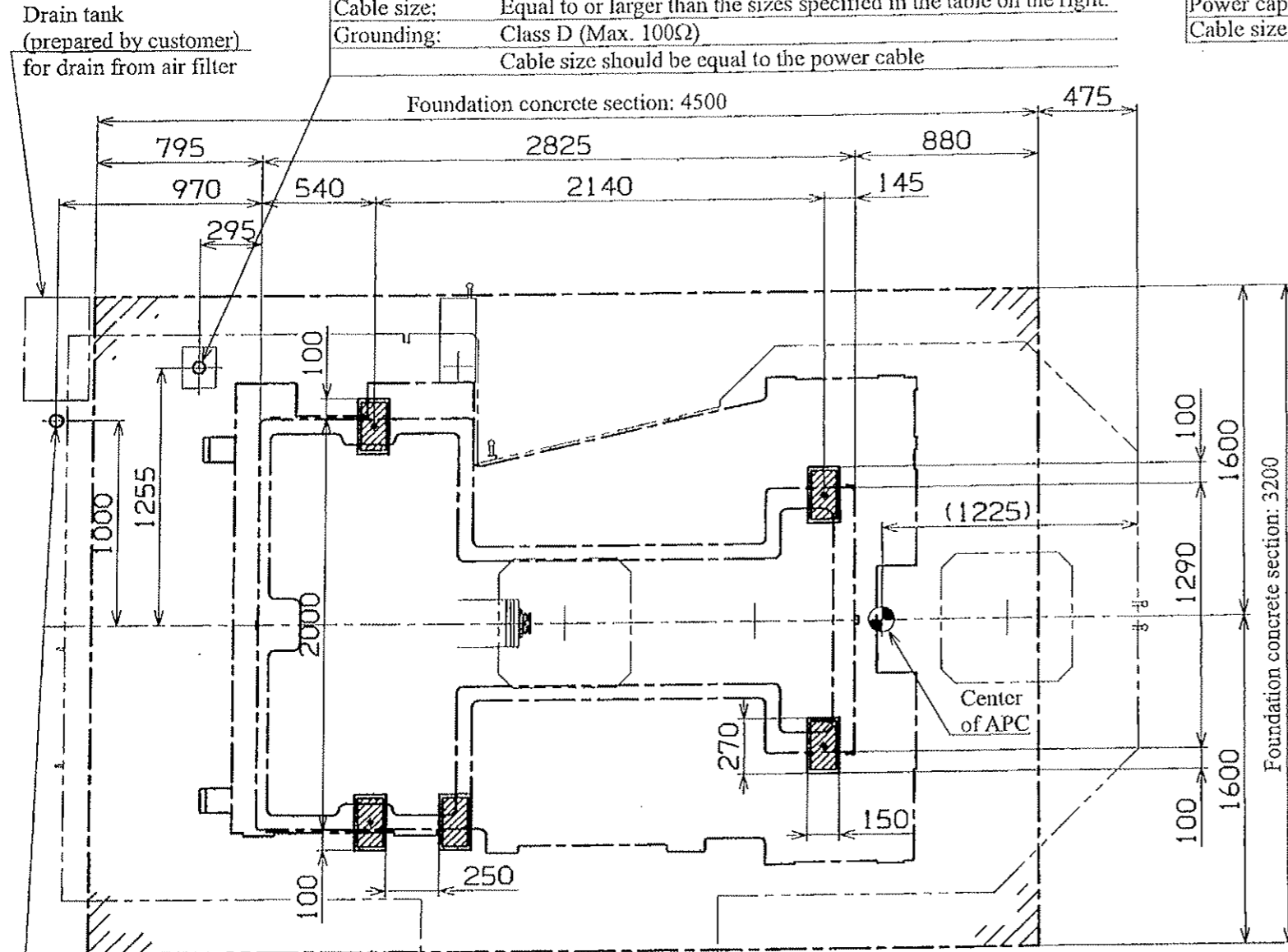


2.5 Foundation Drawing for Installation

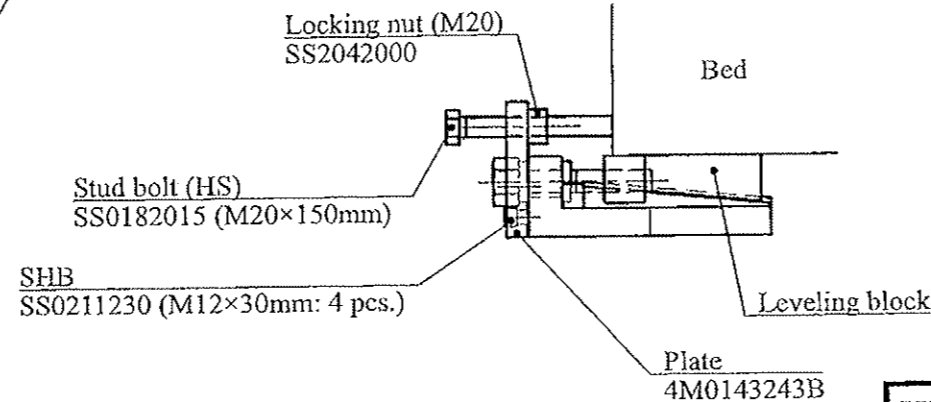
Power cable connection (From floor to the control box base plate: 945 mm)
 Power capacity: Refer to the table on the right.
 Cable size: Equal to or larger than the sizes specified in the table on the right.
 Grounding: Class D (Max. 100Ω)
 Cable size should be equal to the power cable

Power capacity and cable sizes

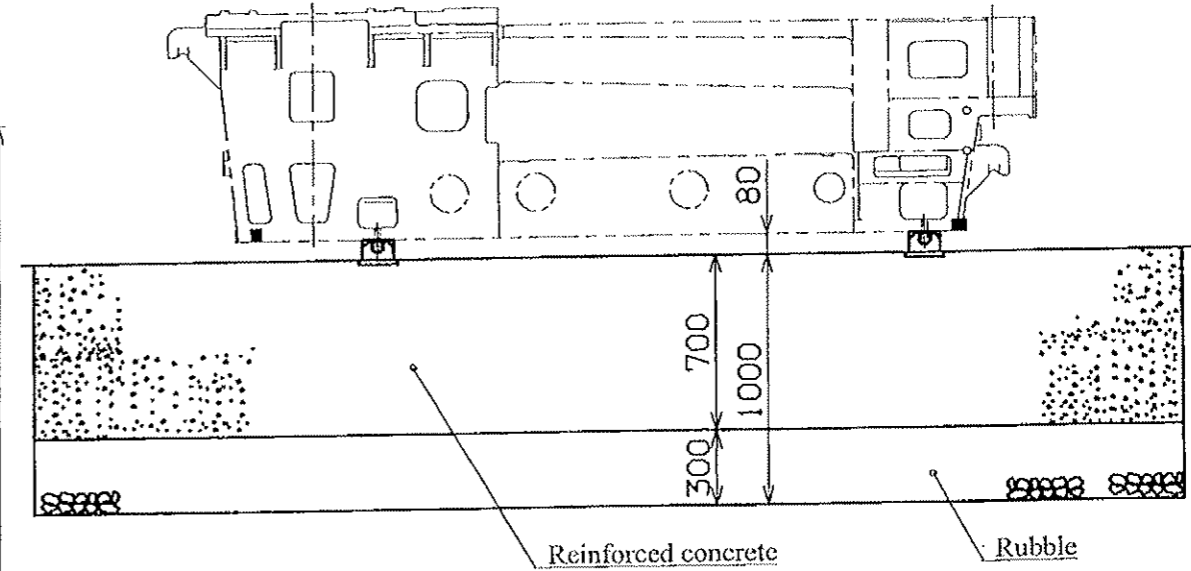
Machine specification	54-m/min rapid traverse rate specification		75-m/min rapid traverse rate specification	
	FANUC		FANUC	
	12R	8R (OP)	12R	8R (OP)
Power capacity (kVA)	76	65	76	65
Cable size (mm ²)	80	60	80	60



< Note > 75-m/min rapid traverse rate specification (option)
 After completion of leveling, attach a plate to each of the four leveling blocks in the bed and secure it in place by lightly pushing a stud bolt (HS) to the edge of the bed. (Refer to the figure below.)



Air supply connection (From floor to the hose nipple: 970 mm)
 Supply pressure: 0.4 to 0.6 MPa
 Capacity : 500 L/min(ANR) or larger
 Hose nipple: φ12 with Rc 1/2
 Customer should prepare and connect a hose that is compatible with the above hose nipple.



[CAUTION]

The foundation anchoring parts are option.

Foundation and Installation :

To maintain machine precision and prevent vibration, pay special attention to the following.

1. The foundation should be rugged enough to maintain safety and horizontality for the machine weight according to the type of soil in the installation place. (Nominal strength : Min. 23 MPa)
2. The foundation concrete should be reinforced by arranging reinforcing bars as appropriate so that it may sufficiently withstand the machine weight.
3. The foundation concrete should be cured for 4 weeks.
4. When installing the machine, set leveling blocks as shown in the drawing for leveling, centering and to prevent oscillation. Periodically check that they stay in proper position and condition.
5. Soil bearing capacity of the ground should be 0.07 MPa at the minimum.
6. When nature of the soil or soil bearing capacity is insufficient, determine sizes and the number of piles and lay them as necessary.
7. Foundation anchor bolts are optional specification.
8. Prepare five iron floor sheets (270 mm × 150 mm × 19 mm thick) before starting the foundation work.

HM-X6000
 Total machine weight : 20000 kg
 Max. loadable weight of workpiece : 650 kg per pallet

HM-X6000	Standard	23
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080903 山本 (直) REF:0169FD002C

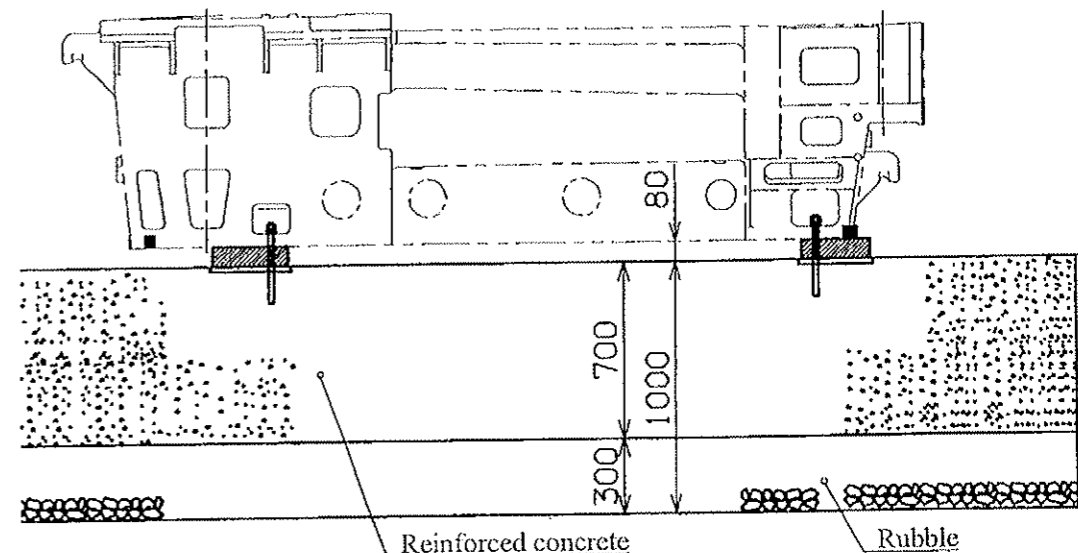
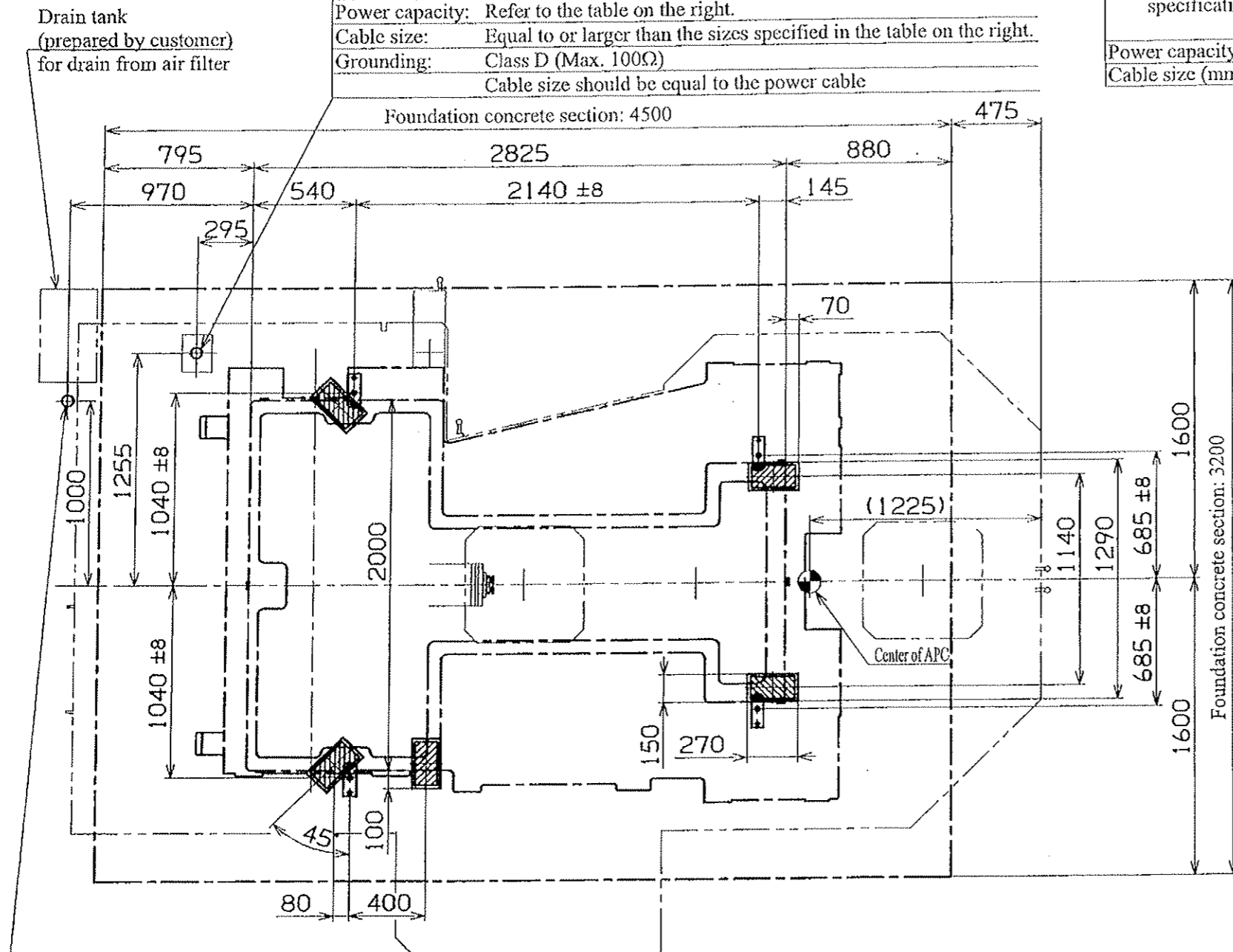
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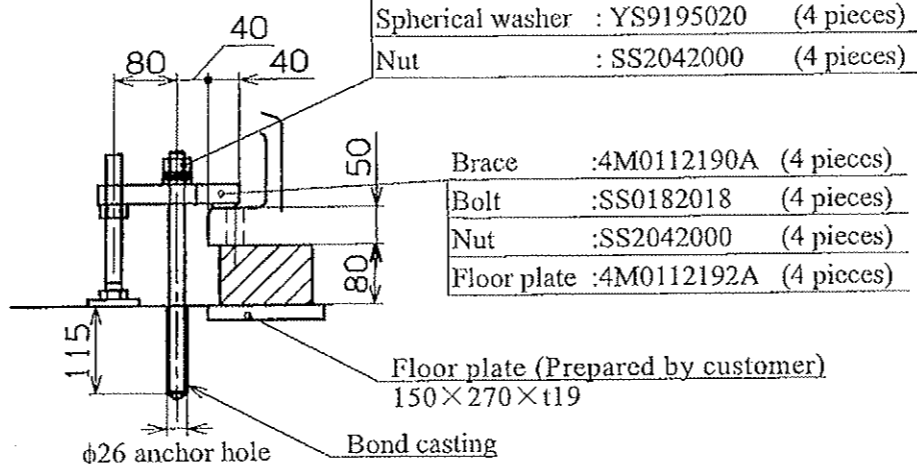
Power cable connection (From floor to the control box base plate: 945 mm)
 Power capacity: Refer to the table on the right.
 Cable size: Equal to or larger than the sizes specified in the table on the right.
 Grounding: Class D (Max. 100Ω)
 Cable size should be equal to the power cable

Machine specification	24-m/min rapid traverse rate specification		15-m/min rapid traverse rate specification	
	FANUC		FANUC	
	12R	8R (OP)	12R	8R (OP)
Power capacity (kVA)	76	65	76	65
Cable size (mm ²)	80	60	80	60



Air supply connection
 (From floor to the hose nipple: 967 mm)
 Supply pressure: 0.4 to 0.6 MPa
 Capacity: 500 L/min(ANR) or larger
 Hose nipple: φ12 with Rc 1/2
 Customer should prepare and connect a hose that is compatible with the above hose nipple.

Anchor bolt : 4M0131398A (4 pieces)
 Spring washer : SS2552000 (4 pieces)
 Spherical washer : YS9195020 (4 pieces)
 Nut : SS2042000 (4 pieces)



Brace : 4M0112190A (4 pieces)
 Bolt : SS0182018 (4 pieces)
 Nut : SS2042000 (4 pieces)
 Floor plate : 4M0112192A (4 pieces)

Foundation and Installation :

To maintain machine precision and prevent vibration, pay special attention to the following.

1. The foundation should be rugged enough to maintain safety and horizontality for the machine weight according to the type of soil in the installation place. (Nominal strength : Min. 23 MPa)
2. The foundation concrete should be reinforced by arranging reinforcing bars as appropriate so that it may sufficiently withstand the machine weight.
3. The foundation concrete should be cured for 4 weeks.
4. When installing the machine, set leveling blocks as shown in the drawing for leveling, centering and to prevent oscillation, and adjust and secure with foundation bolts (option). Periodically check that they stay in proper position and condition.
5. Soil bearing capacity of the ground should be 0.07 MPa at the minimum.
6. When nature of the soil or soil bearing capacity is insufficient, determine sizes and the number of piles and lay them as necessary.
7. Drill each anchor hole in position within ±8 mm from the reference anchor hole.
8. Avoid the anchor hole position to embed the reinforcement.
9. For the bond anchor procedure, refer to the separate "Anchor Bolt Embedding Work Procedure".

NOTE: The following bond is used at the time of anchor hole processing.
 Bond E200 (Konishi Co., Ltd.)
 Required amount: 1.0 kg (Standard spec.)

HM-X6000
 Total machine weight : 20000 kg
 Max. loadable weight of workpiece : 650 kg per pallet