POWER FEED INSTALLATION  
Model M-1550 Cross Feed  
Lagun Mills

REFERENCE DRAWINGS ENCLOSED

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PREPARATION

*Step 1:* Remove the nut, key, handle, and dial assembly from the lead screw.

*Step 2:* Remove the shroud from the power feed.

*Step 3:* Slide the spacer and bearing race onto the lead screw.

*Step 4:* Slide the power feed over the bearing race and square to the mill.

*Step 5:* Transfer the mounting holes from the power feed to the mill.

*Step 6:* Remove the power feed, spacer, and bearing race from the mill.

*Step 7:* Drill and tap 1/4-20 x 3/8” deep thread into the bearing housing. *Do not* contaminate the bearings.

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 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:* Place the shroud onto the power feed and slide the unit onto the lead screw. Secure using 1/4-20 x 1-1/4” 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. Plastic and metal washers are provided for this. Shim as required.
Step 2: In the following sequence, put on the dial locking nut, place key in the shaft extension, and slide the handcrank #57903 in place. Secure with the 1/2-20 lock nut.

LIMIT SWITCH INSTALLATION

Step 1: See the limit switch installation on drawing ND-1996.

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.

0.015/0.005 (THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN 0.015/.005 BACKLASH.

PUSH BEVEL GEAR AGAINST SHIMS.

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.

**STEP 3**
DOUBLE CHECK OF SHIMMING

**STEP 4**
LUBRICATION

INSTALL KEY

SEAL

SERVO PRODUCTS COMPANY
BEVEL GEAR INSTALLATION
NA-5444 C
M-1550 CROSS FEED PARTS IDENTIFICATION LIST