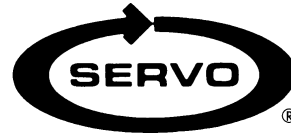


# POWER FEED INSTALLATION

## Model M-9518 Cross Feed

### Alliant RT2-50



#### REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-57536	Power Feed Installation
ND-6293	Type 150 Servo Power Feed
ND-6292	Type 140 Servo Power Feed
0800-80001	Servo Power Feed Operation

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#### PREPARATION

- Step 1:* Remove the nut, key, handle, and dial assembly from the lead screw.
- Step 2:* Remove the shroud from the power feed.
- Step 3:* Slide the spacer and bearing race onto the lead screw.
- Step 4:* Slide the power feed over the bearing race and square to the mill.
- Step 5:* Transfer the mounting holes from the power feed to the mill.
- Step 6:* Remove the power feed, spacer, and bearing race from the mill.
- Step 7:* Drill and tap 1/4-20 x 3/8" deep into the bearing housing.

#### 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 shaft and pin the 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:* Place the shroud onto the power feed and slide the unit onto the lead screw. Secure using 1/4-20 x 1-1/4" long socket head cap screws.

#### BEVEL GEAR INSTALLATION

- Step 1:* Follow drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

#### DIAL AND HANDCRANK 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, place the 5 mm key in the shaft extension, and slide the handcrank #57903 in place. Secure with the 1/2-20 lock nut.

## LIMIT SWITCH INSTALLATION

*Step 1:* See the limit switch installation on drawing NB-57536.

## OPERATION

See separate *Servo Power Feed Operation* sheet. Plug the unit into a source of 120 volt, 50 or 60 cycle power.

### 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!

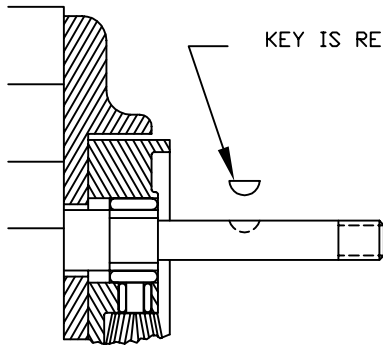
Prevent contact during fast traverses.

## SERVO PRODUCTS COMPANY

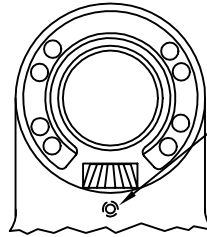
433 North Fair Oaks Avenue, Pasadena, CA 91103 USA  
Phone: 800.521.7359 or 626.796.2460 Fax: 626.796.3845

Web: [www.servoproductsco.com](http://www.servoproductsco.com)

Call for the location of our regional Service Centers.

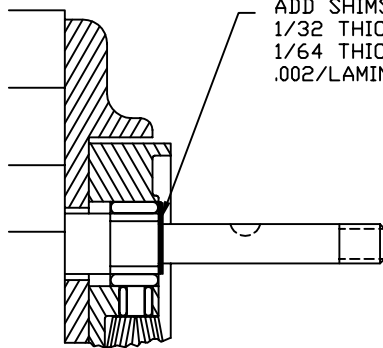


KEY IS REMOVED DURING SHIMMING

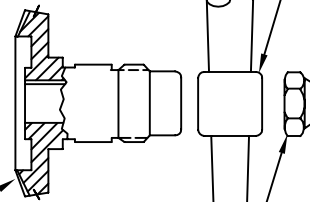


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1  
PREPARATION



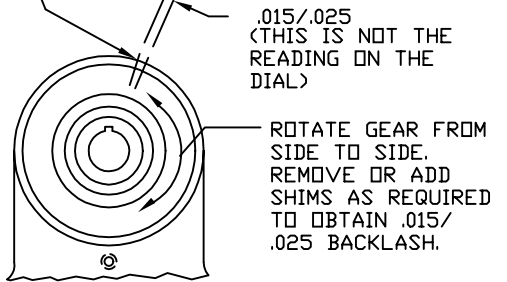
ADD SHIMS PROVIDED  
1/32 THICK ARE SOLID  
1/64 THICK ARE LAMINATED  
.002/LAMINATION



PUSH BEVEL GEAR AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.



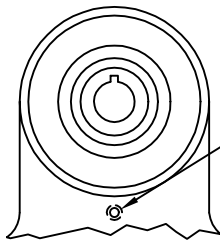
.015/.025  
(THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN .015/.025 BACKLASH.

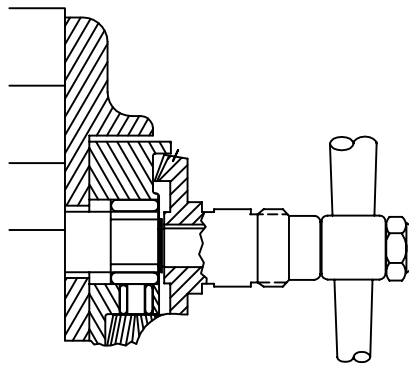
TIGHTEN NUT.

STEP 2  
SHIMMING BEVEL GEAR

**CAUTION:** IF BACKLASH IS NOT PROPERLY SET BEFORE TURNING UNIT ON, BEVEL GEAR MAY BE DESTROYED.



LOOSEN SETSCREW

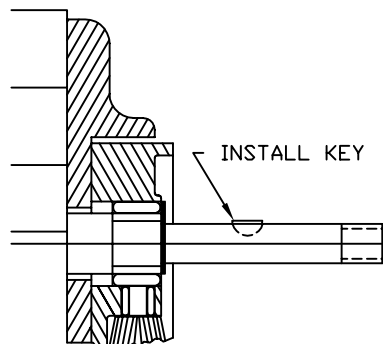


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.

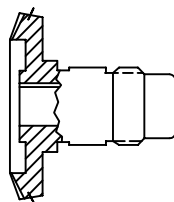


CONTROL HANDLE @ NEUTRAL POSITION

STEP 3  
DOUBLE CHECK OF SHIMMING



INSTALL KEY



SEAL

REMOVE GEAR, PACK WITH GREASE. (DO NOT USE SILICONE TYPE GREASE) REPLACE GEAR. (DO NOT LOSE ANY SHIMS)

PICTURES IN THIS DRAWING ARE FOR REFERENCE ONLY. SEE INSTALLATION DRAWING OF CORRESPONDING MODEL FOR EXACT PARTS CONFIGURATION.

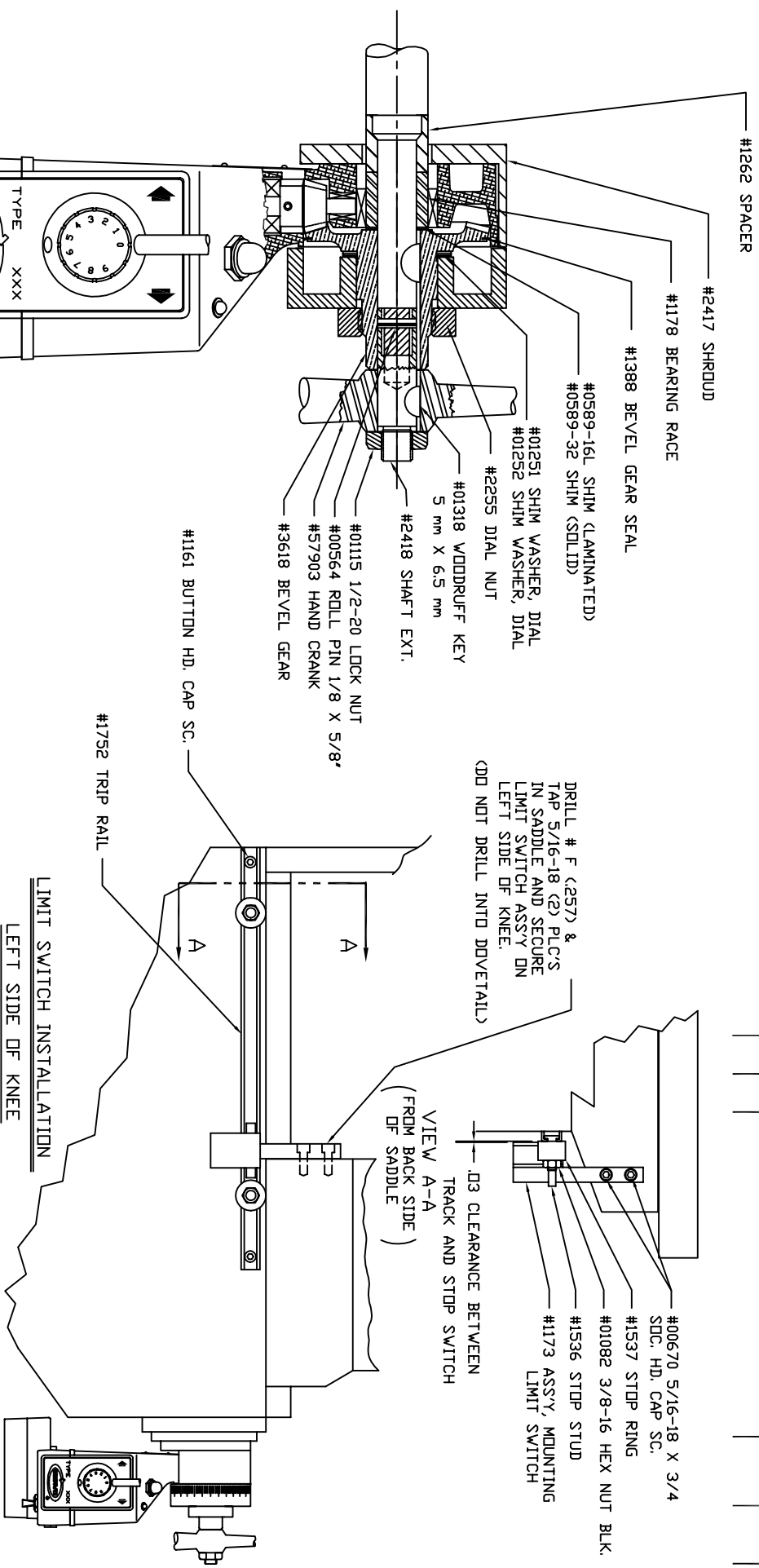
SERVO PRODUCTS COMPANY

BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4  
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS: DECIMALS ± 1/64 .XX ± .005 ANGLES ± 1/2° MATERIAL NOTED FINISH NOTED

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CONTRACT NO.	APPROVALS	DATE
	DRAWN G. BUINN	6/29/95
CHECKED		

COMPUTER NO.	SCALE
N57536ADJVG	5/8

**SERVOD PRODUCTS COMPANY**  
 433 N. FAIR BANKS AVE., PASADENA, CALIFORNIA 91039  
**INSTALLATION DRAWING**  
**ALLIANT RT2-50**  
**MODEL 9518**  
 SIZE CODE IDENT. NO. DRAWING NO. REV.  
 B 0800-80521 NB-57536 A  
 SCALE 5/8 SHEET OF

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