

DYNAMO FEED INSTALLATION

Model D1000-3750 Cross Feed

Alliant, Sharp First, and others



PREPARATION

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

POWER FEED INSTALLATION

Step 1: Place the adaptor in the cavity of the bearing carrier.

Step 2: Using the adaptor as a template, spot four holes.

Step 3: Drill and tap 1/4-20 four places.

NOTE *Due to the irregularities in a cast surface, take special care to be sure that the adaptor is centered and parallel to the lead screw. Shim as required.*

Step 4: Secure the adaptor using four 1/4-20 x 1" cap screws.

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

Step 6: Using the hole provided as a pilot, drill a 1/8 diameter hole through the shaft extension.

Step 7: Pin the shaft extension to the lead screw with the 1/8 diameter x 5/8" long roll pin. File smooth.

Step 8: Slide the bearing race onto the lead screw.

Step 9: Mount the power feed to the adaptor using two 1/4-20 x 1" 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, insert the modified #7 woodruff key. Install the hand crank . 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.

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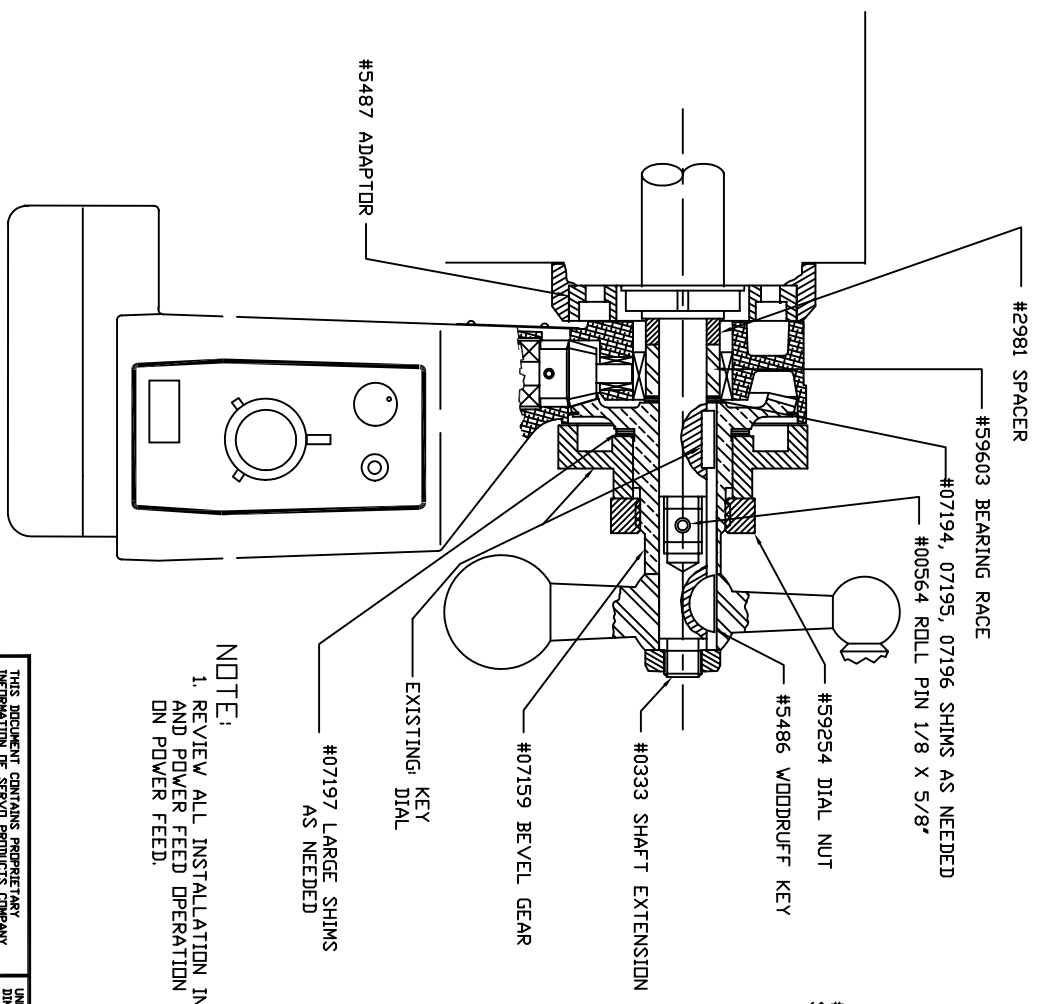
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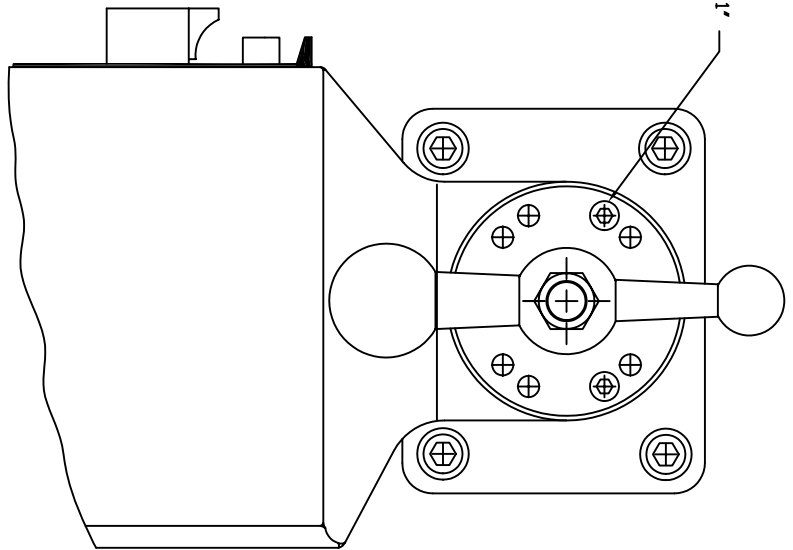
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REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



NOTE:
1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATION BEFORE TURNING ON POWER FEED.

#00586 1/4-20 x 1"
SDC: HD, CAP SC.
(2) PLS



UNLESS OTHERWISE SPECIFIED, FINISHES ARE TO BE WITHIN 0.1 FLATNESS TO BE WITHIN 0.1 CONCENTRICITY TO BE WITHIN 0.1 REMOVE SHARP EDGES AND CORNERS 0.05 MIN. DIMETING STANDARD PER ANSI Y14.5M-1992

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS: DECIMALS ± 0.005 FRACTIONS ± 1/64 ANGLES ± 1/2° FINISH NOTED MATERIAL CHECKED

CONTRACT NO.	APPROVALS	DATE
DRAWN BIMA	7/08/09	
CHECKED		

SERVOPRODUCTS COMPANY
34940 LAKELAND BLVD., EASTLAKE, OH 44095

INSTALLATION DRAWING

MODEL 3750

SIZE CODE IDENT NO. DRAWING NO. REV.
B 0800-80987 NB-59618

SCALE 5/8 SHEET DF

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