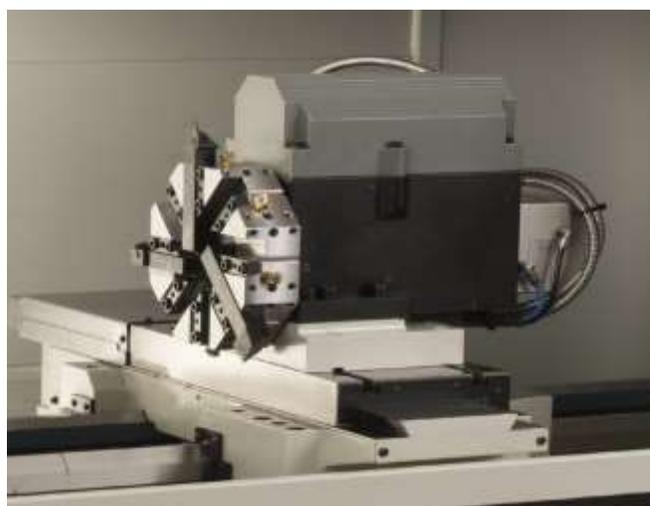


Southwestern Industries, Inc.  
**TRAK CNC Turret**



**TRAK** MACHINE  
TOOLS



**SOUTHWESTERN INDUSTRIES, INC.**

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Southwestern Industries, Inc.  
**TRAK CNC Turret Specifications**

Specifications

- **Servo Motor** – high-performance, very rugged DC brushless servo, thermally protected.
- **Heavy Duty Reducer** – capable of handling impact loads 5X its rating, over 1000 times.
- **Belt Drive** - isolates impact loads from the reducer during accidental tool crashes.
- **Absolute Position Encoder** – guarantees correct tool position every time, non-contact.
- **Coupling** - 3-piece Hirth design, high stiffness and accuracy, no movement during index.
- **Main Body** - thick wall cast iron, provides excellent vibration dampening during cutting.
- **Clamp Cylinder** - clamps with 1275 lbs of clamping force (@ 90 psi air supply), allows coupling to skip teeth during accidental tool crash without causing damage to the unit itself.

Description	Units	¾" (20 mm) disks	1" (25 mm) disks
Weight of turret with disk	lbs (kg)	98 (44.5)	110 (50)
Max. square shank tool holder	in (mm)	0.75 (20)	1.00 (25)
Max. boring bar diameter	in (mm)	1.25 (32)	1.50 (40)
Index time including locking	45°	sec	1.4
	90°	sec	1.8
	135°	sec	2.2
	180°	sec	2.6

- Accuracy specifications

INDEX Position Repeatability (for same location)      +/- 2 arcsec  
INDEX Position Accuracy (for any location)              +/- 6 arcsec

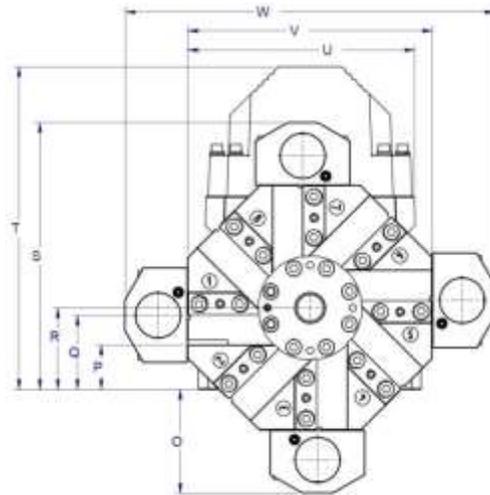
- Power requirements

Electrical Power– 110 VAC, 4 A max., 60 Hz  
Compressed air– 3/8" min. supply line, 80 psi pressure, 1.5 CFM (11 SCFM) min. flow.

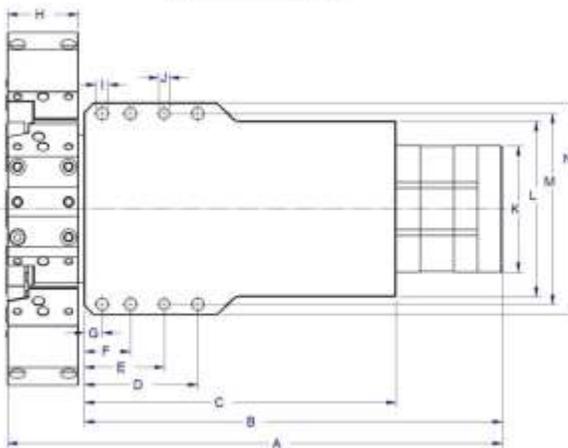
- Maximum Swing with CNC Turret installed and door closed

- 1630SX and 1630HSSX - 12"
- 1845SX (3/4") – 17.5"
- 1845SX (1") – 14"
- 2470SX – 22"

- Overall dimensions



Locating holes for 0.375 dia. pins



Disk Size	A	B	C	D	E	F	G	H	I	J	K	L
3/4" (in)	17.21	14.75	11.000	4.000	2.813	1.625	.625	2.250	.422	.376	4.469	6.213
20 (mm)	437.2	374.7	279.4	101.6	71.5	41.3	15.9	57.2	10.72	9.55	113.5	157.8
1" (in)	17.46	14.75	11.000	4.000	2.813	1.625	.625	2.500	.422	.376	4.469	6.213
25 (mm)	443.5	374.7	279.4	101.6	71.5	41.3	15.9	63.5	10.72	9.55	113.5	157.8

Disk Size	M	N	O	P	Q	R	S	T	U	V	W
3/4" (in)	6.750	7.500	2.375	1.750	2.500	2.750	7.875	10.875	7.000	6.500	10.250
20 (mm)	171.45	190.5	60.3	44.5	64.45*	69.9	200.0	276.2	177.8	165.1	260.4
1" (in)	6.750	7.500	3.500	1.500	2.500	2.750	9.000	10.875	7.875	8.250	12.500
25 (mm)	171.45	190.5	88.9	38.1	63.10*	69.9	228.6	276.2	200.0	209.6	317.5