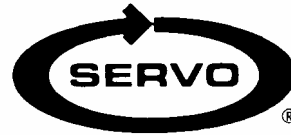


DYNAMO FEED INSTALLATION

Model D1000-4950 Cross Feed

Clousing Kondia



PREPARATION

- Step 1:* Remove the nut, handcrank, dial assembly, and key from the lead screw.
- Step 2:* Remove the bearing retainer from the end bracket and replace with the bearing retainer provided.

POWER FEED INSTALLATION

- Step 1:* Slide the bearing race and adaptor onto the lead screw and secure to the bearing retainer with the 1/4-20 x 1/2" long socket head cap screws. Remove the bearing race.
- Step 2:* Screw the shaft extension onto the lead screw and tighten.
- Step 3:* Using the hole provided as a pilot, drill a 1/8" diameter hole through and pin the shaft extension in place using the 1/8 diameter x 5/8" long roll pin. File smooth.
- Step 4:* Slide the spacer and bearing race onto the lead screw.
- Step 5:* 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, install the 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.

SERVO PRODUCTS COMPANY

Web: www.servoproductsco.com

CALIFORNIA BRANCH

14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

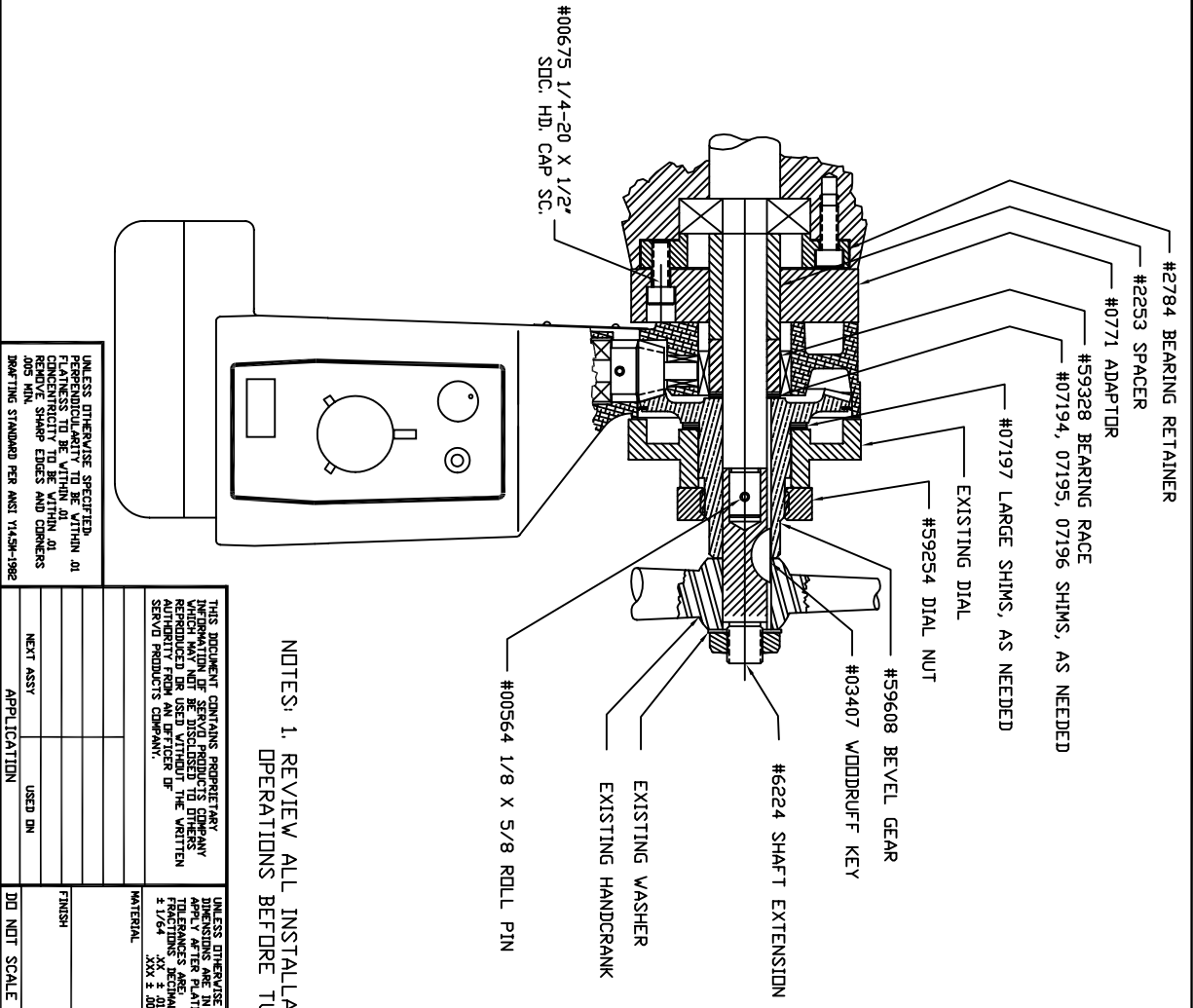
HEADQUARTERS

34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555

REVISION		DATE	DRAWN	CHECKED
EGD	LTR			
DESCRIPTION				




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

UNLESS OTHERWISE SPECIFIED, PERPENDICULARITY TO BE WITHIN .01 INCHES AND SURFACE FINISH TO BE WITHIN .005 RMS UNLESS OTHERWISE SPECIFIED. RAFTING STANDARD PER ANSI Y14.3M-1982

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVO PRODUCTS COMPANY. REPRODUCTION OR USE WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVO PRODUCTS COMPANY.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE FRACTIONS OF INCHES. ANGLES ARE IN DEGREES. FINISH: XXX ± .005

CONTRACT NO.	DATE	APPROVALS	CHECKED
	7/16/09	BRANN BIMA	


SERVO PRODUCTS COMPANY
 3490 LAKELAND BL. EASTLAKE OH 44095 USA
INSTALLATION DRAWING
 MODEL 4950
 SIZE CODE IDENT NO. DRAWING NO. REV.
 B 0800-80994 NB-59625
 SCALE 5/8 SHEET 1 OF 1