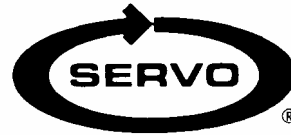


# DYNAMO FEED INSTALLATION

## Model D1000-1350 Cross Feed

Kondia G, FV-1, Hurco SM1,  
and others



### PREPARATION

- Step 1:* Remove the nut, hand crank, dial, dial hub, and key from the lead screw.
- Step 2:* Replace the Kondia bearing retainer with the bearing retainer provided.
- Step 3:* Slide the bearing race into the adaptor.
- Step 4:* Slide the adaptor and bearing race onto the lead screw and secure to bearing retainer with the 1/4-20 x 1/2" long socket head cap screws.
- Step 5:* Remove the bearing race.

### 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 shaft 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:* Secure the power feed to the adaptor using the 1/4-20 x 1" long socket head cap screws.

### BEVEL GEAR INSTALLATION

- Step 1:* Turn the leadscrew CW to ensure the leadscrew is extended out fully and shouldered against the bearing
- Step 2:* 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. of the INSTALLATION & OPERATION MANUAL. Add, remove or replace shims to obtain the .080/.085 in. (2.0 / 2.16 mm) dimension. Install the spacer, handcrank, and nut. Check that the dimension is still ok after the nut is tightened.
- Step 3:* With feed in neutral, turn hand crank. If it turns freely in one direction but catches in the other, the backlash is too large. Reduce the thickness of the shims. If rough engagement is heard or felt in BOTH directions you need additional shims.

## DIAL AND HANDWHEEL 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. Two plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.

*Step 2:* In the following sequence, put on the dial locking nut, add the spacer #1230, and insert the woodruff key. Slide the Kondia hand crank and washer in place. Secure with the hand crank nut #1229.

## LIMIT SWITCH INSTALLATION

Refer to the D-1000Y INSTALLATION & OPERATION MANUAL

## OPERATION

See 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

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

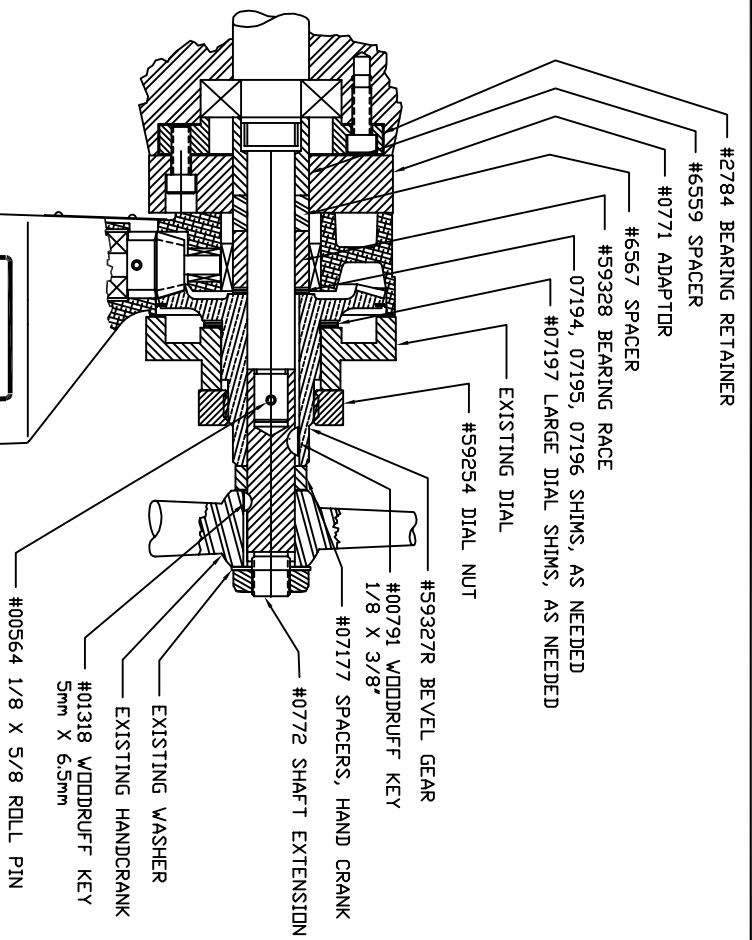
### HEADQUARTERS

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

REVISION		DATE	DRAWN	CHECKED
ECO	LTR			
DESCRIPTION				



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

UNLESS OTHERWISE SPECIFIED, PERPENDICULARITY TO BE WITHIN .01 FLATNESS TO BE WITHIN .01 CONCENTRICITY TO BE WITHIN .01 AND ALL SHARP EDGES AND CORNERS ROUNDED STANDARD PER ANSI Y14.5M-1982

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APPROVALS	07/01/09
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**SERVO** SERVO PRODUCTS COMPANY  
34940 LANGLAND BLVD., EASTLAKE, OHIO 44095

**INSTALLATION DRAWING**

MODEL D1000-1350

SIZE: B CODE: 0800-80982 DRAWING NO.: NB-59613

SCALE: 5/8 SHEET 1 OF 1

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