POWER FEED INSTALLATION
Model M-1500/1501 Table Feed
Lagun Mill

REFERENCE DRAWINGS ENCLOSED
NA-5444       Bevel Gear Installation
NB-1995       Power Feed Installation
ND-6293       Type 150 Servo Drive
ND-6292       Type 140 Servo Drive
0800-80001    Servo Power Feed Operation

PREPARATION

Step 1: Move the table to the extreme left-hand position.

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.

Step 4: Using a soft hammer, tap the bearing housing off. Clean the end surface of the table.

POWER FEED INSTALLATION

Step 1: Slide the bearing race onto the lead screw.

Step 2: Slide the adapter and feed onto the bearing race.

Step 3: Secure the adapter to end of table with existing 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. Plastic and metal washers are provided for this. Shim as required.

Step 2: In the following sequence, put on the dial locking nut and slide the handcrank in place. Add the washer and the 1/2-20 lock nut.
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 bracket. Place the short spacers into the counterbored holes in the T-stop and place the limit switch assembly on the spacers and locate using the M8 cap screws.

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 3: Secure the cable using the cable clamp provided. Use the screw provided to attach the clamp to the right hand side of the chip scraper.

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

**STEP 2**
SHIMMING BEVEL GEAR

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.

0.015/0.025
(TO THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN 0.015/0.025 BACKLASH.

**STEP 3**
DOUBLE CHECK OF SHIMMING

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

LOOSEN 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
LIMIT SWITCH INSTALLATION

1. Limit switch must be parallel.

LIMIT STOP INSTALLATION

#99524 dial nut

#99525 dial nut

#1967 bevel gear

#1968 bevel gear seal

NOTES:

CTRNT R3 DIA. 1 0.5 X 0.5 SHA.CS.

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