POWER FEED INSTALLATION
Model M-0901 Table Feed
Index Mill 45, 645, 745

REFERENCE DRAWINGS ENCLOSED
NA-5444  Bevel Gear Installation
NB-0664  Power Feed Installation
ND-6293  Type 150 Servo Power Feed
ND-6292  Type 140 Servo Power Feed
0800-80001 Servo Power Feed Operation

PREPARATION

Step 1: Gather together the following items that you will need to complete this installation.
  a) 3/8” electric hand drill
  b) 1/8” drill, 5/64” drill, 3/16” drill or reamer
  c) flat file
  d) 3/4” socket wrench
  e) set of inch hex wrenches
  f) soft hammer
  g) grease
  h) clean shop rag

Step 2: Remove the nut, handle, and dial assembly from the right hand end of the table.

Step 3: Remove the four cap screws from the bearing housing. Using a soft hammer, tap the bearing housing off.

POWER FEED INSTALLATION

Step 1: Move the table to the extreme left-hand position.
Step 2: Screw the shaft extension to the lead screw and tighten.
Step 3: Using the hole provided as a pilot, drill 1/8” diameter through. Pin in place using the 1/8” x 5/8” long roll pin. File smooth.
Step 4: Slide the bearing race onto the lead screw.
Step 5: Slide the adaptor and Power Feed onto the bearing race.
Step 6: Secure adaptor to end of table with existing cap screws.

BEVEL GEAR INSTALLATION

Step 1: Follow the drawing NA-5444 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, put on the dial locking nut, place the key in the shaft extension, slide the handwheel (supplied) in place and secure with locking nut.

LIMIT SWITCH INSTALLATION

Step 1: Slide the table stop assembly into the T-slot to the left of the right-hand mounting pad. Slide the other table stop into the right of the mounting pad.

Step 2: Using the 3/8” x 1/2” cap screw supplied, bolt the bracket in place on the right-hand mounting pad.

Step 3: Drill 5/64” (.078 diameter) and size with a drill or reamer to 3/16”. Install roll pin.

OPERATION

See separate Servo Power Feed Operation sheet. Plug the unit 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.

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**Step 1**
Preparation

**Step 2**
Shimming Bevel Gear

- Add shims provided: 1/32 thick are solid, 1/64 thick are laminated, .002/lamination
- Push bevel gear against shims
- Install handcrank

**Step 3**
Double Check of Shimming

- Loosen setscrew
- Rotate gear from side to side. Remove or add shims as required to obtain .015/.025 backlash.

**Step 4**
Lubrication

- Install key
- Seal

**CAUTION:** If backlash is not properly set before turning unit on, bevel gear may be destroyed.

With power feed in neutral position, turn handcrank. If excessive gear noise or binding occurs, shims need to be added. When adding shims, repeat steps 1 and 2.

**Control Handle @ Neutral Position**

- Remove gear, pack with grease.
- (Do not use silicone type grease)
- Replace gear.
- (Do not lose any shims)

Pictures in this drawing are for reference only. See installation drawing of corresponding model for exact parts configuration.

**Servo Products Company**

**Bevel Gear Installation**

NA-5444 C
1. Review all Installation Instructions and Power Feed.

NOTE:

- #00596 roll pin
- #00596 limit switch plate
- #00416 stop nut

INSTALLATION LIMIT SWITCH