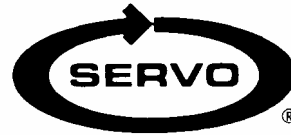


DYNAMO FEED INSTALLATION

Model D1000-1300 Table Feed

Kondia G, FV-1, Hurco SM1 and others



PREPARATION

Step 1: Remove the nut, handle, and dial assembly from the right-hand end of the table.

Step 2: Remove the bearing retainer from the end bracket. Save the screws.

POWER FEED INSTALLATION

Step 1: Attach the bearing retainer #2784 using the original screws.

Step 2: Slip the bearing race inside the adaptor. Slide them on the lead screw up to the end bracket and secure the adaptor with the three 1/4-20 x 1/2" long socket head cap screws. Remove the bearing race.

Step 3: Add the sleeve as shown, followed by the bearing race.

Step 4: Install the power feed to the adaptor using the 1/4-20 x 1" long socket head cap screws.

Step 5: Screw the shaft extension on the lead screw and tighten.

Step 6: Pin the shaft extension. NOTE: (You may wish to do this step after determining the shims required for the bevel gear.)
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.

BEVEL GEAR INSTALLATION

Step 1: Install two of the thickest shim washers, then the bevel gear. Measure the gap between the back face of the gear and the front face of the power feed, as shown in FIG. A. Add, remove or replace shims as needed to obtain the .080/.085 in. (2.0 / 2.16 mm) measurement. Install the handcrank and nut. Check to see the measurement is still ok after the nut is tightened.

Step 2: With feed in neutral turn hand crank. If it turns freely in one direction but catches in the other, backlash is too large. Reduce the shim thickness. If rough engagement is heard or felt in BOTH directions you need additional shims.

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 shim washers are provided for this. Shim as required.

Step 2: In the following sequence, put on the dial locking nut, add spacer #1230, and insert the woodruff key #1318. Slide the handcrank in place and secure with washer and handcrank nut #1229.

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 T-shaped table stop piece and install limit switch using existing screws. A spacer may be required to space limit switch from table.

□ NOTE

Step 1: For proper operation, the electrical limit switch should be engaged .4 inch before the mechanical stop to allow for coasting of the table.

Step 2: Put the cable clamp on the cable and secure to the right-hand chip scraper screw.

OPERATION

See DYNAMO INSTALLATION & OPERATION MANUAL

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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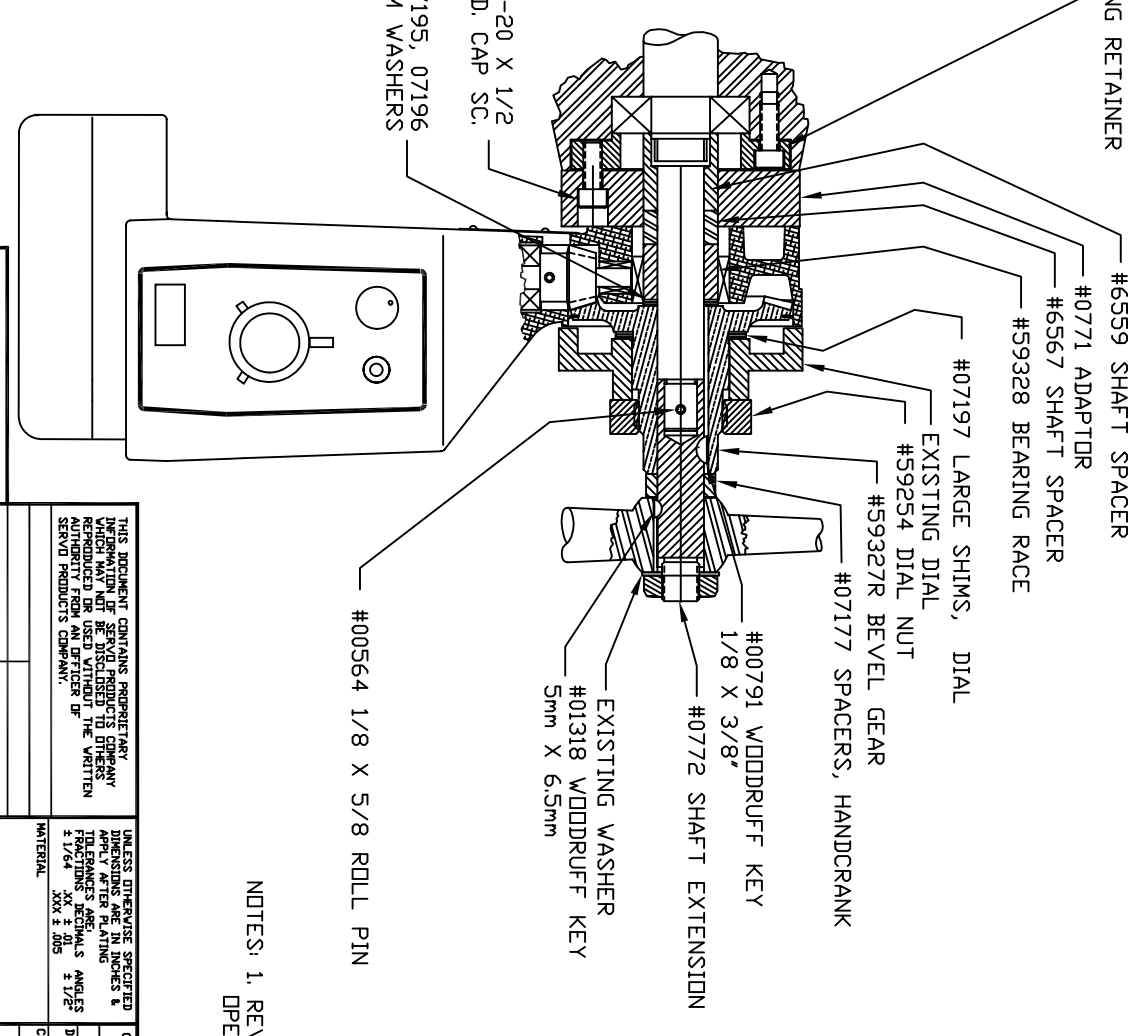
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REVISION			
NO.	DESCRIPTION	DATE	DRAWN CHECKED
1			
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NOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON SERVO POWER FEED.

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SERVO PRODUCTS COMPANY
 3490 LAKELAND BL. EASTLAKE, OH 44095 USA

INSTALLATION DRAWING

MODEL D1000-1300

SIZE B CODE IDENT NO. 0800-80981 DRAWING NO. NB-59612 REV.

SCALE 5/8 SHEET 1 OF 1

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