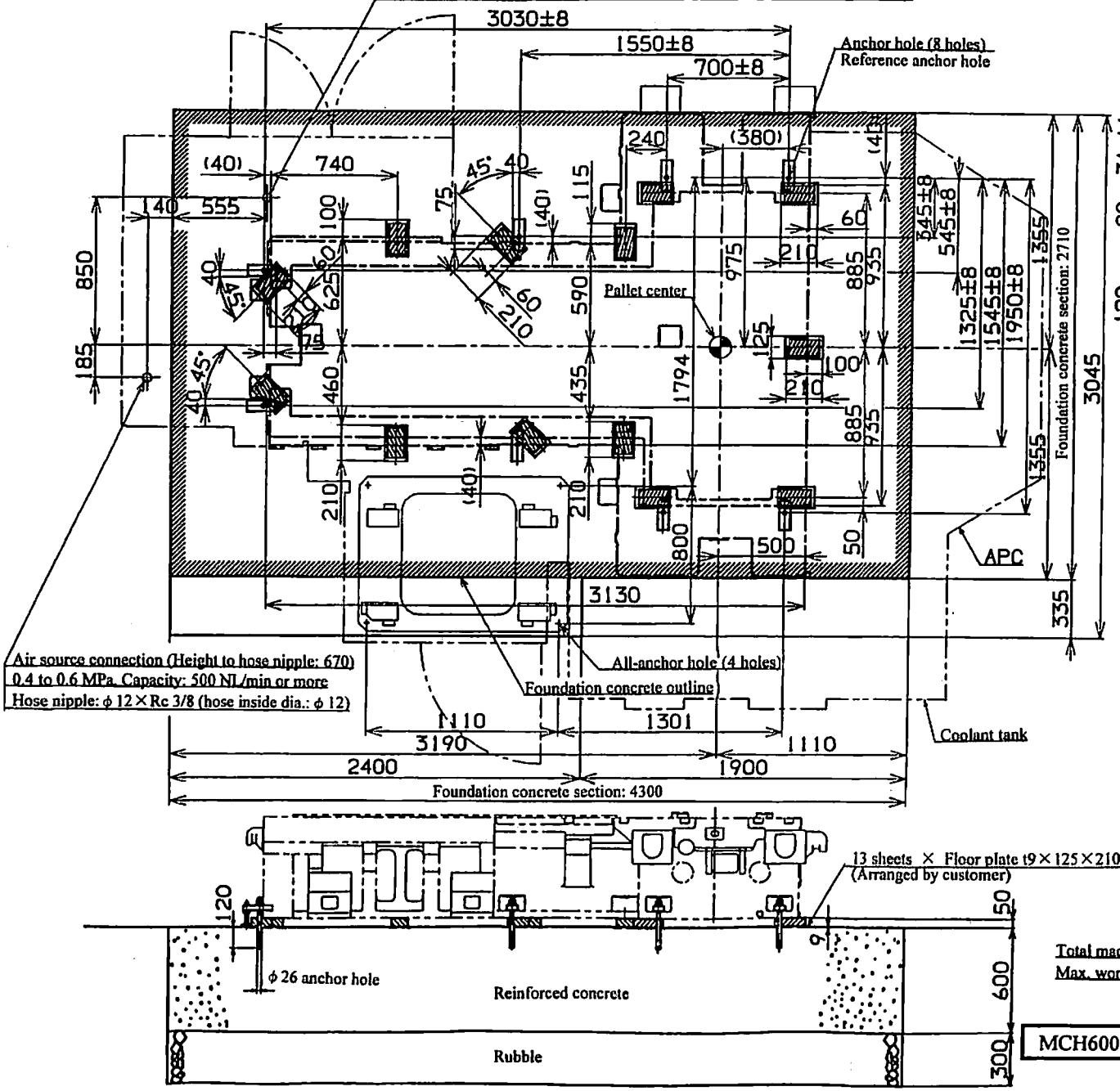
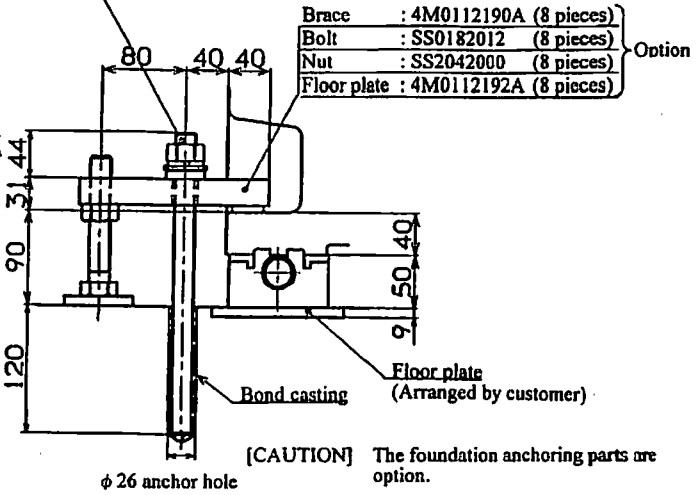
2.4 Foundation Drawing for Installation

Power cable incoming port (Height to control box base: 460) Cable size: 50 mm² or larger			
Specification	Standard specification	Increased spindle motor horsepower	13R-spindle (MS)
Reference power supply capacity (High-pressure coolant)	56 kVA (7 kVA)	61 kVA (7 kVA)	73 kVA (7 kVA)
Grounding: Class D (Max. 100 Ω), Cable size equal to the power cable			



Anchor bolt	: 4M0115254A (8 pieces)	Option
Spring washer	: SS2552000 (8 pieces)	
Spherical washer	: YS9195020 (8 pieces)	
Nut	: SS2042000 (8 pieces)	

Brace	: 4M0112190A (8 pieces)	Option
Bolt	: SS0182012 (8 pieces)	
Nut	: SS2042000 (8 pieces)	
Floor plate	: 4M0112192A (8 pieces)	



[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 ground for installation place. (Nominal strength: 23 MPa Min.)
2. The foundation concrete should be reinforced with the reinforcing bar arranged 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 for leveling, centering and to prevent oscillation as shown in the drawing, and adjust and secure with foundation bolts (option).
   Periodically check that they stay in proper position and condition.
5. The ground soil bearing power required should be 0.06 MPa Min.
6. When the nature of the soil and soil bearing capacity are unfavorable, determine the pile size and number of piles accordingly for installation.
7. Drill each anchor hole in position with tolerance of ±8 mm based on the reference anchor hole.
8. Avoid the anchor hole position to embed the reinforcement.
9. For the bond anchor procedure, refer to "Anchor Bolt Embedding Work Procedure".

NOTE: The following bond is recommendable.
Bond E200 (Konishi Co., Ltd.)
Amount required: 1.0 kg (Standard spec.)

Total machine weight: 15000 kg
Max. workpiece loading capacity: 1250 kg