

# POWER FEED INSTALLATION

## D1000-9808, 9809 Knee Feeds

### Kent 3VK, 5VK, Webb Champ



#### REFERENCE DRAWINGS ENCLOSED

NB-59611 INSTALLATION DRAWING  
DYNAMO INSTALLATION AND OPERATION MANUAL

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#### PREPARATION

- Step 1:* Unscrew the front ring nut and remove the drive clutch, the dial hub ass'y and keys from the elevating jack shaft. Save the parallel key for installation later.
- Step 2:* Remove the bearing retainer ring, and mount the 59602 adaptor in its place, using the same three screws that held the bearing retainer ring.
- Step 3:* Place the shaft spacer and ext. shaft onto the jack shaft. Be sure the ext. shaft presses against the shaft spacer, and the shaft spacer presses against the elevating jack shaft bearing.
- Step 4:* Slide the power feed onto the extension shaft and bolt it to the adaptor. The feed may need to be swung to the left to get the mounting holes to line up with the 1/4-20 tapped holes in the adaptor. Check that the .866 dia. shoulder of the ext. shaft is flush, plus or minus .03, with the face of the power feed roller bearing. If the shoulder is recessed too much, add to the shaft spacer. If the shoulder protrudes out of the roller bearing too far, reduce the thickness of the shaft spacer.
- Step 5:* Once you have determined the extension shaft is located correctly, pin it to the elevating jack shaft. Using the hole provided as a pilot, drill .201 (#7) diameter through the shaft and pin the extension with the .20 x 3/4 roll pin. File smooth.

#### BEVEL GEAR INSTALLATION

- Step 1:* Use the key you saved before for the bevel gear installation.
- Step 2:* See the DYNAMO D1000Z INSTALLATION & OPERATION MANUAL

#### DIAL AND HANDCRANK INSTALLATION

See the DYNAMO D1000Z INSTALLATION & OPERATION MANUAL

## LIMIT SWITCH INSTALLATION

The installation of the limit switch will be as described in the DYNAMO D1000Z INSTALLATION & OPERATION MANUAL, except the trip rail is a single piece. The limit switch can be mounted on either side of the knee. Since the switch is directional, it will have to be turned, either with the switch box facing the knee or facing away from the knee, to stop the feed travel. **Operate the feed up and down, and press the switch by hand to determine the proper orientation before mounting.**

## OPERATION

See the DYNAMO D1000Z 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

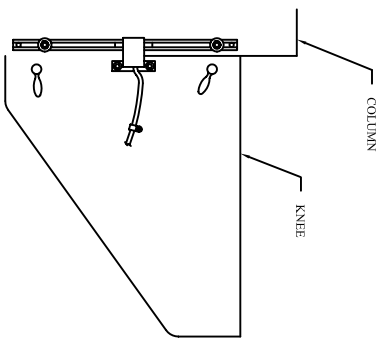
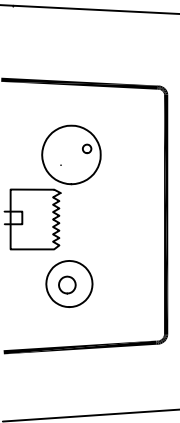
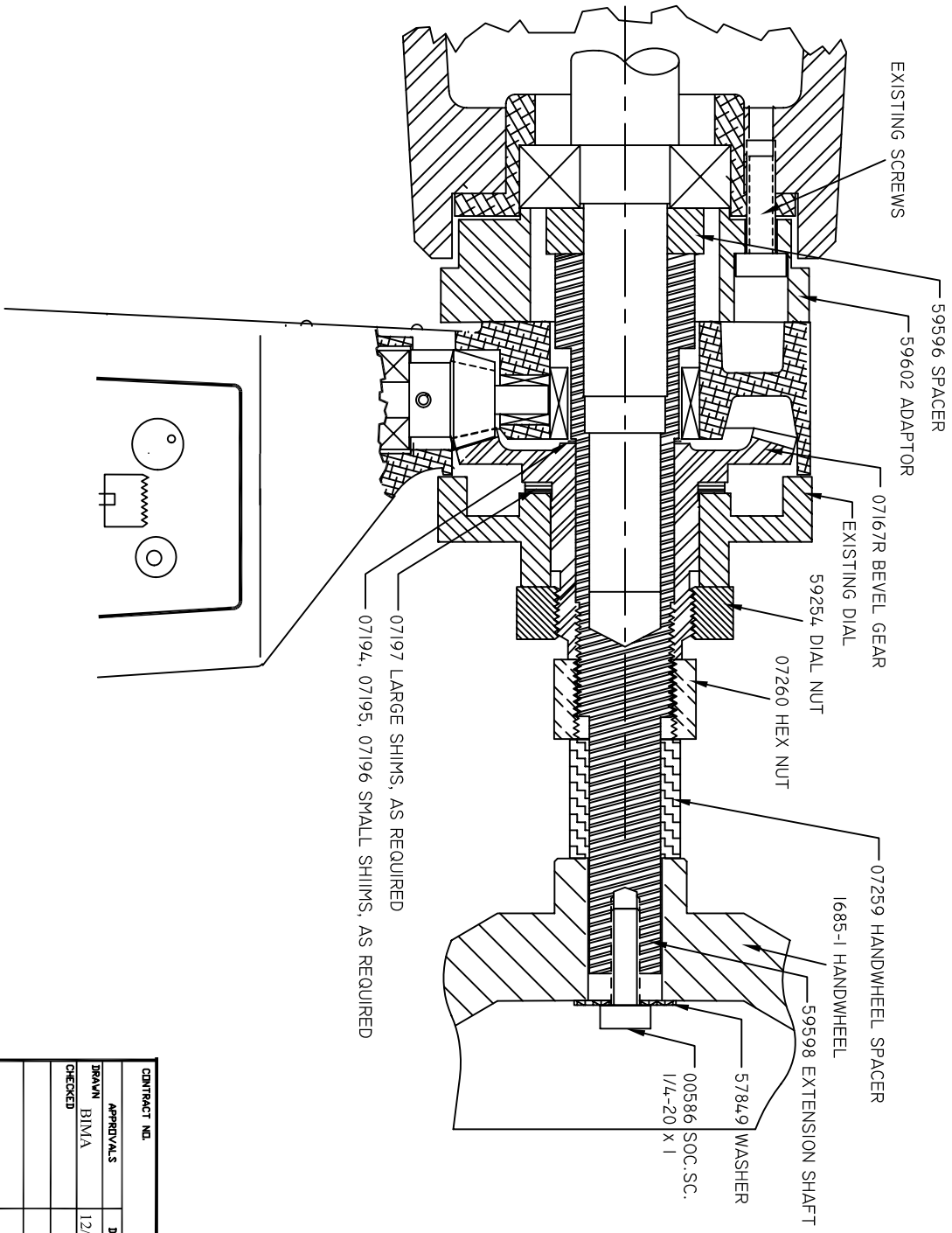
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### HEADQUARTERS

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### FLORIDA BRANCH

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**LIMIT SWITCH INSTALLATION, KNEE**  
 (L/S CAN BE MOUNTED ON EITHER SIDE OF KNEE)

CONTRACT NO.	DATE
APPROVALS	12/04/09
DRAWN B1M/A	
CHECKED	
COMPUTER NO.	

**SERVOD PRODUCTS COMPANY**  
 34940 LAKELAND BL. EASTLAKE OH 44095 USA

**INSTALLATION DRAWING**  
**MODEL D-1000-9808, 9809**

SIZE B CODE IDENT NO. 0800-80980 DRAWING NO. NB-59611 REV.

SCALE SHEET DF