

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.

SERVO PRODUCTS COMPANY

Web: www.servoproductsco.com

CALIFORNIA BRANCH

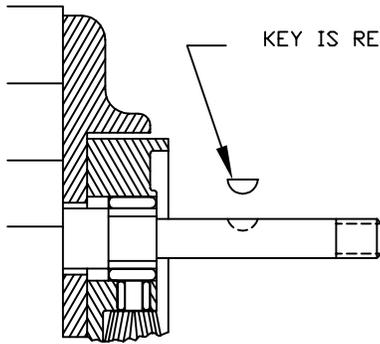
14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

HEADQUARTERS

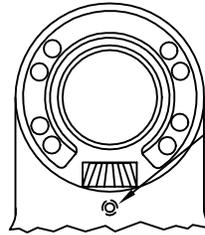
34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555

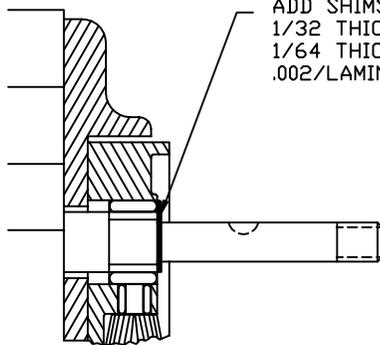


KEY IS REMOVED DURING SHIMMING

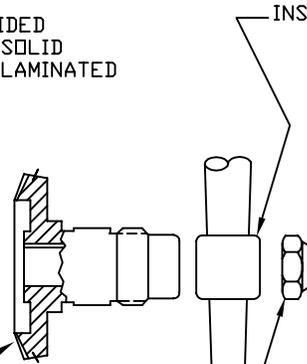


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1
PREPARATION



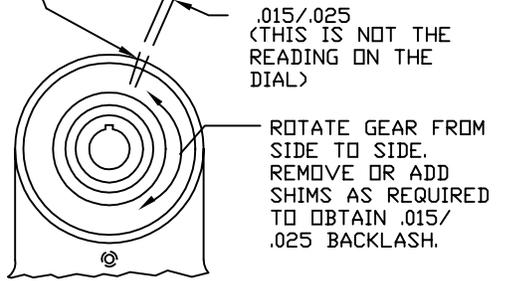
ADD SHIMS PROVIDED
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION



PUSH BEVEL GEAR AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.



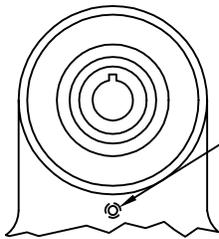
.015/.025
(THIS IS NOT THE READING ON THE DIAL)

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

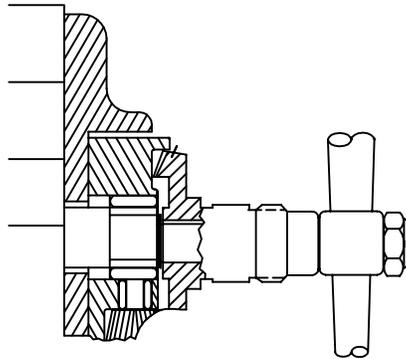
STEP 2
SHIMMING BEVEL GEAR

TIGHTEN NUT.

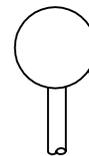
CAUTION: IF BACKLASH IS NOT PROPERLY SET BEFORE TURNING UNIT ON, BEVEL GEAR MAY BE DESTROYED.



LOOSEN SETSCREW

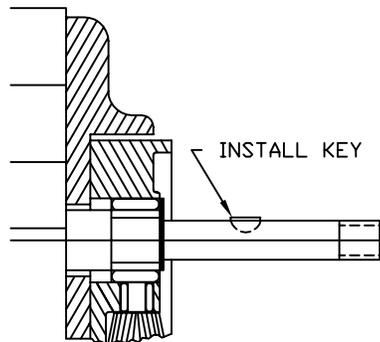


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.

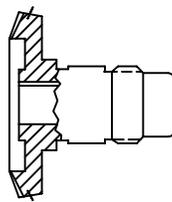


CONTROL HANDLE @ NEUTRAL POSITION

STEP 3
DOUBLE CHECK OF SHIMMING



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.

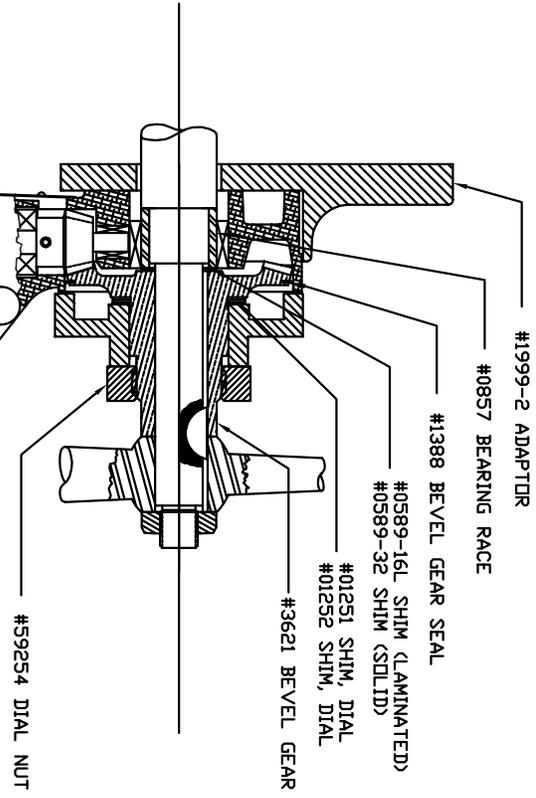
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BEVEL GEAR INSTALLATION

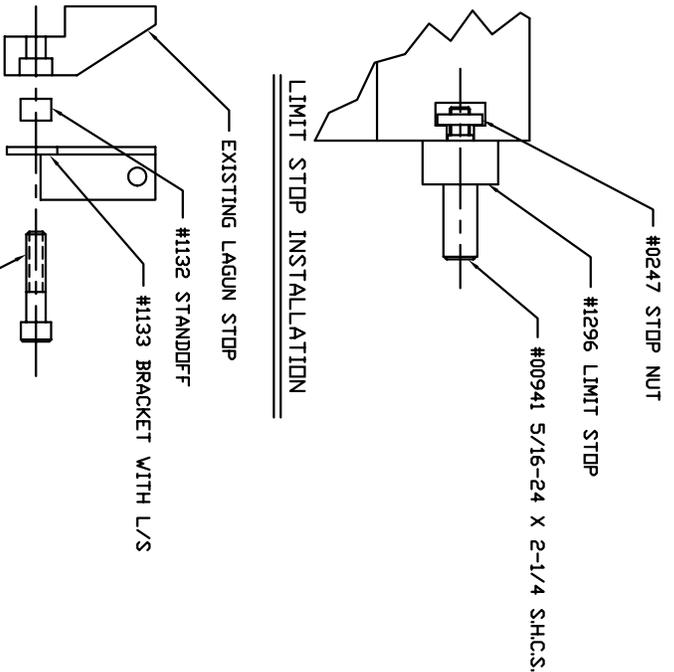
NA-5444 C

STEP 4
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



- NOTES:
- LIMIT SWITCH MUST BE PARALLEL WITH TABLE. IT MAY BE REQUIRED TO ALTER STANDOFF LENGTHS DUE TO COUNTER BORE DEPTH VARIATIONS.



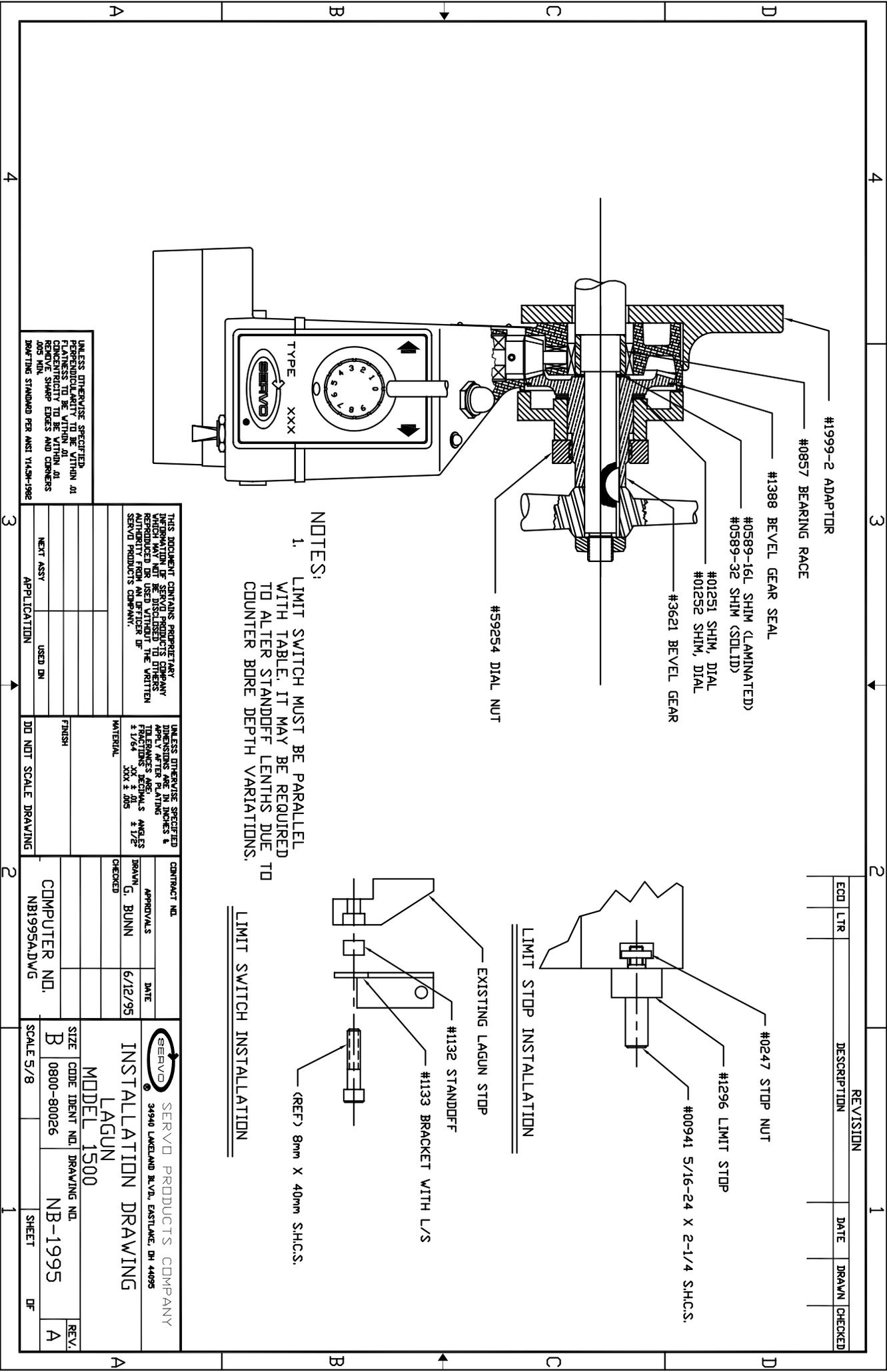
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE FRACTIONS DECIMALS ANGLES
 ± 1/64 .XX .05 ± 1/2°
 MATERIAL FINISH CHECKED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE WITHIN .01 FLATNESS TO BE WITHIN .01 CONCENTRICITY TO BE WITHIN .01 REMOVE SHARP EDGES AND CORNERS .005 MIN. DRAWING STANDARDS PER ANSI Y14.5M-1992	THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVO PRODUCTS COMPANY WHICH MAY NOT BE DISCLOSED TO OTHERS WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVO PRODUCTS COMPANY.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE FRACTIONS DECIMALS ANGLES ± 1/64 .XX .05 ± 1/2° MATERIAL FINISH CHECKED	CONTRACT NO. APPROVALS DATE 6/12/95	COMPUTER NO. NB1995AD/VG	SCALE 5/8	SIZE CODE IDENT NO. 0800-80026	DRAWING NO. NB-1995	REV. A

SERVO PRODUCTS COMPANY
 34940 LAKELAND BLVD., EASTLAKE, OH 44095

INSTALLATION DRAWING
 LAGUN
 MODEL 1500





M-1500/1501 TABLE FEED PARTS IDENTIFICATION LIST

- 00579 Clamp Qty = 1
- 01050 Clamp Qty = 1
- 00688 Phil Pan Hd Screw Qty = 1
- 0266 Limit Switch Gasket Qty = 1
- 1133 Limit Switch Bracket Qty = 1
- 06928 Phil Pan Hd Screw Qty = 4
- 1132 Standoff Qty = 2

- 00941 Soc Head Cap Screw Qty = 2
- 0247 Stop Nut Qty = 2
- 1296 Limit Stop Qty = 2
- 59254 Dial Nut Qty = 1
- 01251 Brass Shim Qty = 5
- 01252 Plastic Shim Qty = 5
- 3621 Bevel Gear Qty = 1

- 0589-32 .032 Shim Qty = 8
- 0589-16L .016 Shim Qty = 2
- 0857 Bearing Race Qty = 1
- 00586 Soc Hd Cap Screw Qty = 2
- 00596 Roll Pin Qty = 2



1999-2 Adaptor Qty = 1