POWER FEED INSTALLATION
Model M-9501 Cross Feed
Willis Micro Cut

REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-57120	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Operation

PREPARATION

Step 1: Remove the nut, crank, dial assembly, and key from the lead screw.

Step 2: Remove the bearing retainer from the bearing housing.

POWER FEED INSTALLATION

Step 1: Screw the shaft extension onto the lead screw.

Step 2: Using the hole provided as a pilot, drill 1/8 diameter hole and pin the extension in place using the 1/8 x 5/8 roll pin. File smooth.

Step 3: Install the adaptor using three 1/4-20 x 1-1/4" socket head cap screws.

Step 4: Slide the spacers #2253 and #0477 onto the lead screw.

Step 5: Slide the bearing race onto the lead screw.

Step 6: Slide the power feed over the bearing race. Secure using two 1/4-20 x 1" 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. Four washers are provided for this, two solid and two laminated. Shim as required.

Step 2: Put on the dial locking nut.

Step 3: Install the square key in the shaft extension. Cut length to fit.

Step 4: Install the crank and secure using the locking nut.

LIMIT SWITCH INSTALLATION

Step 1: See limit switch installation on drawing NB-57120.

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

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Largo, FL 33773
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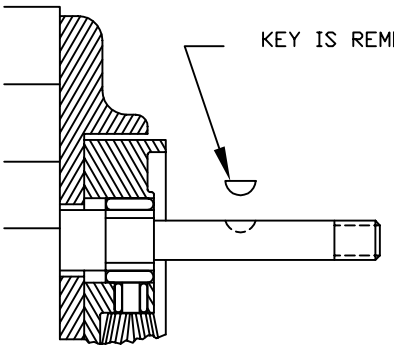
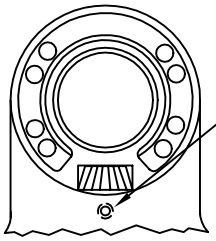
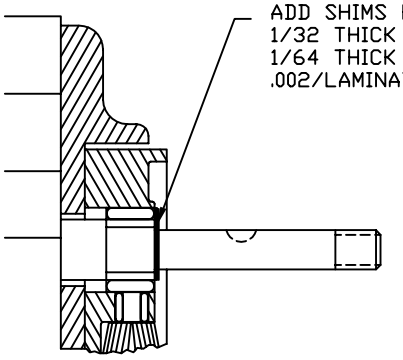
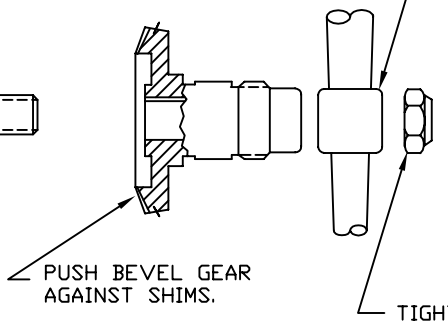
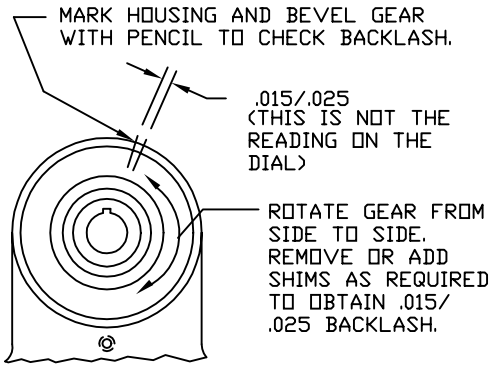




STEP 1
PREPARATION

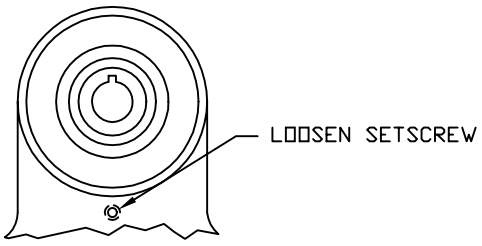


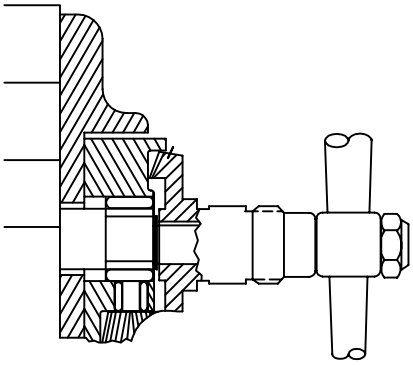




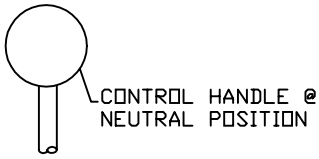
STEP 2
SHIMMING BEVEL GEAR

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

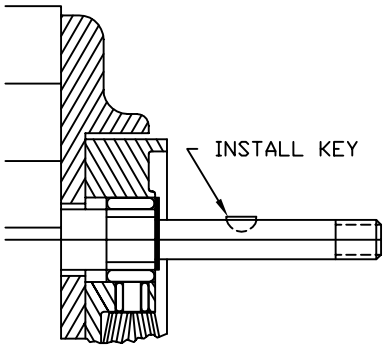


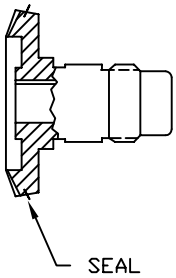


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.



STEP 3
DOUBLE CHECK OF SHIMMING





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

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

STEP 4
LUBRICATION

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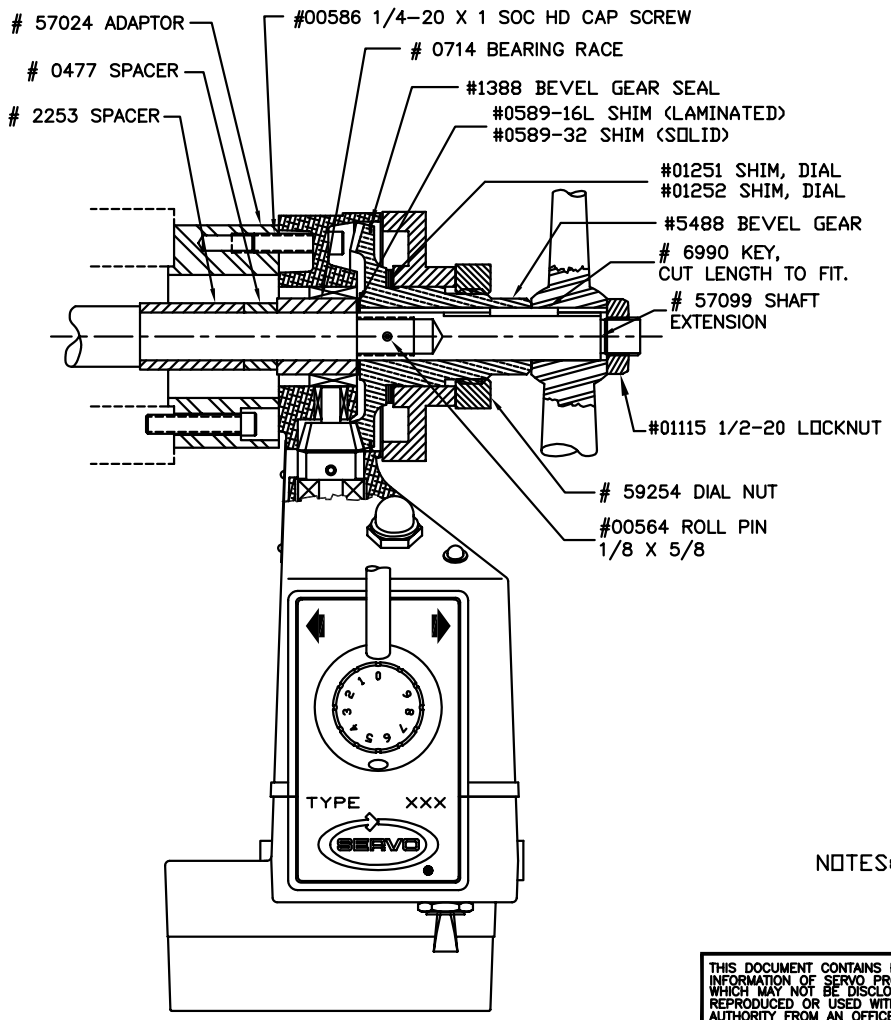
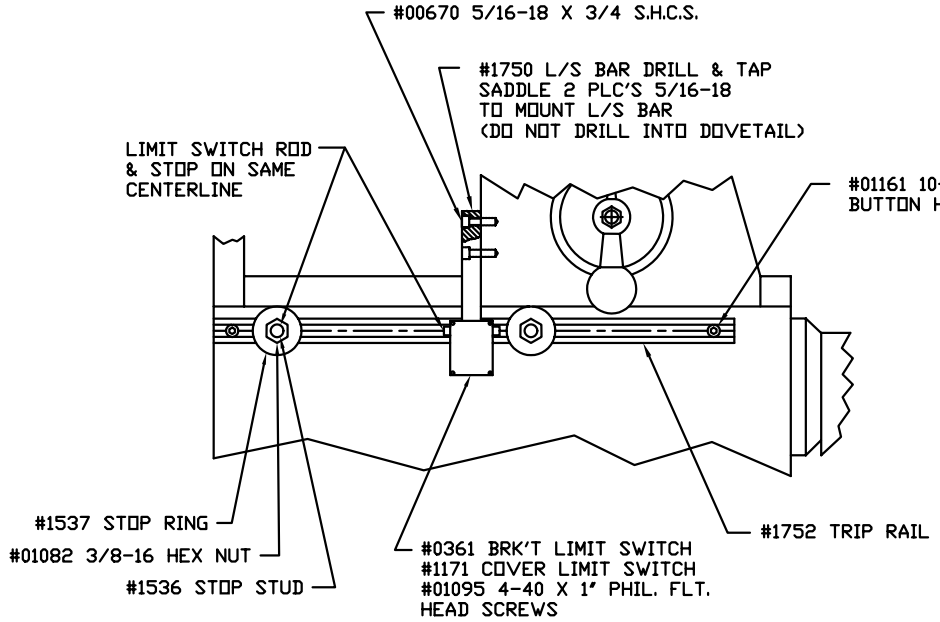
BEVEL GEAR INSTALLATION

NA-5444 C

REVISION					
ECO	LTR	DESCRIPTION	DATE	DRAWN	CHECKED





LIMIT SWITCH INSTALLATION
LEFT SIDE OF KNEE.

NOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON SERVO POWER FEED.

UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, RUNOUT, CONCENTRICITY, CYLINDRICITY TO BE WITHIN .01 TOTAL OR .040/ft. SURFACE ROUGHNESS WITHIN 125/ REMOVE SHARP CORNERS AND EDGES .005 MIN. DRAFTING STANDARD PER ANSI Y14.5M-1982

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & APPLY AFTER PLATING
TOLERANCES ARE:
FRACTIONS DECIMALS ANGLES
±1/64 .XX ±.01 ± 1/2°
.XXX±.005

MATERIAL

FINISH

DO NOT SCALE DRAWING

NEXT ASSY	USED ON
APPLICATION	

CONTRACT NO.

APPROVALS	DATE
DRAWN T. KU	7/24/97
CHECKED	

COMPUTER NO.

SERVO PRODUCTS COMPANY
34940 LAKELAND BLVD., EASTLAKE, OH 44095

POWER FEED INSTALLATION MODEL 9501

SIZE	CODE IDENT NO.	DRAWING NO.	REV.
B		NB-57120	
SCALE 5/8		SHEET OF	