

# POWER FEED INSTALLATION

## Model M-1550 Cross Feed

### Lagun Mills



#### REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-1996	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Operation

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#### PREPARATION

- Step 1:* Remove the nut, key, handle, and dial assembly from the lead screw.
- Step 2:* Remove the shroud from the power feed.
- Step 3:* Slide the spacer and bearing race onto the lead screw.
- Step 4:* Slide the power feed over the bearing race and square to the mill.
- Step 5:* Transfer the mounting holes from the power feed to the mill.
- Step 6:* Remove the power feed, spacer, and bearing race from the mill.
- Step 7:* Drill and tap 1/4-20 x 3/8" deep thread into the bearing housing. **Do not** contaminate the bearings.

#### POWER FEED INSTALLATION

- Step 1:* Screw the shaft extension onto the lead screw and tighten.
- Step 2:* Using the hole provided as a pilot, drill 1/8" diameter through the lead screw and pin the extension in place using the 1/8" diameter x 5/8" long roll pin. File smooth.
- Step 3:* Slide the spacer and bearing race onto the lead screw.
- Step 4:* Place the shroud onto the power feed and slide the unit onto the lead screw. Secure using 1/4-20 x 1-1/4" long socket head cap screws.

#### BEVEL GEAR INSTALLATION

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

#### DIAL AND HANDCRANK INSTALLATION

- Step 1:* After getting the proper 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. Plastic and metal washers are provided for this. Shim as required.

*Step 2:* In the following sequence, put on the dial locking nut, place key in the shaft extension, and slide the handcrank #57903 in place. Secure with the 1/2-20 lock nut.

## LIMIT SWITCH INSTALLATION

*Step 1:* See the limit switch installation on drawing ND-1996.

## 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.

# SERVO PRODUCTS COMPANY

Web: [www.servoproductsco.com](http://www.servoproductsco.com)

## CALIFORNIA BRANCH

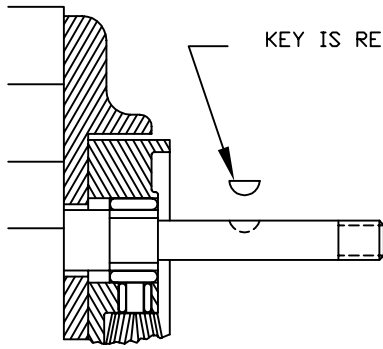
14254 Valley Blvd., Unit A  
City of Industry, CA 91746  
Ph. 626.961.7800 Fax 626.961.2444

## HEADQUARTERS

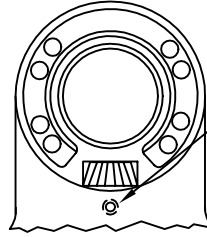
34940 Lakeland Blvd.  
Eastlake, OH 44095  
Ph. 440.942.9999 Fax 440.942-9100

## FLORIDA BRANCH

8950 131<sup>st</sup> Ave. N.  
Largo, FL 33773  
Ph. 727.585.8555 Fax 727.585.6555

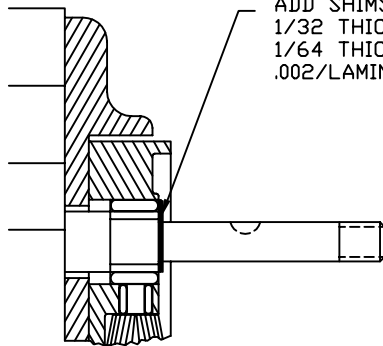


KEY IS REMOVED DURING SHIMMING

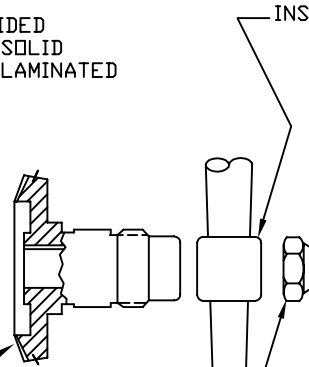


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1  
PREPARATION



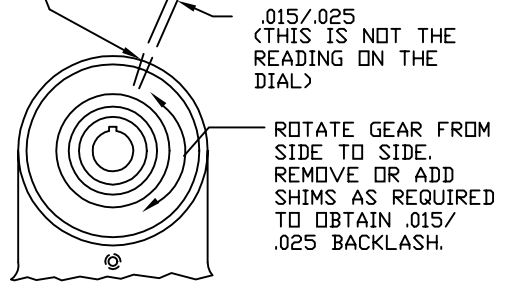
ADD SHIMS PROVIDED  
1/32 THICK ARE SOLID  
1/64 THICK ARE LAMINATED  
.002/LAMINATION



PUSH BEVEL GEAR AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.



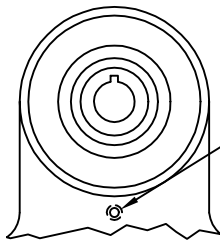
.015/.025  
(THIS IS NOT THE READING ON THE DIAL)

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

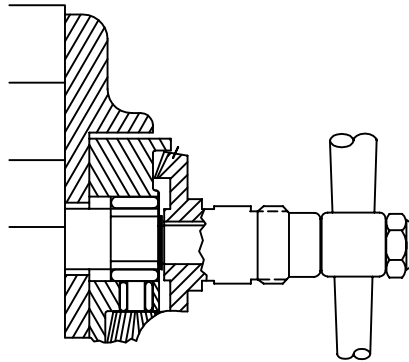
STEP 2  
SHIMMING BEVEL GEAR

TIGHTEN NUT.

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



LOOSEN SETSCREW

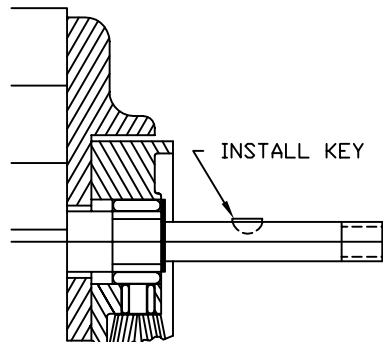


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.



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





# M-1550 CROSS FEED PARTS IDENTIFICATION LIST

- 00579 Clamp Qty = 1
- 01050 Clamp Qty = 1
- 00669 Phil Pan Head Screw Qty = 1
- 01095 Phil Flat Head Screw Qty = 1
- 1171 Limit Switch Bracket Qty = 1
- 0266 Limit Switch Gasket Qty = 1
- 0361 Limit Switch Bracket Qty = 1
- 00613 Phil Flat Head Screw Qty = 2
- 1750 Limit Switch Bar Qty = 1
- 00670 Soc Head Cap Screw Qty = 2



- 1752 Trip Rail Qty = 1
- 01161 Button Head Cap Screw Qty = 2

- 1536 Stop Stud Qty = 2
- 1537 Stop Ring Qty = 2
- 01082 Hex Nut Qty = 2



- 2417-2 Shroud Qty = 1

- 01318 Key Qty = 1
- 00564 Roll Pin Qty = 1
- 2418 Shaft Extension Qty = 1
- 01115 Lock Nut Qty = 1
- 01251 Brass Shim Qty = 5
- 01252 Plastic Shim Qty = 5

- 59254 Dial Nut Qty = 1
- 3618 Bevel Gear Qty = 1
- 0589-16L .016 Shim Qty = 2
- 0589-32 .032 Shim Qty = 8
- 1178 Bearing Race Qty = 1
- 1262 Spacer Qty = 1
- 01072 Soc Head Cap Screw Qty = 2