

DYNAMO FEED INSTALLATION

D1000-9508 Cross Feed

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



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:* 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:* Using the hole provided as a pilot, drill 1/8" diameter through the lead screw. Pin the shaft extension to the lead screw with 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 to the bearing housing.
- Step 2:* Slide the adaptor onto the lead screw (counterbore facing outside).
- Step 3:* Slide the bearing race onto the lead screw and into the adaptor for proper alignment of the adaptor.
- Step 4:* Secure the adaptor to the bearing retainer using three 1/4-20 x 1" long socket head cap screws.
- Step 5:* Remove the bearing race.
- Step 6:* Slide the spacer and bearing race onto the lead crew.
- 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 :* Use the 3 mm parallel key you saved before for the bevel gear installation.
- Step 2.* Turn the leadscrew CW to ensure the leadscrew is extended out fully and shouldered against the bearing

Step 3: 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 4: 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. Slide the 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

Web: www.servoproductsco.com

CALIFORNIA BRANCH

14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

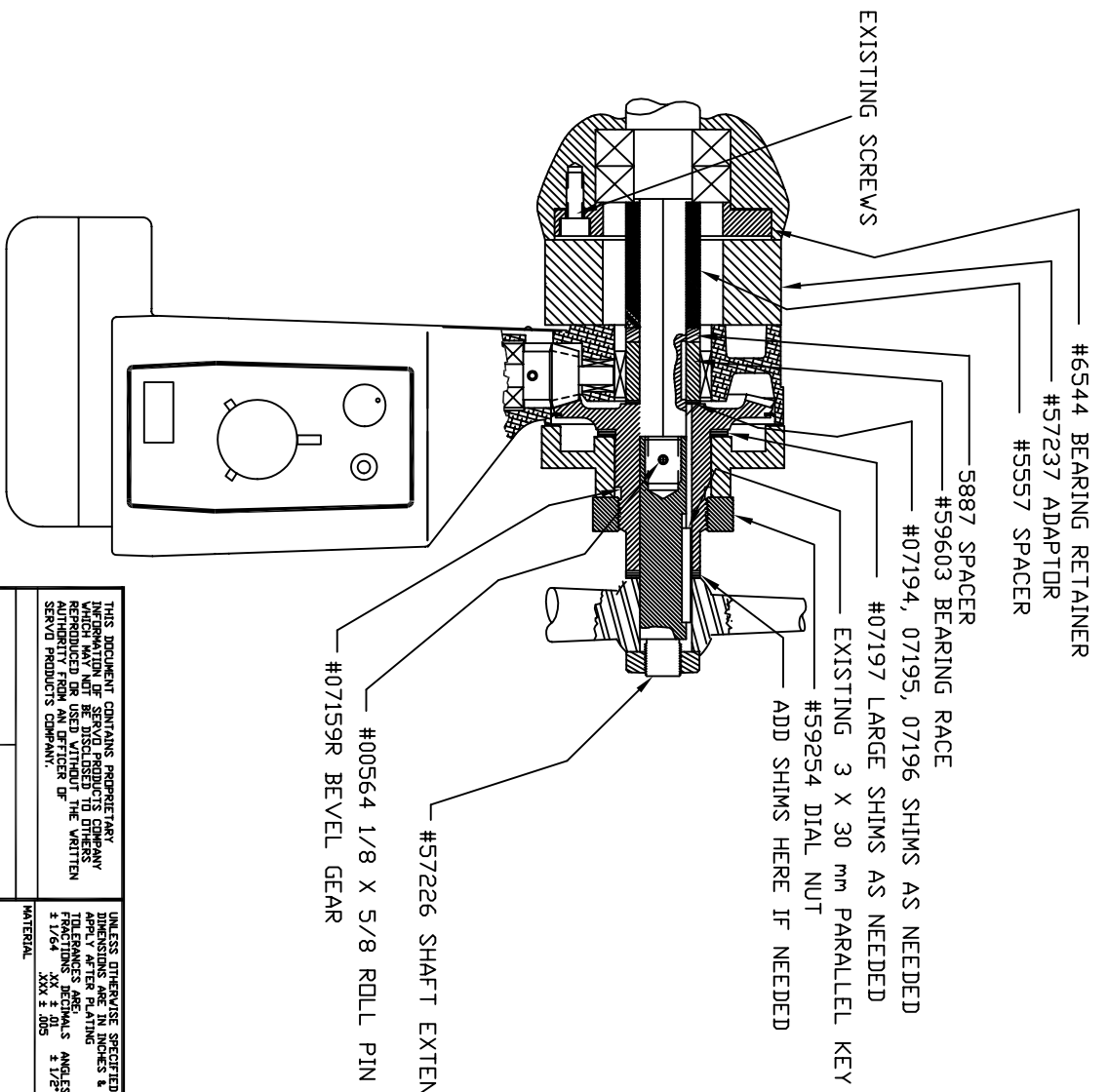
HEADQUARTERS

34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555

REVISION		DATE	DRAWN	CHECKED
ECD	LTR			




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. DRAWING STANDARD PER ANSI Y14.3M-1992

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVOD PRODUCTS COMPANY WHICH MAY NOT BE DISCLOSED TO OTHERS WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVOD PRODUCTS COMPANY.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE IN THE FOLLOWING FRACTIONS: DECIMALS ± 1/64 ANGLES ± 1/2° MATERIAL NOTED FINISH NONE

CONTRACT NO.	APPROVALS	DATE
DRAWN BIMA		07/20/09
CHECKED		
APPLICATION	USED ON	
NEXT ASSY		


SERVOD PRODUCTS COMPANY
 34940 LAKELAND BLVD, EASTLAKE, OH 44195
INSTALLATION DRAWING
 MODEL D1000-9508

SIZE	CODE IDENT NO.	DRAWING NO.
B	0800-81001	NB-59632
SCALE	5/8	SHEET
		OF

