

INSTALLATION INSTRUCTIONS

640SX Shaft Extension Kit for Bridgeport Mill



REFERENCE DRAWINGS ENCLOSED

NB-0889

Shaft Extension Kit Installation

➔ **NOTE** The Power Feed unit is sold separately as M-0200-140 or M-0200-150. Reference drawings NA-5444 and NB-0296 are included with the M-0200 installation instructions.

PREPARATION

Step 1: Gather together the following items that you will need to complete this installation.

- a) soft hammer
- b) 3/4" socket wrench
- c) set of inch hex wrenches
- d) grease
- e) clean shop rag

Step 2: Move the table to the extreme left.

Step 3: Remove the nut, handle, and dial assembly from the right-hand end of the table.

Step 4: Remove the four cap screws holding the bearing housing in place.

Step 5: Using a soft hammer, tap the bearing housing off. Remove raised burrs on end surface of the table, if any. Then clean the surface.

POWER FEED INSTALLATION

Step 1: With the table in the extreme left-hand position, slide the bearing race #0246 onto the lead screw as shown on drawing NB-0889. Then install the adaptor assembly and tighten with the four cap screws

➔ **NOTE** On some machines the drive pin holes do not line up with the adaptor. Remove and discard the pins in such cases. The four cap screws are all that is necessary.

Step 2: Slide the sleeve #57277 onto the lead screw. Screw on the shaft extension tight against the sleeve. Then install spacer #6843 onto the shaft extension to check .27" dimension. Machine if necessary.

Step 3: Slide the second bearing race #0246 onto the shaft extension as shown.

Step 4: Slide the power feed onto the bearing race and push flush to the end of the adaptor assembly. Secure with two 1/4-20 x 1" long socket head cap screws.

BEVEL GEAR INSTALLATION

Step 1: Follow drawing NA-5444 that you received in the Power Feed packet for installation of the bevel gear. Adjust for proper gear backlash.

DIAL AND HANDWHEEL INSTALLATION

Step 1: After getting the proper gear 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. Three plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.

Step 2: In the following sequence, install the key, dial, and dial locking nut. Slide the handle in place and tighten with 1/2-20 locknut #01115.

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. See drawing NB-0296.

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 3/8-16 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 0.4 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 unit into a source of 120 volt, 50 or 60 cycle power.

*Please read **WARNINGS** on the following page.*

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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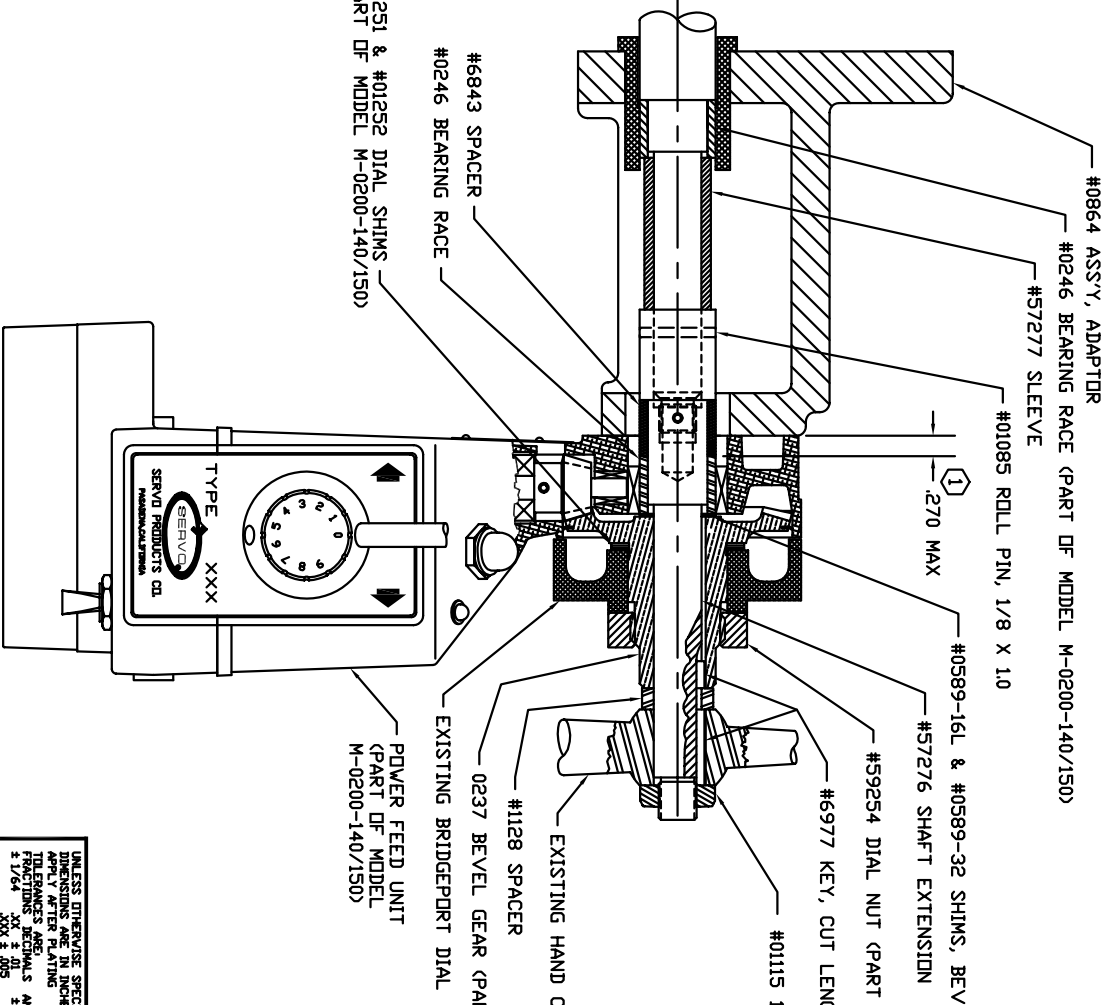
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REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				




- NOTES:
1. CHECK THIS DIMENSION WHEN THE SHAFT EXTENSION & SPACER #6843 ARE INSTALLED. IF IT IS GREATER THAN THE DIMENSION SHOWN, THE LENGTH OF THE SPACER #6843 WILL HAVE TO BE SHORTENED TO OBTAIN A .230/.270 PROJECTION. THIS IS TO ALLOW PROPER SHIMMING OF THE BEVEL GEAR.
 2. THIS KIT TO BE USED IN CONJUNCTION WITH MODEL M-0200-140/150.
 3. USE HANDLE AND KEY TO TIGHTEN SHAFT EXTENSION.
 4. READ ALL INSTALLATION AND OPERATION INSTRUCTION BEFORE TURNING ON THE POWER FEED.

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UNLESS OTHERWISE SPECIFIED, PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUND, CONCENTRICITY, CYLINDRICITY TO BE WITHIN .01 TOTAL OR .040/√L. SURFACE ROUGHNESS WITHIN 125 REMOVE SHARP CORNERS AND EDGES .005 MIN. DIMS TO UNLESS OTHERWISE SPECIFIED PER ANSI Y14.5M-1982

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & FRACTIONS DECIMALS ANGLES	CONTRACT NO.
1/64 XX ± .005	APPROVALS
1/32 XX ± .005	DATE
1/16 XX ± .005	9/9/96
NOTED	DRAWN G. BUINN
FINISH	CHECKED
DID NOT SCALE DRAWING	COMPUTER NO.

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SERVVO PRODUCTS COMPANY
 34940 LAKELAND BLVD, EASTLAKE, OH 44095
SHAFT EXTENSION KIT
INSTALLATION DRAWING
 MODEL KP-0640
 SIZE CODE IDENT NDL DRAWING NDL
 B 0800-80082 NB-0889 D
 SCALE 5/8 SHEET DF

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