

# DYNAMO FEED INSTALLATION

## Model D1000-4900 Table Feed

### Clousing Kondia



#### PREPARATION

- Step 1:* Remove the nut, hand crank, dial assembly, and key from the right hand end of the table.
- Step 2:* Remove the bearing retainer from the end bracket and replace with the bearing retainer provided.

#### POWER FEED INSTALLATION

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

#### BEVEL GEAR INSTALLATION

- Step 1:* 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 2:* 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. Four shim washers are provided for this. Shim as required.
- Step 2:* In the following sequence, put on the dial locking nut and slide the handle in place. Add the 1/2-20 lock nut and tighten.

#### LIMIT SWITCH INSTALLATION

- Step 1:* Remove the standard table stop pieces and install the table stop pieces furnished. Put the standard stops back in a position to prevent feed stops from being set beyond extreme table travel.

*Step 2:* Remove the T-shaped table stop piece and install limit switch using existing screws. Spacers may be required to space limit switch from table.

□ **NOTE** For proper operation, the electrical limit switch should be engaged .4 inch before the mechanical stop to allow for coasting of the table.

*Step 4:* Put the cable clamp on the cable and secure using the right-hand chip scraper screw.

## OPERATION

See DYNAMO 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

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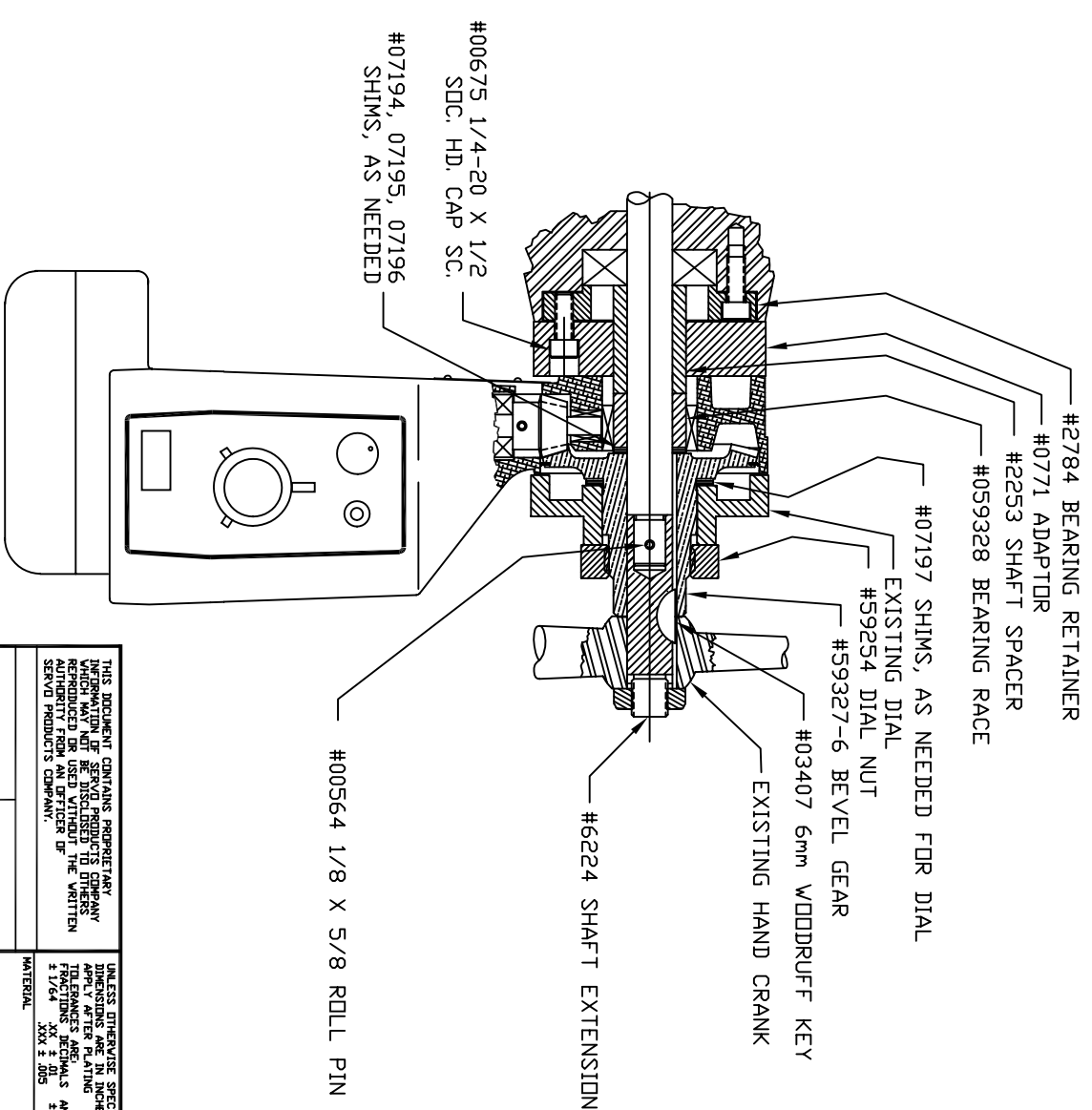
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UNLESS OTHERWISE SPECIFIED, FINISHES TO BE WITHIN .01 FLATNESS TO BE WITHIN .01 CONCENTRICITY TO BE WITHIN .01 REMOVE SHARP EDGES AND CORNERS .005 MIN. DIMETING STANDARD PER ANSI Y14.5M-1992

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	BIMBA	7/15/09	
APPLICATION	USED IN	DID NOT SCALE DRAWING	COMPUTER NO.
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**SERVOPRODUCTS COMPANY**  
 3490 LAKELAND BL. EASTLAKE OH 44095 USA  
**INSTALLATION DRAWING**  
 MODEL 4900

SIZE	CODE IDENT NO.	DRAWING NO.	SHEET	OF
B	0800-80993	NB-59624	1	1
SCALE	5/8			