



SERVO POWER FEED MAINTENANCE

CAUTION

Every attempt has been made to seal this feed. However, excessive amounts of coolant can work its way in and ultimately damage the feed. For long life, keep the unit as dry as possible. Wipe down at the end of each shift.

Motor Brushes - The motor is a commutator type with the brushes accessible from the outside. The replacement brush, part number 01283, is available from your dealer or the factory. Inspect the brushes monthly. Replace if less than 1/4" long. Reseal the brush caps with Silastic 738 RTV non-corrosive adhesive sealant.

Lubrication - At assembly, grease the bevel gear with bearing grease as noted on drawing #NA-5444.

WARNING

When using a power feed unit, it is important to replace the standard feed handle with a safety handle. Failure to do so could result in injury.

A proper safety handle is available through your Servo Products Company distributor.

WARRANTY

All Servo Products Company products are warranted against defects in material and workmanship. This warranty applies for one year from the day of delivery to the customer.

KP-0620

Safety Handwheel Kit
(Does not spin under power.)



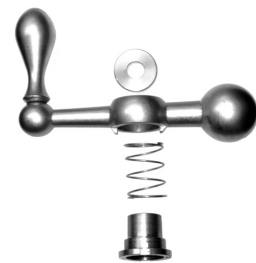
29976-SP

Handwheel with Retractable Handle



038-0406

Safety Ballcrank Handle
(Does not spin under power.)



Other Options Available:

Model 640 Shaft Extension Kit (Restores normal table travel when feed is mounted on Bridgeport mill table)

Model 660 Limit Switch Kit (Mounts limit switch to rear of table when front tee slot is covered, for example, by a linear scale.)

Model 670 Shaft Extension Kit (Restores normal table travel when feed is mounted on Lagun mill table)

Recommended Spare Parts:

See drawing #6292L (Type 140) or #6293L (Type 150) for an exploded view of the feed showing all parts.

01283	Motor Brush
01282	Brush holder
00573	Brush cap
4737	Gear clutch assembly
2974	Bottom cover
04103-K	Circuit breaker 3.0
***	Bevel gear (need make & model of mill and for which axis X, Y or Z)

SERVO Power Feeds are proudly manufactured in the USA by

SERVO PRODUCTS COMPANY

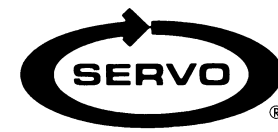
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Email: info@ServoProductsCo.com

Call or see website for location of regional Service Centers.



SERVO POWER FEED OPERATION

Power - Plug the feed into a source of 120 volts ac, 50/60 cycle power having a current capacity of five amperes.

CAUTION

The feed has a 3-wire cord that includes a ground prong. **Do not** remove this ground prong. On installations where the cord is wired to a junction box, be sure to ground the green wire.

Turn the power switch ON. The blue LED pilot illuminates to verify that the feed control has power. Turn the power OFF at night or when the feed will not be used for an extended period.

Feed Direction - The operating handle controls the feed direction. Handle to the left feeds to the left; handle to the right feeds to the right. When the handle is in the center, the feed stops and the clutch disengages.

Feed Rate - Rotate the black center knob to control the feed rate. The numbers (0-9) are for reference only. The Type 150 feed rate is regulated electronically, which means the rate remains essentially constant at typical cutting speeds no matter the load, within the capacity of the feed. **Do not** use the Type 150 as a knee feed; it will stall.

Rapid Traverse - Press the blue LED switch to increase the feed rate to 35 ipm (inches per minute). This does not disturb the feed rate previously selected using the black center knob.

Overload Protection - The circuit and motor are protected by a circuit breaker-on/off switch combination that will trip when the feed is under excessive load. To reset: disengage the feed. Then turn the power switch back on. **Do not overload the feed.** If the circuit breaker trips, reduce the cutting load before continuing.

Limit Switches - The limit switch is a safety stop only and is not intended to be used as a precision stop. The stopping point changes according to the speed of the motor at the time the limit stop is engaged. When the feed shuts itself off against a stop, move the handle to the opposite side to reverse the feed. It will automatically feed in the direction away from the stop.

CAUTION

Do not allow the feed to crash into any hard stop. This may damage the feed and the milling machine. Always set the stops so that they prevent the feed from running into the end of the table travel.

WARNING

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-quarter 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.

