POWER FEED INSTALLATION
Model M-1300 Table Feed
Kondia G, FV-1, Hurco SM1 and others

REFERENCE DRAWINGS ENCLOSED
NA-5444 Bevel Gear Installation
NB-0761 Power Feed Installation
ND-6293 Type 150 Servo Drive
ND-6292 Type 140 Servo Drive
0800-80001 Servo Power Feed Operation

PREPARATION

Step 1: Remove the nut, handle, and dial assembly from the right-hand end of the table.

Step 2: Remove the bearing retainer from the end bracket. Save the screws.

POWER FEED INSTALLATION

Step 1: Attach the bearing retainer #2784 using the original screws.

Step 2: Slip the bearing race inside the adaptor. Slide them on the lead screw up to the end bracket and secure the adaptor with the three 1/4-20 x 1/2" long socket head cap screws. Remove the bearing race.

Step 3: Add the sleeve as shown, followed by the bearing race.

Step 4: Install the power feed to the adaptor using the 1/4-20 x 1" long socket head cap screws.

Step 5: Screw the shaft extension on the lead screw and tighten.

Step 6: You may wish to add the roll pin after determining the shims required for the bevel gear.
Using the hole provided as a pilot, drill 1/8" diameter through the lead screw and pin the extension in place using the 1/8 diameter x 5/8" long roll pin. File smooth.

BEVEL GEAR INSTALLATION

Step 1: Follow drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

DIAL AND HANDCRANK 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, add spacer #1230, and insert the woodruff key #1318. Slide the handcrank in place and secure with Kondia washer and handcrank nut #1229.

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: Install the limit switch as shown in drawing ND-0761.

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 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.
**STEP 1**
PREPARATION

**ADD SHIMS PROVIDED**
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION

**INSTALL HANDCRANK.**

**MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.**
015/025 (THIS IS NOT THE READING ON THE DIAL)

**ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN 015/025 BACKLASH.**

**STEP 2**
SHIMMING BEVEL GEAR

**PUSH BEVEL GEAR AGAINST SHIMS.**

**TIGHTEN NUT.**

**CAUTION: IF BACKLASH IS NOT PROPERLY SET BEFORE TURNING UNIT ON, BEVEL GEAR MAY BE DESTROYED.**

**STEP 3**
DOUBLE CHECK OF SHIMMING

**LOSEN SETSCREW**

**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.**

**STEP 4**
LUBRICATION

**INSTALL KEY**

**SEAL**

**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