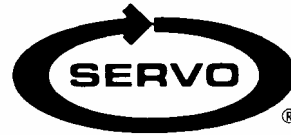


# DYNAMO FEED INSTALLATION

## D1000-9518 Cross Feed

### Alliant RT2-50



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#### PREPARATION

- Step 1:* Remove the nut, key, handle, and dial assembly from the lead screw.
- Step 2:* Remove the shroud from the power feed.
- Step 3:* Slide the spacer and bearing race onto the lead screw.
- Step 4:* Slide the power feed over the bearing race and square to the mill.
- Step 5:* Transfer the mounting holes from the power feed to the mill.
- Step 6:* Remove the power feed, spacer, and bearing race from the mill.
- Step 7:* Drill and tap 1/4-20 x 3/8" deep into the bearing housing.

#### POWER FEED INSTALLATION

- Step 1:* Screw the shaft extension onto the lead screw and tighten.
- Step 2:* Using the hole provided as a pilot, drill 1/8" diameter through the shaft and pin the extension in place using the 1/8 diameter x 5/8" long roll pin. File smooth.
- Step 3:* Slide the spacer and bearing race onto the lead screw.
- Step 4:* Place the shroud onto the power feed and slide the unit onto the lead screw. Secure using 1/4-20 x 1-1/4" 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:* In the following sequence, put on the dial locking nut, place the 5 mm key in the shaft extension, and slide the handcrank #57903 in place. Secure 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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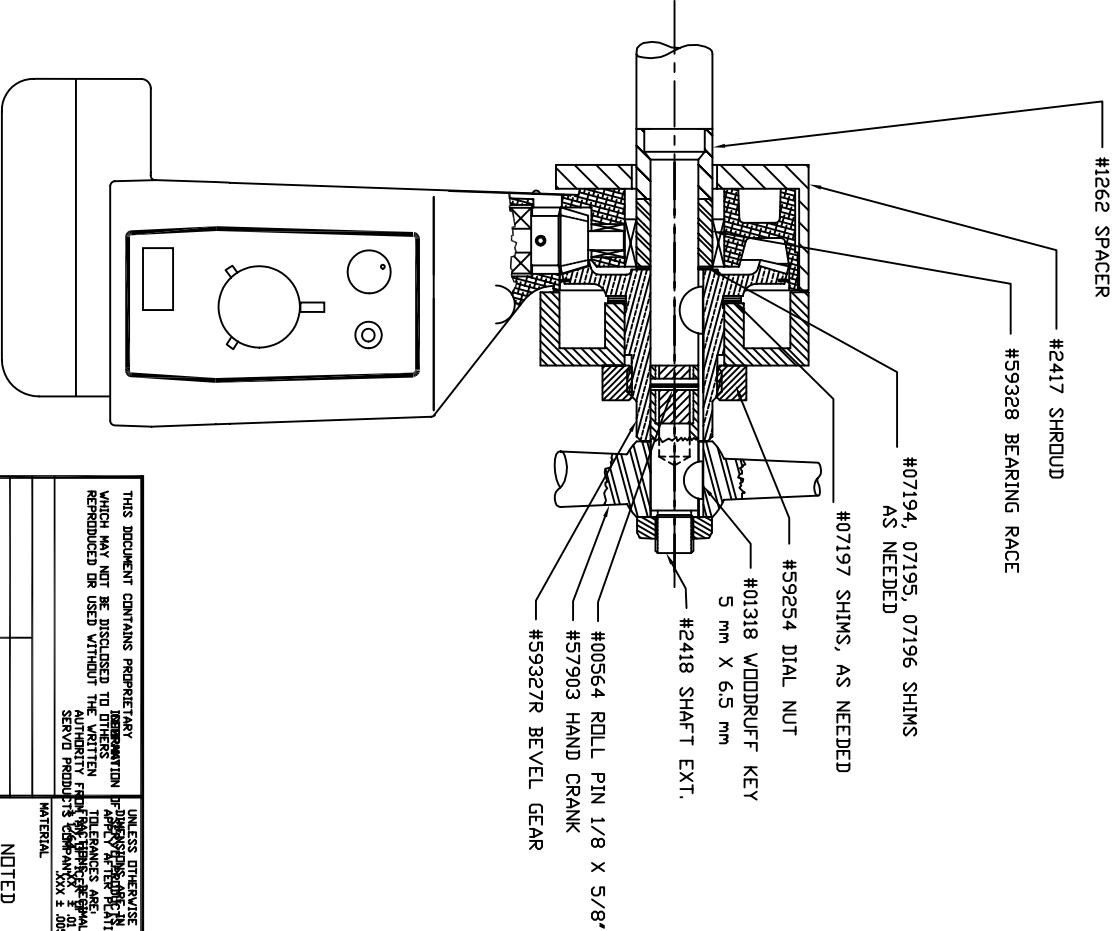
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Ph. 727.585.8555 Fax 727.585.6555

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SERVO PRODUCTS COMPANY  
 34940 LABELAND BL., EASTLAKE, OH 44095 USA

INSTALLATION DRAWING  
 ALLIANT RT2-50  
 MODEL 9518

COMPUTER NO.

DID NOT SCALE DRAWING

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