



TURBO DRIVE INSTALLATION

MODEL 9822T KNEE FEED

Servo SV 50

- ➔ **NOTE** This Turbo Drive Knee Feed is configured for mounting the feed on the front of the knee with the keypad facing left. The lead screw pitch is 5 turns per inch left hand with 2 to 1 reducing bevel gear set from the jack shaft to the lead screw (jack screw). See **CAUTION** below before changing anything!

CAUTION

The Turbo Drive power cable should be left **unplugged** until the drive is properly installed on the lead screw.

See the **Operation** manual to reverse the direction of travel or to change the lead screw pitch default. Turn **off** the Turbo Drive and **remove** the power plug from the wall before you attempt to change any jumpers or reverse the top housing.

WARNINGS

DO NOT install and operate this power feed without the 8" safety handwheel Servo #1685-1 for the knee feed. This is required to prevent injury.

Check handwheel clearances before operation.

Clearances between the surfaces of the handwheel and the non-moving parts of the equipment on which the handwheel is installed must be at least one-fourth inch (1/4") to prevent injury.

Do not operate without proper clearance!

Prevent contact during fast traverses.

WARRANTY CAUTION

There are **NO** user-serviceable parts inside the center or bottom housings. Removal of the motor, keyboard, or bottom housing screws **voids** the warranty.

REFERENCE DRAWINGS ENCLOSED

NA-58496	Bevel Gear Installation
NB-58627	Turbo Drive Installation
0800-80678	Turbo Drive Operation manual

PREPARATION

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

- a) lathe
- b) 3/8" electric hand drill
- c) #7 drill, 3/16" drill, 7/16" drill, #H drill

- d) 1/4-20 tap
- e) 9/32" diameter transfer punch
- f) flat file
- g) 3/4" socket wrench
- h) set of inch hex wrenches
- i) grease
- j) clean shop rag

Step 2: Clean the power feed mounting area completely.

Step 3: Remove the drive clutch from the elevating jack shaft.

Step 4: Remove the dial nut, dial, and dial carrier. (Turn the dial carrier counterclockwise to remove.) Keep the dial for reuse later.

Step 5: Slip bearing race #6901 onto the jack shaft as shown. Slide the Turbo Drive over the bearing race and locate against front of the knee.

Step 6: Using a 9/32" diameter transfer punch, transfer two mounting holes from the feed to the bearing retainer. Remove the unit and the bearing race just installed. Then drill .201 diameter (#7 drill) through the bearing retainer and bearing housing and 1" into the knee casting.

Step 7: Remove the bearing retainer.

Step 8: Pull jack shaft out of knee. Hold inboard end up while removing to avoid damage to the pinion gear.

Step 9: Open up the drilled holes on the bearing retainer and the bearing housing to .266" diameter clearance holes. Tap 1/4-20 UNC x 1/2" deep into the knee casting.

Step 10: Press the bearing off the jack shaft.

Step 11: Drill and ream the end of the jack shaft .4375" diameter by 13/16" deep. The .4375" diameter must be concentric to the shaft O.D. within .002" T.I.R. Chamfer 1/32" x 1/2" diameter. **For best results, machining should be done in a lathe.**

Step 12: Place the shaft extension #1619 into the end of the jack shaft. Finish drill 3/16" diameter hole through threaded joint and pin with the 3/16" diameter x 5/8" long roll pin. File smooth.

Step 13: Reassemble and replace the jack shaft in the machine.

Step 14: Replace the bearing retainer.

TURBO DRIVE INSTALLATION

Step 1: Slide the bearing race back onto the jack shaft.

Step 2: Slide the Turbo Drive onto the bearing race and push against the knee. Secure with two 1/4-20 x 2" long socket head cap screws.

IF: If the bearing race is not flush with the needle bearing in the unit within $\pm.05$ ", then either shim behind the race or machine the spacer to correctly locate the race.

BEVEL GEAR INSTALLATION

Step 1: Follow the drawing NA-58496 for installation of the bevel gear. Adjust for proper gear backlash.

DIAL AND HANDWHEEL INSTALLATION

Step 1: After getting the proper gear 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. Three plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.

Step 2: In the following sequence, install the key, dial and dial nut #2255. Slide the handwheel #1685-1 in place and tighten with 1/2-20 locknut #01115.

TURBO DRIVE OPERATION

See the separate **Servo Turbo Drive Operation** manual for complete operating instructions. Plug the unit into a properly grounded three-wire outlet supplying 110 volt single phase 50/60 Hz 6 amp power. Turn the control switch ON and follow the instructions in the manual or on the **Quick Reference** sheet for setting limits.

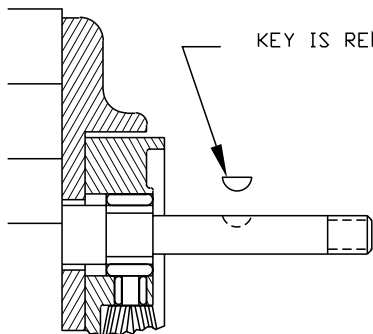
SERVO PRODUCTS COMPANY

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

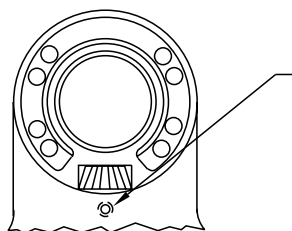
Web: www.servoproductsco.com

If service is required, call Servo Products Company.

DO NOT PLUG IN POWER UNTIL ALL STEPS ARE COMPLETED.

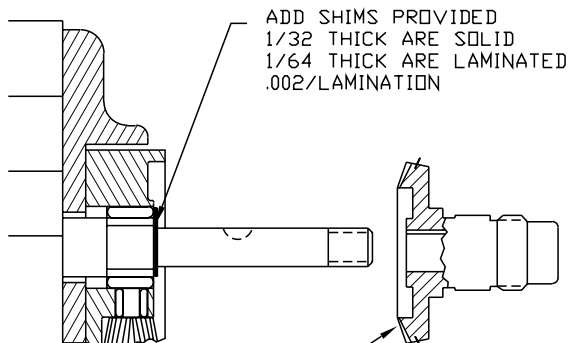


KEY IS REMOVED DURING SHIMMING

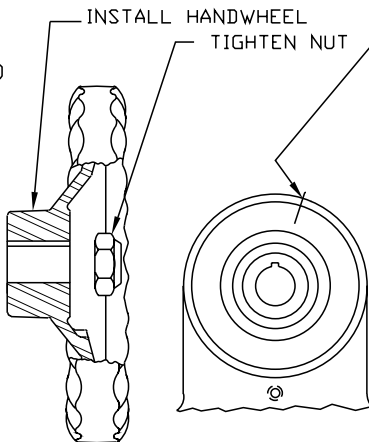


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)
(TIGHTEN UPPER ONE ONLY)

STEP 1
PREPARATION



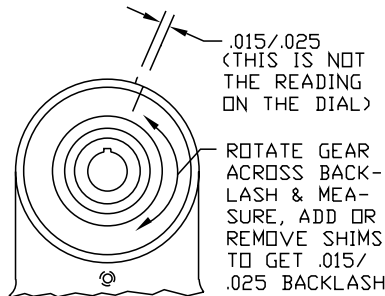
ADD SHIMS PROVIDED
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION



INSTALL HANDWHEEL

TIGHTEN NUT

SCRIBE ACROSS GEAR & HOUSING WHILE PUSHING GEAR AGAINST ONE SIDE OF THE BACKLASH



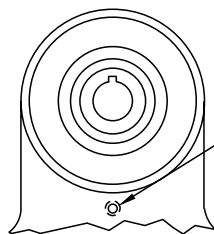
.015/.025
(THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR ACROSS BACKLASH & MEASURE, ADD OR REMOVE SHIMS TO GET .015/.025 BACKLASH

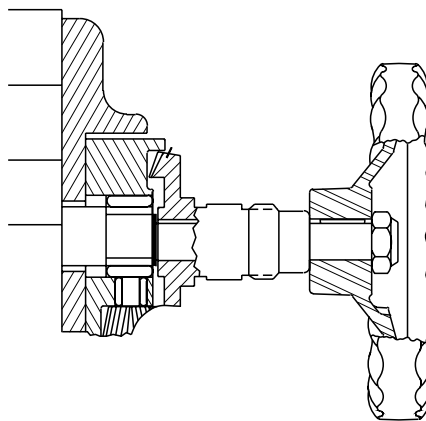
PUSH BEVEL GEAR AGAINST SHIMS.

STEP 2
SHIMMING BEVEL GEAR

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

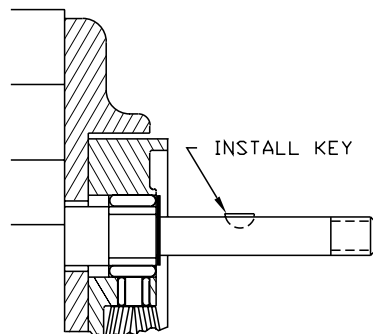


LOOSEN SETSCREW

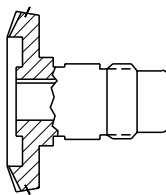


MANUALLY TURN HANDWHEEL. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED OR REMOVED, WHEN RE-SHIMMING, REPEAT STEPS 1 AND 2.

STEP 3
DOUBLE CHECK OF SHIMMING



INSTALL KEY



SEAL

STEP 4
LUBRICATION

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.

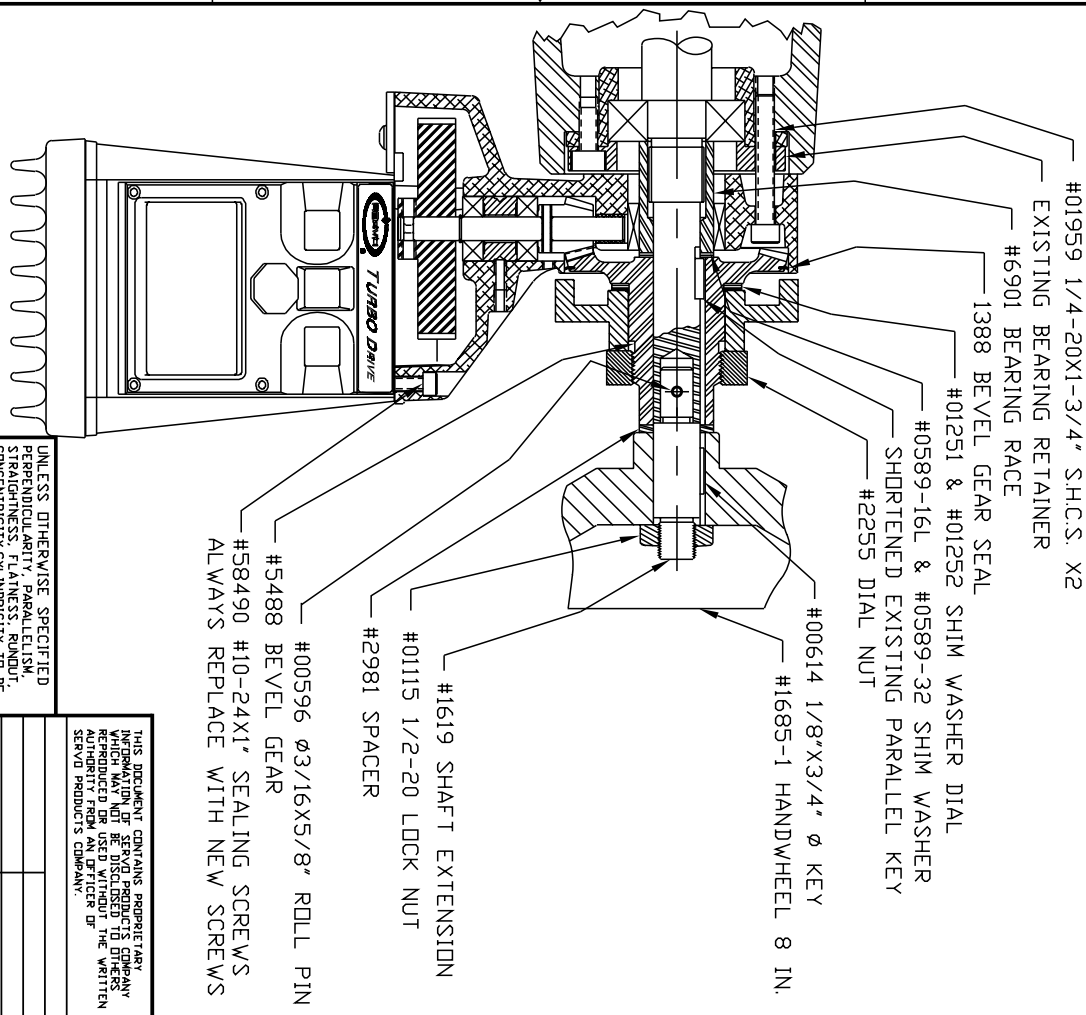


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BEVEL GEAR INSTALLATION

NA-58496

REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				



NOTE:
 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATION INSTRUCTION BEFORE TURNING ON SERVO POWER FEED.
 2. REMOVAL OF MOTOR, KEY PAD OR BOTTOM HOUSING VOIDS WARRANTY.

UNLESS OTHERWISE SPECIFIED
 SERVO PRODUCTS COMPANY
 DIMENSIONS ARE IN INCHES &
 TOLERANCES ARE AS FOLLOWS
 FRACTIONS ANGLES
 ± 1/64 ± .015 ± 1/2°
 DECIMALS ± .015
 HOLE DRILLS ± .015
 UNLESS OTHERWISE SPECIFIED
 SURFACES ARE TO BE FINISHED
 WITHIN 0.005 IN. UNLESS
 OTHERWISE SPECIFIED
 SURFACE ROUGHNESS WITHIN 125
 REMOVE SHARP CORNERS AND
 EDGES .005 MIN
 DRAFTING STANDARD PER ANSI Y14.5M-1982

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 WHICH MAY NOT BE DISCLOSED TO OTHERS
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 PERMISSION FROM SERVO PRODUCTS COMPANY.

APPLICATOR	USED ON
NEXT ASSY	

MATERIAL	FINISH	DID NOT SCALE DRAWING

CONTRACT NO.	APPROVALS	DATE
	T. KU	01/08/99

SERVO PRODUCTS COMPANY
 433 N. FAIR DMES AVE., PASADENA CALIFORNIA 91103
INSTALLATION DRAWING
 MODEL 9822T
 SERVO SV50
 SIZE CODE IDENT NO. DRAWING NO.
 B 0800-80744 NB-58627
 SCALE 5/8 SHEET OF

