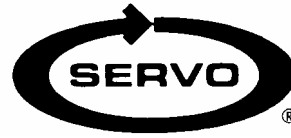


# DYNAMO FEED INSTALLATION

## D1000-5050 Cross Feed

### Acra 10x50, 10x54



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#### PREPARATION

- Step 1:* Move the saddle to the front of the mill.
- Step 2:* Remove the nut, handle, dial assembly, and key from the lead screw. Save the key for installation later.
- Step 3:* Screw the shaft extension onto the lead screw.
- Step 4:* Slide the bevel gear onto the lead screw to ensure proper fit. Then remove the bevel gear.
- Step 5:* Using the hole provided as a pilot, drill a 3/16" diameter hole through the lead screw. Pin the shaft extension to the lead screw with the 3/16" diameter x 5/8" long roll pin. File smooth.

#### POWER FEED INSTALLATION

- Step 1:* Slide the adaptor onto the lead screw (counterbore facing outside).
- Step 2:* Slide the bearing race onto the lead screw and into the adaptor for proper alignment of the adaptor.
- Step 3:* Using a transfer punch, transfer the three mounting holes onto the bearing retainer and tap 1/4-20 through.
- Step 4:* Secure the adaptor to the bearing retainer using three 1/4-20 x 1" socket head cap screws.
- Step 5:* Remove the bearing race.
- Step 6:* Slide the two spacers onto the lead screw followed by the bearing race, as shown on installation drawing NB-6296.
- Step 7:* Slide the power feed onto the bearing race and secure to the adaptor using two 1/4-20 x 1" long socket head cap screws.

## BEVEL GEAR INSTALLATION

*Step 1:* Turn the leadscrew CW to ensure the leadscrew is extended out fully and shouldered against the bearing

*Step 2:* 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. of the INSTALLATION & OPERATION MANUAL. Add, remove or replace shims to obtain the .080/.085 in. (2.0 / 2.16 mm) dimension. Install the spacer, handcrank, and nut. Check that the dimension 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, the backlash is too large. Reduce the thickness of the shims. If rough engagement is heard or felt in BOTH directions you need additional shims.

## DIAL AND HANDWHEEL 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:* Slide the spacer and handcrank onto the end of the shaft extension and tighten with the 1/2-20 lock nut.

## LIMIT SWITCH INSTALLATION

Refer to the D-1000Y INSTALLATION & OPERATION MANUAL

## OPERATION

See 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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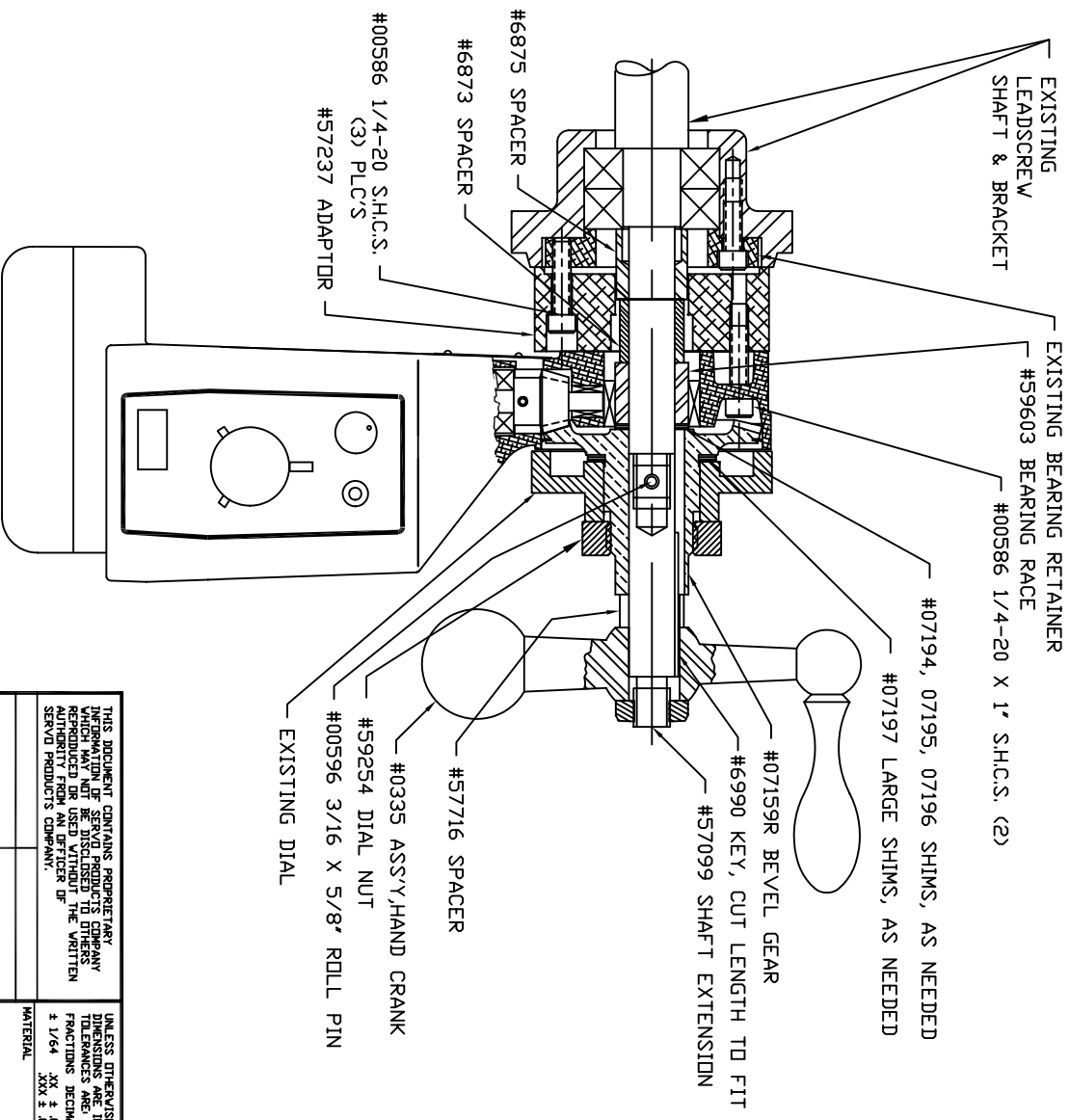
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REVISION		DATE	APPROVED
ECD	LTR		
DESCRIPTION			



UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± .005 ± .1/2

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CONTRACT NO.	APPROVALS	DATE
	BIMA	7/16/09
	CHECKED	

**SERVOD PRODUCTS COMPANY**  
 34940 LAKELAND BLVD., EASTLAK, OHIO 44903

**INSTALLATION DRAWING**  
 MODEL 5050

SIZE: B CODE IDENT. NO.: 0800-80996 DRAWING NO.: NB-59627 REV: B

SCALE: 5/8 SHEET: 1 OF 1

UNLESS OTHERWISE SPECIFIED, FLATNESS TO BE WITHIN .01 CONCENTRICITY TO BE WITHIN .01 REMOVE SHARP EDGES AND CORNERS .005 MIN.

APPLICATION USED IN NEXT ASSY

DID NOT SCALE DRAWING

APPLICATION