

POWER FEED INSTALLATION

Model M-0200 Table Feed

Bridgeport Mill & Others



REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-0296	Power Feed Installation
ND-6293	Type 150 Servo Power Feed
ND-6292	Type 140 Servo Power Feed
0800-80001	Servo Power Feed Operation
0800-80426	Parts List I.D. Sheet K-0200

PREPARATION

Step 1: Gather together the following items that you will need to complete this installation.

- a) soft hammer
- b) 3/4" socket wrench
- c) set of inch hex wrenches
- d) grease
- e) clean shop rag

Step 2: Move the table to the extreme left.

Step 3: Remove the nut, handle, and dial assembly from the right-hand end of the table.

Step 4: Remove the four cap screws holding the bearing housing in place.

Step 5: Using a soft hammer, tap the bearing housing off. Clean the end surface of the table.

POWER FEED INSTALLATION

Step 1: With the table in the extreme left-hand position, install the adaptor with the four cap screws

➔ **NOTE** On some machines the drive pin holes do not line up with the adaptor. Remove and discard the pins in such cases. The four cap screws are all that is necessary.

Step 2: Slide the bearing race onto the lead screw.

Step 3: Slide the power feed onto the bearing race and push flush to the end of the adaptor. Secure with two 1/4-20 x 1" long socket head cap screws.

BEVEL GEAR INSTALLATION

Step 1: Follow the drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

DIAL AND HANDWHEEL INSTALLATION

Step 1: After getting the proper gear backlash, the dial should be adjusted to obtain .005" spacing from the face of the power feed. This is important in order to keep chips from entering the gear train. Three plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.

Step 2: In the following sequence, replace the key (if removed), dial, and dial locking nut. Slide the handle in place and tighten with 1/2-20 locknut #01115.

LIMIT SWITCH INSTALLATION

Step 1: Remove the standard table stop pieces and install the table stop pieces furnished. Put the standard stops back in a position to prevent feed stops from being set beyond extreme table travel.

Step 2: Remove the two cap screws holding the T-shaped table stop. Place the limit switch spacers into the T-stop and install limit switch using 3/8-16 x 1-1/4" long socket head cap screws.

Step 3: The T-stop is retained to act as a positive stop where required for manual operation.

➔ **NOTE** For proper operation, the electrical limit switch should be engaged 0.4 inch before the mechanical stop to allow for coasting of the table. The T-stops are often not symmetrical and may need to be ground to obtain proper operation.

Step 4: Put the cable clamp on the cable and secure to the right-hand chip scraper screw.

OPERATION

See separate *Servo Power Feed Operation* sheet. Plug the unit into a source of 120 volt, 50 or 60 cycle power.

WARNINGS

Check hand crank clearances before operation.

Clearances between the surfaces of the hand crank and the non-moving parts of the equipment on which the hand crank is installed must be at least one-fourth inch (1/4") to prevent injury. Modification of existing hand crank or replacement may be required.

Do not operate without proper clearance!

Prevent contact during fast traverses.

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Web: www.servoproductsco.com

CALIFORNIA BRANCH

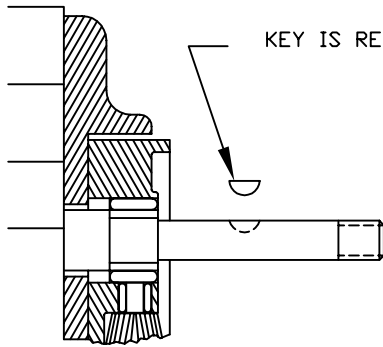
14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

HEADQUARTERS

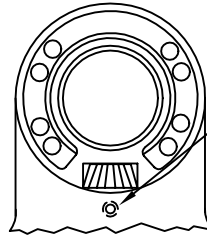
34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555

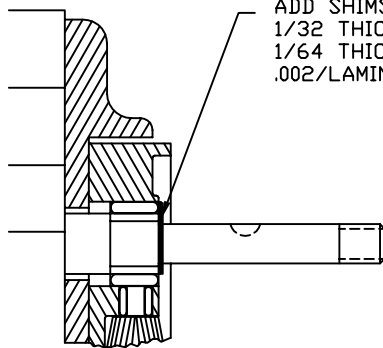


KEY IS REMOVED DURING SHIMMING

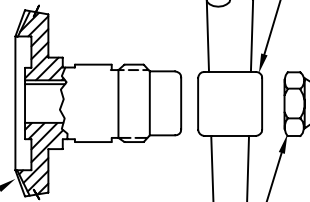


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1
PREPARATION



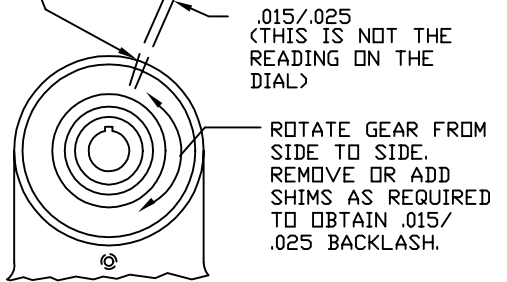
ADD SHIMS PROVIDED
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION



PUSH BEVEL GEAR
AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR
WITH PENCIL TO CHECK BACKLASH.



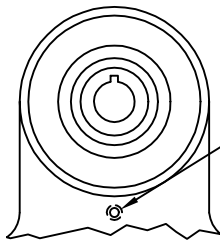
.015/.025
(THIS IS NOT THE
READING ON THE
DIAL)

ROTATE GEAR FROM
SIDE TO SIDE.
REMOVE OR ADD
SHIMS AS REQUIRED
TO OBTAIN .015/
.025 BACKLASH.

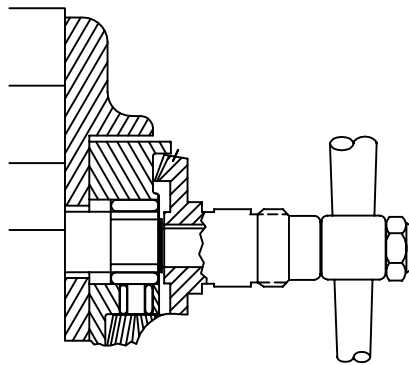
TIGHTEN NUT.

STEP 2
SHIMMING BEVEL
GEAR

CAUTION: IF BACKLASH
IS NOT PROPERLY SET
BEFORE TURNING UNIT ON,
BEVEL GEAR MAY BE
DESTROYED.



LOOSEN SETSCREW

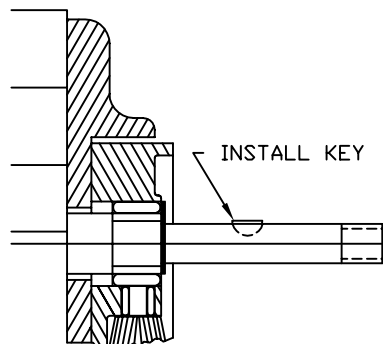


WITH POWER FEED IN
NEUTRAL POSITION, TURN
HANDCRANK. IF EXCESSIVE
GEAR NOISE OR BINDING
OCCURS, SHIMS NEED TO BE
ADDED. WHEN ADDING SHIMS,
REPEAT STEPS 1 AND 2.



CONTROL HANDLE @
NEUTRAL POSITION

STEP 3
DOUBLE CHECK OF SHIMMING



INSTALL KEY



SEAL

REMOVE GEAR, PACK WITH GREASE.
(DO NOT USE SILICONE TYPE GREASE)
REPLACE GEAR.
(DO NOT LOSE ANY SHIMS)

PICTURES IN THIS DRAWING ARE FOR
REFERENCE ONLY. SEE INSTALLATION
DRAWING OF CORRESPONDING MODEL
FOR EXACT PARTS CONFIGURATION.

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BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4
LUBRICATION



M-0200 TABLE FEED PARTS IDENTIFICATION LIST

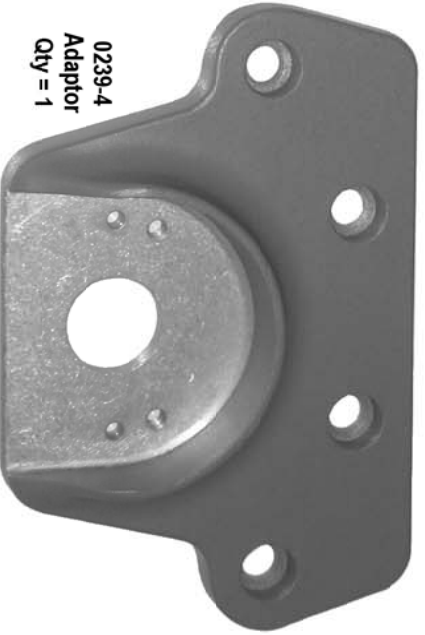
- 00579 Clamp Qty = 1
- 01050 Clamp Qty = 1
- 00688 Phil Pan Hd Screw Qty = 1
- 0266 Limit Switch Gasket Qty = 1
- 0272 Limit Switch Bracket Qty = 1
- 06928 Phil Pan Hd Screw Qty = 4
- 0271 Limit Switch Spacer Qty = 2
- 00585 Soc Hd Cap Screw Qty = 2



- 00689 Hex Hd Bolt Qty = 2
- 0247 Stop Nut Qty = 2
- 0251 Limit Stop Qty = 2
- 01115 Lock Nut Qty = 1
- 59254 Dial Nut Qty = 1
- 01251 Brass Shim Qty = 5
- 01252 Plastic Shim Qty = 2
- 0237 Bevel Gear Qty = 1

- 0589-32 .032 Shim Qty = 2
- 0589-16L .016 Shim Qty = 2
- 0246 Bearing Race Qty = 1
- 00586 Soc Hd Cap Screw Qty = 2

- 00595 Roll Pin Qty = 2
- 00596 Roll Pin Qty = 2



- 0239-4 Adaptor Qty = 1