POWER FEED INSTALLATION
Model M-1350 Cross Feed
Kondia G, FV-1, Hurco SM1, and others

REFERENCE DRAWINGS ENCLOSED

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PREPARATION

Step 1: Remove the nut, handcrank, dial, dial hub, and key from the lead screw.

Step 2: Replace the Kondia bearing retainer with the bearing retainer provided.

Step 3: Slide the bearing race onto the adaptor.

Step 4: Slide the adaptor and bearing race onto the lead screw and secure to bearing retainer with the 1/4-20 x 1/2" long socket head cap screws.

Step 5: Remove the bearing race.

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 lead screw and pin the shaft 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: Secure the power feed to the adaptor using the 1/4-20 x 1" long socket head cap screws.

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 the spacer #1230, and insert the woodruff key. Slide the Kondia handcrank and washer in place. Secure with the handcrank nut #1229.
LIMIT SWITCH INSTALLATION

Step 1: See limit switch installation on drawing ND-1231.

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

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.

0.015/.025 (THIS IS NOT THE READING ON THE DIAL)

STEP 2
SHIMMING BEVEL GEAR

INSTALL HANDCRANK.

PUSH BEVEL GEAR AGAINST SHIMS.

ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN 0.015/.025 BACKLASH.

TIGHTEN NUT.

STEP 3
DOUBLE CHECK OF SHIMMING

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

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

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
NOTES: 1. Review ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPETATIONS BEFORE TURNING ON SERVO POWER FEED.

ON LEFT SIDE OF KNEE:
LIMIT STOP MAY BE MOUNTED.

1/32 IN. STOP RING
1/8 x 16 HEX NUT
M10-1.25 X 12MM TAP
M12 X 1.25 X 12MM TAP
06670 TAP DRILL 1/2" TAP
1/4" DIA IN. DIA. 9/16" DIA. 5/8" DIA.