

# POWER FEED INSTALLATION

## Model M-0206 Table Feed

### Bridgeport Mill



Replaces Bridgeport 6F and 8F Electronic Feed

#### REFERENCE DRAWINGS ENCLOSED

NB-2339	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Operation

#### CAUTION

This is a factory pre-assembled unit. *Do not* disassemble!

#### PREPARATION

- Step 1:* Move the table to the extreme left.
- Step 2:* Remove the Bridgeport power feed from the right-hand end of the table, including the coupling to the lead screw. Leave the key in the lead screw. Save the cap screws that attached the feed to the table.
- Step 3:* Remove and retain the following parts from the Bridgeport 6F feed: dial, dial nut, handcrank, spring, spring seat washer, and handcrank sleeve.
- IF:* If the Bridgeport 6F feed has a new style safety handle, retain the following parts: dial, dial nut, and hub.
- Step 4:* For the new style safety handle, modify the Bridgeport hub as shown on installation drawing NB-2339 in Detail "B".

#### POWER FEED INSTALLATION

- Step 1:* Slide the table feed assembly over the shaft and bolt to the table.
- Step 2:* With the shims provided, position the dial 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.
- Step 3:* Add the dial nut.
- Step 4:* Add the shaft extension with the handcrank and related parts. (See drawing NB-2339 Note #1 for the old style safety handle assembly and Note #2 for the new style safety handle assembly.)
- Step 5:* Engage the directional control lever and turn the handcrank. The lead screw should turn freely without binding.
- IF:* If required, the alignment can be adjusted by loosening the four bolts holding the feed to the table and re-tightening them when no binding is experienced.

## 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 two cap screws holding the T-shaped table stop. Place the limit switch spacers into the T-stop and install limit switch using two 3/8 x 16 x 1-1/4" long socket head cap screws.

*Step 3:* The T-stop is retained to act as a positive stop where required for manual operation.

☐ **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 4:* Put the cable clamp on the cable and secure to the right-hand chip scraper screw.

## OPERATION

See separate *Servo Power Feed Operation* sheet. Plug the table feed into a source of 120 volt, 50 or 60 cycle power.

### 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.

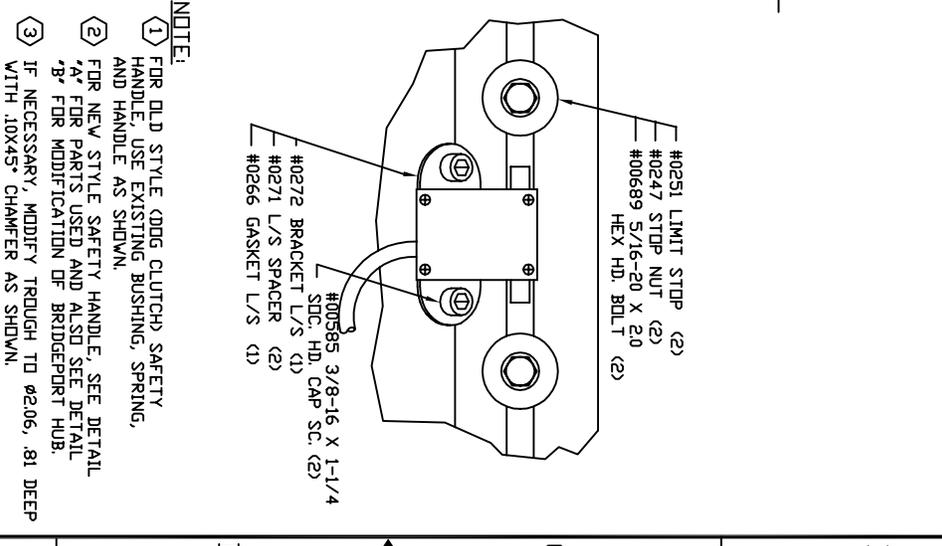
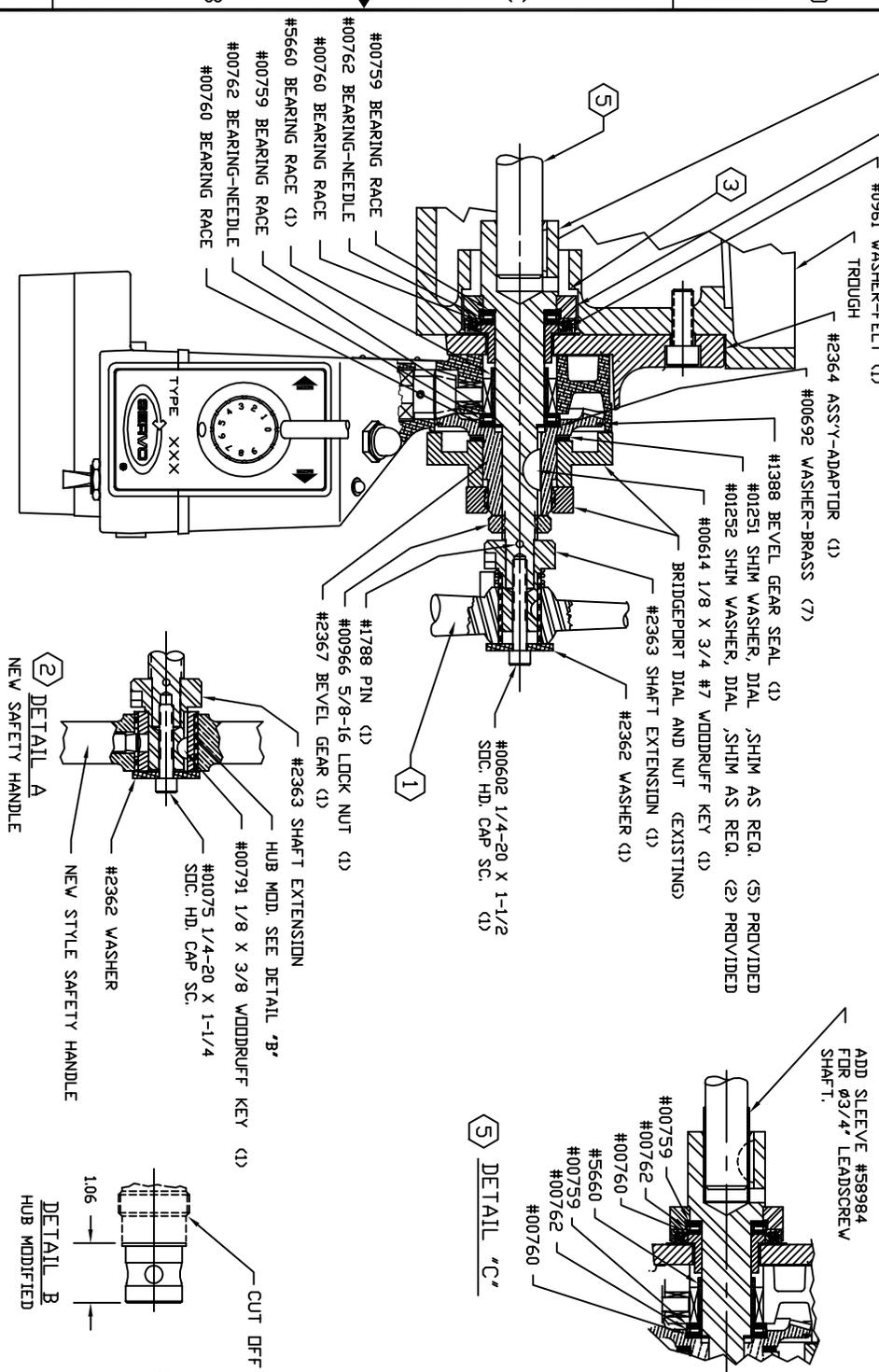
## SERVO PRODUCTS COMPANY

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DESCRIPTION				



**NOTE:**

1 FOR OLD STYLE (DGG CLUTCH) SAFETY HANDLE, USE EXISTING BUSHING, SPRING, AND HANDLE AS SHOWN.

2 FOR NEW STYLE SAFETY HANDLE, SEE DETAIL 'A' FOR PARTS USED AND ALSO SEE DETAIL 'B' FOR MODIFICATION OF BRIDGEPORT HUB.

3 IF NECESSARY, MODIFY TROUGH TO Ø2.06, .81 DEEP WITH .10X45° CHAMFER AS SHOWN.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS: DECIMALS ± 1/64, .XX ± .005, ANGLES ± 1/2°

UNLESS OTHERWISE SPECIFIED, FINISHES TO BE WITHIN .015 CONCENTRICITY TO BE WITHIN .01 REMOVE SHARP EDGES AND CORNERS .005 MIN. DOWELING STANDARD PER ANSI Y43M-1982

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SERVOPRODUCTS COMPANY  
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**INSTALLATION DRAWING**  
MODEL 206

SIZE CODE IDENT. NO. DRAWING NO. REV.  
B 0800-80091 NB-2339 C

SCALE 1/2 SHEET 1 OF 1

NOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON SERVOPOWER FEED.