

# POWER FEED INSTALLATION

## Model D1000-9130 Table Feed

### Clausing Kalamazoo



#### 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:* Slide shaft spacer #0859 and bearing race #59328 onto the lead screw.
- Step 4:* Slide the power feed over the bearing race. Select and transfer three mounting holes onto existing bearing retainer or use supplied bearing retainer #6544.
- Step 5:* If using existing bearing retainer, remove to drill and tap 1/4-20 through and then reinstall otherwise use supplied #6544 bearing retainer.
- Step 6:* Screw the shaft extension onto the lead screw.
- Step 7:* Slide the bevel gear onto the lead screw to ensure proper fit. Then remove the bevel gear.
- Step 8:* 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:* 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. ***Be sure the power feed is installed square with the shaft.***

#### 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 0859 spacer and the 59328 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 0859 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. 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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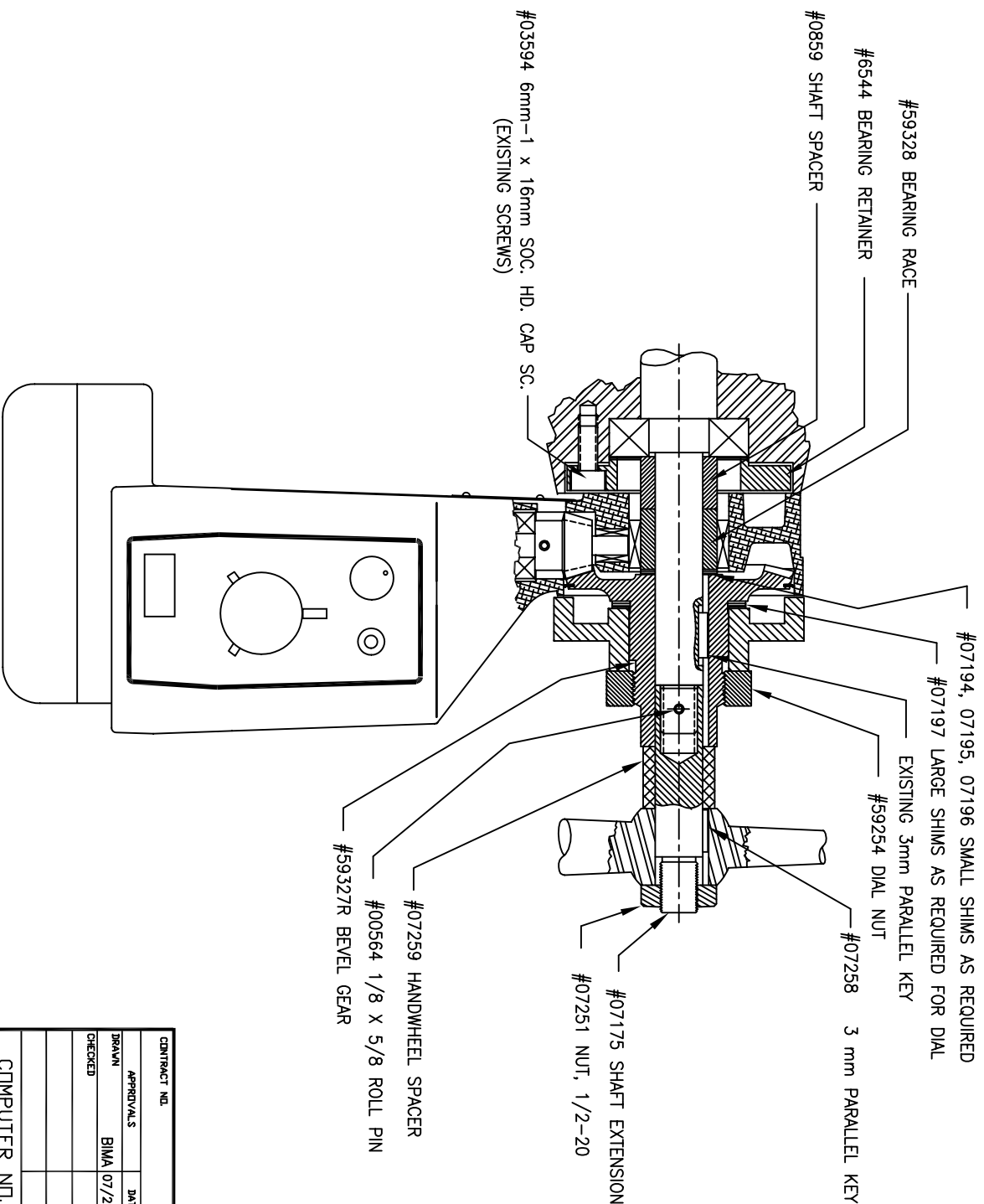
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CONTRACT NO.		DATE	
APPROVALS		BIMA 07/22/10	
DRAWN		CHECKED	
COMPUTER NO.		NB59648.dwg	


**SERVO PRODUCTS COMPANY**  
 34940 LAKELAND BLVD, EASTLAKE, OHIO 44095

**INSTALLATION DRAWING,**  
**MODEL D1000-9130**  
**KALAMAZOO 2YS, 3YS, 4YSQ**

SIZE	CODE IDENT NO.	DRAWING NO.	REV.
B	0800-81017	NB-59648	

SCALE: B  
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