



# SERVO TYPE 350X 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** – Are no longer used, the Type 350X uses a brushless DC motor that provides much greater power, efficiency, and reliability.

**Lubrication** - At assembly, grease the bevel gear with bearing grease as noted on drawing #NA-5444. The large metal drive gear (4738X) at the bottom of the power feed will require a light coat of high impact grease every 6 months or sooner depending on usage.

### 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

Servo Products Company Type 350X is warranted against defects in material and workmanship. This warranty applies for two years from the day of delivery to the customer. See warranty page for details.

#### 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)

### Replacement Parts:

See the drawing on the reverse side of this sheet for an exploded view of the feed showing all parts.

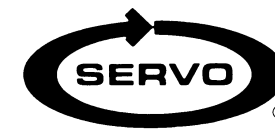


www.servoautomation.com

SERVO Power Feeds are proudly manufactured in the USA by

### SERVO PRODUCTS COMPANY

34940 Lakeland Blvd, Eastlake, OH 44095 USA  
Phone: 800.521.7359 or 440.942.9999 Fax: 440.942.9100  
Website: ServoProductsCo.com  
Email: info@ServoProductsCo.com  
Call or see website for location of regional Service Centers.



# SERVO TYPE 350X 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. The Type 350X also has the capability to operate from 240 volts ac with an internal jumper change. (This should only be performed by a qualified technician)

### 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 350X feed rate is regulated electronically with closed loop feedback, which maintains perfect constant speed no matter the load.

**Rapid Traverse** - Press the blue LED switch to increase the feed rate to 32 ipm (inches per minute). This does not disturb the feed rate previously selected using the black center knob.

**E-Stop Button** - The Type 350X incorporates a safety E-Stop button that will immediately stop the power feed when pressed. To restore operation, the E-Stop button must first be released and the direction handle returned to the center position before the feed will operate.

**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.

**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.

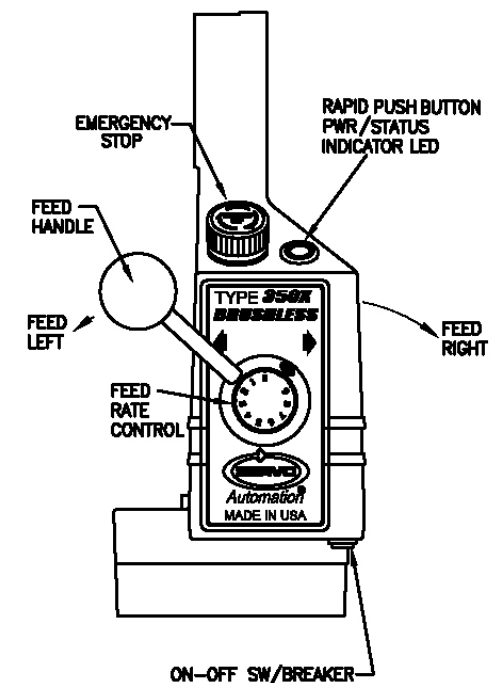
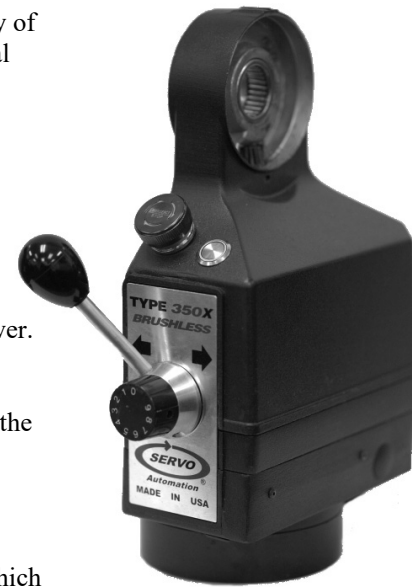
### WARNING

#### 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.



# TYPE 350X POWER FEED

