

INSTALLATION INSTRUCTIONS

680HX Handle Extension Kit

for Bridgeport Mill



REFERENCE DRAWINGS ENCLOSED

NA-59551 Handle Extension Kit Installation

➔ **NOTE** The Power Feed unit is sold separately as M-0200-140 or M-0200-150. Reference drawings NA-5444 and NB-0296 are included with the M-0200 installation instructions.

If this kit is included with a new Model 200 or similar power feed, follow the installation instructions for that model. After checking that the feed operates correctly and manually cranks freely, install this kit.

PREPARATION

Step 1: Gather together the following items that you will need to complete this installation.

- a) 3/4" socket wrench
- b) hand drill
- c) 1/8" drill
- d) medium-fine file

Step 2: Move the table to the extreme left.

Step 3: Remove the nut and handle from the right-hand end of the lead screw. Leave the woodruff key which was shared between the bevel gear and the handle in place.

Step 4: Screw the 0333 shaft extension firmly onto the lead screw. Rotate the shaft until the 1/8" hole in the shaft extension is conveniently accessible. Using the hole as a pilot, drill through the shaft and the far side of the extension. Press in 00564 1/8 x 5/8" roll pin. File or stone both ends smooth.

Step 5: Slide the 59550 spacer with the notch aligned over the existing key up against the bevel gear. Add the 1230 spacer, insert the 00614 woodruff key and slide the handle over it. If the handle hub is more than 1.2" thick you may need to cut the 1230 spacer down. Secure the handle with the original 1/2-20 locknut.

Check that the feed still runs quietly and manually cranks freely. If any difficulties are seen, check that the nut on the left end of the table has not loosened, allowing the lead screw to move endwise.

*Please read **WARNINGS** on the following page.*

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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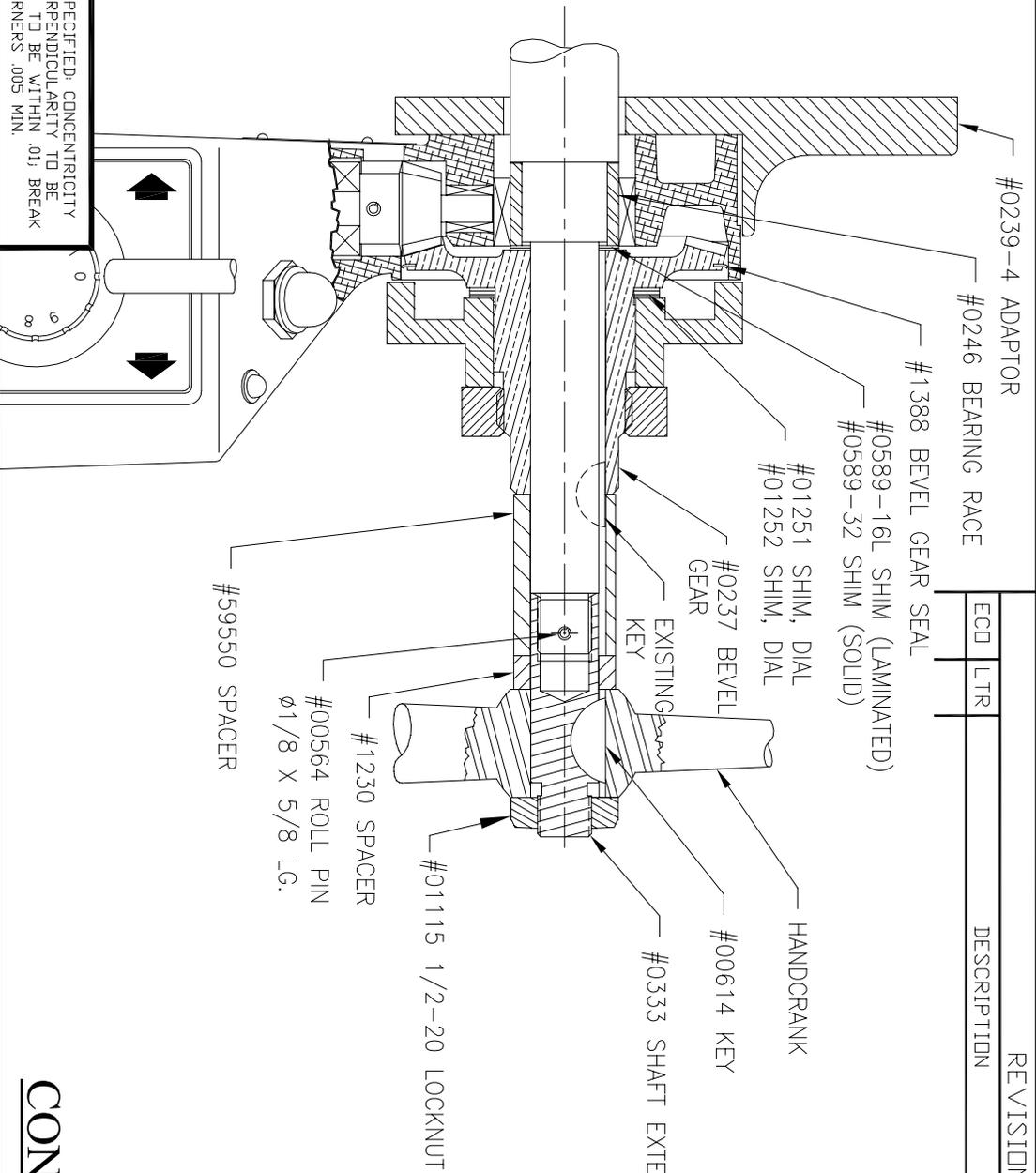
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REVISION					
ECD	LTR	DESCRIPTION	DATE	DRAWN	CHECKED



CONFIDENTIAL

UNLESS OTHERWISE SPECIFIED: CONCENTRICITY TO BE WITHIN .01; PERPENDICULARITY TO BE WITHIN .01; FLATNESS TO BE WITHIN .01; BREAK SHARP EDGES AND CORNERS .005 MIN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & APPLY AFTER PLATING TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± .01 ± 1/2°

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REMOVE SHARP CORNERS .005 R. TYP. DRAFTING STANDARD PER ANSI Y14.5M-1982

MATERIAL NOTED

FINISH

DO NOT SCALE DRAWING

COMPUTER NO. NB59551.dwg

CONTRACT NO. APPROVALS DATE DRAWN B.G.W. 7/15/08 CHECKED R.R.A. 7/15/08

SIZE CODE IDENT NO. DRAWING NO. NA-59551

SCALE 5/8 SHEET 1 OF 1

SERVOD PRODUCTS COMPANY
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HANDLE EXTENSION KIT

REVISION