

DYNAMO FEED INSTALLATION

Model D-1000-9108 Table Feed

Kent 3VK, 5VK, Acer 3VS, 3VK
and others



PREPARATION

- Step 1:* Move the table to the extreme left.
- Step 2:* Remove the nut, handle, dial assembly, and key from the lead screw. Save the key for installation later.
- Step 3:* Remove the bearing retainer. Save the screws for installation later.
- Step 4:* Screw the shaft extension onto the lead screw.
- Step 5:* Slide the bevel gear onto the lead screw to ensure proper fit. Then remove the bevel gear.
- Step 6:* Drill a 1/8" diameter hole through the shaft using the hole provided in the shaft extension as a pilot. Pin the shaft extension to the lead screw using the 1/8 diameter x 5/8" long roll pin. File smooth.

POWER FEED INSTALLATION

- Step 1:* Using the existing screws, secure the bearing retainer provided.
- Step 2:* Slide the shaft spacer and bearing race onto the lead screw.
- Step 3:* Slide the power feed onto the bearing race and secure to the bearing retainer using the provided 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. Reduce shim thickness. If rough engagement is heard or felt in BOTH directions you need additional shims.
- Step 3.* After obtaining proper shimming, remove the bevel gear, install the saved 3 mm key, replace the bevel gear.

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 3 mm key provided in the shaft extension.

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

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 bracket and install the limit switch using the existing screws. A spacer may be required to space the limit switch from the 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. The T-stops are often not symmetrical and may need to be ground to obtain proper operation.*

Step 3: Put the cable clamp on the cable and secure using the right-hand chip scraper screw.

OPERATION

See DYNAMO D-1000X INSTALLATION AND 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.

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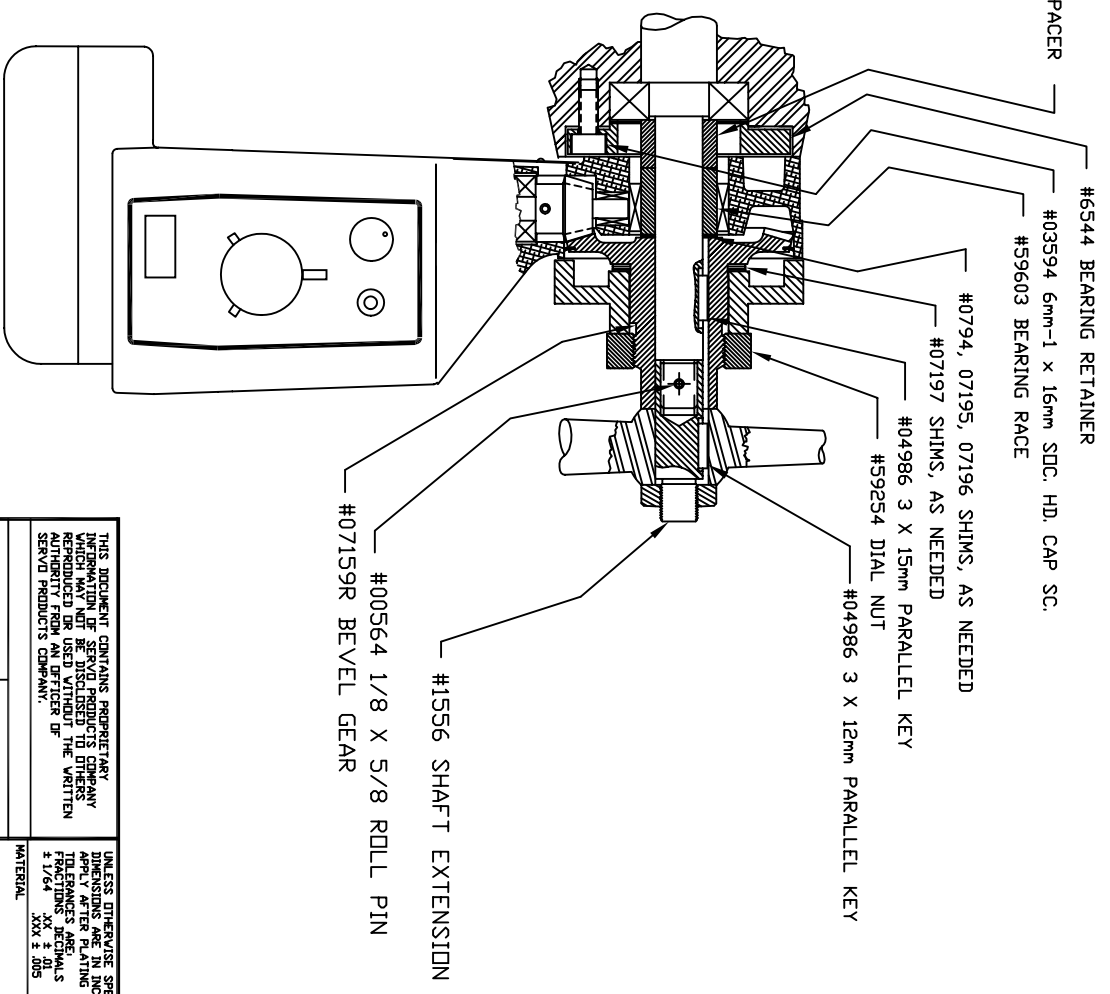
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REVISION		DATE	DRAWN	CHECKED
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UNLESS OTHERWISE SPECIFIED, FINISHES TO BE WITHIN 0.1 FLATNESS TO BE WITHIN 0.1 CONCENTRICITY TO BE WITHIN 0.1 REMOVE SHARP EDGES AND CORNERS 0.05 MIN. DIMETING STANDARD PER ANSI Y14.5M-1992

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NOTED		BIMBA	07/20/09
FINISH NONE	DID NOT SCALE DRAWING		
NEXT ASSY	USED IN	COMPUTER NO.	


SERVO PRODUCTS COMPANY
 34940 LABELAND BLVD, EASTLAKE, OH 44095
INSTALLATION DRAWING,
MODEL D1000-9108

SIZE	CODE IDENT NO.	DRAWING NO.
B	0800-80999	NB-59630
SCALE	5/8	SHEET
		DF

