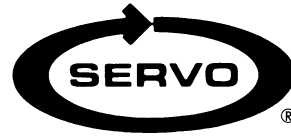


POWER FEED INSTALLATION

Model D1000-4350 Cross Feed



PREPARATION

- Step 1:* Remove the nut, handcrank, dial, dial hub, and key from the lead screw.
- Step 2:* Slide the 59603 bearing race onto the shaft.
- Step 3:* Slide the 0771 adaptor onto the lead screw and over the bearing race.
- Step 4:* Transfer the mounting holes from the adaptor to the bearing housing. Drill and tap 1/4-20 by 3/4" deep. (Avoid contaminating the bearing.)
- Step 5:* Remove and clean all parts thoroughly and lubricate with grease.
- Step 6:* Slide the 59603 bearing race onto the lead screw. Then slide the 0771 adaptor over the race and secure to the bearing housing with the 1/4-20 by 1.0" long socket head cap screws.
- Step 7:* Remove the bearing race.

POWER FEED INSTALLATION

- Step 1:* Screw the 07175 shaft extension onto the lead screw and tighten.
- Step 2:* Using the hole provided as a pilot, drill 1/8" diameter through the lead screw and pin the shaft extension in place using the 1/8 diameter x 5/8" long roll pin. File smooth.
- Step 3:* Slide the 6875 spacer onto the lead screw, then the 59603 bearing race.
- Step 4:* Secure the power feed to the adaptor using the 1/4-20 x 1" long socket head cap screws.

BEVEL GEAR INSTALLATION

- Step 1:* Check that the bearing race is about flush with the needle bearing. If it is recessed, add a shim washer or spacer between the 6875 spacer and the 59603 bearing race. If the race extends out more than .06 in., you may not be able to get the bevel gear backlash small enough. Reduce the length of the 6875 spacer.

- Step 2:* Refer to Fig. A, page 6 of the *INSTALLATION AND OPERATION MANUAL D-1000Y*. 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. Add, remove or replace shims as needed to obtain the .080/.085 in. (2.0 / 2.16 mm) measurement. Install the hand crank and nut. Check to see the measurement 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 direction backlash is too large. If rough engagement is heard or felt in BOTH directions you need additional shims.

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: Put on the dial locking nut.

Step 3: Install the key in the shaft extension.

Step 4: Slide the hand crank onto the end of the shaft extension and tighten with the 1/2-20 nut.

LIMIT SWITCH INSTALLATION

Refer to the *INSTALLATION AND OPERATION MANUAL, MODEL D-1000Y*

OPERATION

Refer to the *INSTALLATION AND OPERATION MANUAL, MODEL D-1000Y*

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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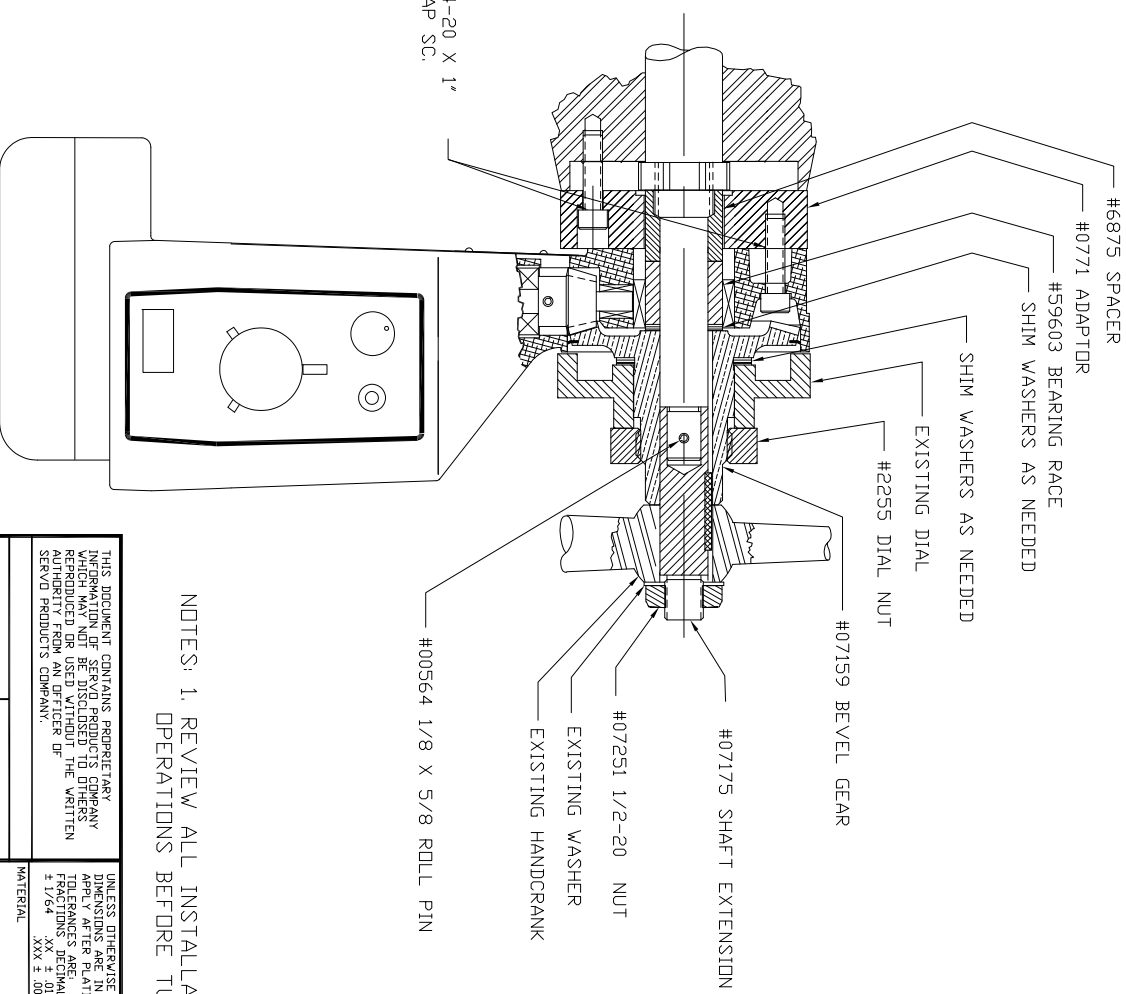
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REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				



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

UNLESS OTHERWISE SPECIFIED, PERPENDICULARITY TO BE WITHIN .01 FLATNESS TO BE WITHIN .01 RADIUS TO BE WITHIN .01 RADIUS SHARP EDGES AND CORNERS .005 MIN. DRAFTING STANDARD PER ANSI Y14.5M-1998

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CONTRACT NO.	APPROVALS	DATE
	DRAWN BY	4/26/10
CHECKED		
APPLICATION	USED ON	
NEXT ASSY		

SERVO PRODUCTS COMPANY
 3490 LAKELAND BL., EASTLAKE, OH 44095
INSTALLATION DRAWING
 MODEL D1000-4350
 SIZE B CODE 0800-81016 IDENT NO. 0800-81016 DRAWING NO. NB-59647 REV. 1
 SCALE 5/8 SHEET 1 OF 1