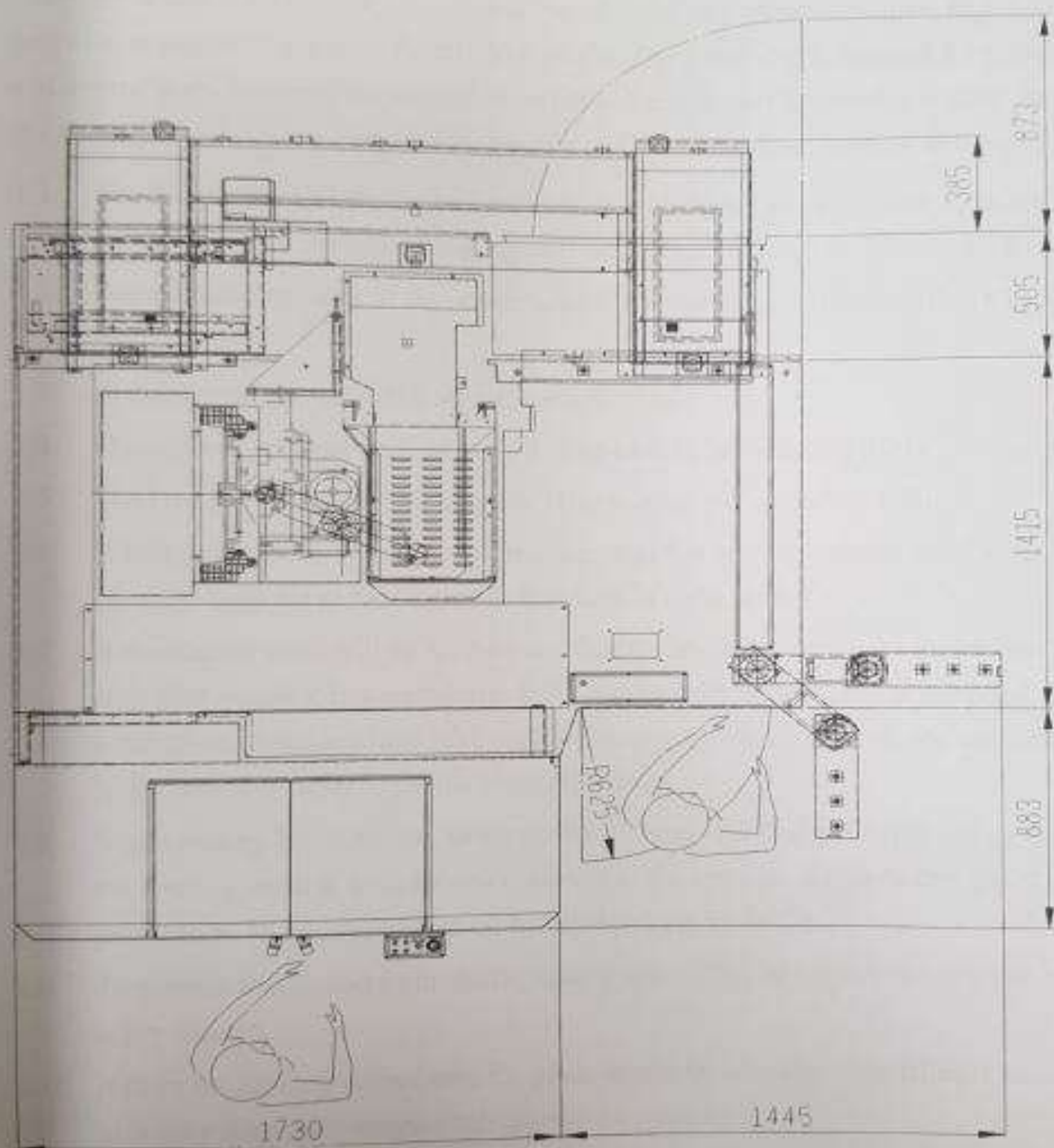


Diagram 2-7

### Chapter 3 Preparations before Installation

#### 1. Base Foundation Requirements

The place where machine will be installed should avoid any vibration source, high humidity, near to heat source or exposed directly to sunlight. The actual depth required for foundation will depend upon the local soil condition be noticed that deeper foundation assures less twist and distortion in the base. Foundation drawing and foundation requirement as figure 3-1

- 1.1 The foundation soil should be hard enough (cobble stones or crushed rocks are much better) to obtain the supporting capacity of at least 5 t/m<sup>2</sup> (0.05 Mpa or 0.5 Bar).
- 1.2 Compressive strength of the concrete should be more than 180kgf/cm<sup>2</sup> (18 Mpa or 180 Bar).
- 1.3 The concrete can not crack after it has solidified.
- 1.4 Quakeproof material such as asphalt to be used by surrounding of the foundation
- 1.5 Steel rods what be used with  $\varphi$  19- 150mm pitch and spread by trellis.
- 1.6 If foundation bolts will be set at first time together with machine's installation, the concrete shall fill in foundation at first time in order to fix foundation bolts.
- 1.7 If foundation bolts will be set later on, then dig available rooms for foundation bolts after first concrete has completed. Until concrete dry enough, adjust temporal parallelism of the machine after setting foundation bolts and let second concrete to fill in the rooms in order to fix the foundation bolts.
- 1.8 While putting 2nd concrete, to sure bolts for temporal fixing to avoid falling down of the leveling units & foundation cushion. Till the concrete complete dry, adjust final parallelism, to set machine up on foundation base by M25 nuts.
- 1.9 To prevent foundation from shrink, adding some CSA into the concrete while concrete is dry enough.
- 1.10 If there are shaking source near the place where the machine is installed. It is necessary to build a shaking resistant ditch around the machine.
- 1.11 Space for installation should consider not only machine's dimension but also available rooms for preparation. (ref. ch1, sec. 1.2c).

## CHAPTER 3 Preparations Before Installation

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### 2. Requirements for machine transportation

- 2.1 Make sure cable of the crane should be capable of lifting 10,000 kgs at least.
- 2.2 Make sure the fork lift should be capable of lifting 7 tons at least. The thread length of lift fork should be over 2000mm, and exceed the center point of machine 100 mm at least.
- 2.3 Any transportation equipment must relate to the dimension & weight of the machine after packing. (Refer to ch4. sec.1.1.A)
- 2.4 While running crane or fork lift, make sure there are no personnel or car as an obstacle
- 2.5 One or two personnel in charge of transportation safety are required.
- 2.6 Transportation zone must set warning sign.