POWER FEED INSTALLATION
Model M-2300/2308 Table Feed
Do All, Exacto, Maxmill, Select and others

REFERENCE DRAWINGS ENCLOSED
NA-5444  Bevel Gear Installation
NB-3200  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.

Step 2:  Remove the nut, handle and dial assembly from the right-hand end of the table.

Step 3:  Remove the four cap screws holding the bearing housing in place.

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

POWER FEED INSTALLATION

Step 1:  With the table in the extreme left-hand position, install the adaptor with the four cap screws.

⚠️ NOTE  On some machines the drive pin holes do not line up with the adapter. Remove and discard the pins in such cases. The four cap screws are all that is necessary.

Step 2:  Slide the bearing spacer, then the bearing race onto the lead screw. Slide the power feed onto the bearing race and push flush to the end of the adaptor.

⚠️ NOTE  Depending on the lead screw, the bearing race spacer might require to be shortened approximately 5/32" in order to get proper shimming of the bevel gear.

Step 3:  Secure the feed with two 1/4-20 x 1" 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. Four washers are provided for this, two solid and two laminated. Shim as required.

Step 2: In the following sequence, replace the dial and dial locking nut, slide the handle in place and tighten with the locking 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 and replace with the limit switch bracket #01852. Secure with original screws.

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.

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STEP 1
PREPARATION

KEY IS REMOVED DURING SHIMMING

STEP 2
SHIMMING BEVEL GEAR

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

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.

0.015/0.025 (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.

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

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.

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BEVEL GEAR INSTALLATION

NA-5444 C

FORM 0800-80002 7/25/95
1. Review all installation instructions and power feed operation.

NOTE:

INSTALLATION LIMIT SWITCH

G AS TRAVEL STOP.

Plunger will be on same
have to be relocated so
these screw holes may

3199 BRACKET LIMIT SWITCH

SOC. HD. CAP SC.

06534 5/16-24 x 1-1/2

LOCK NUT

1115 1/2-20 SE

0247 TABLE STOP NUT

0684 LIMIT STOP

2255 DIAL NUT

3201 BEVEL GEAR

046 BEARING RACE

0989-32 SOLID SHAFTS

0989-160 LAMINATED SHAFTS

1388 BEVEL GEAR SEAL

0239-1 ADAPTER