POWER FEED INSTALLATION
Model M-2350/2358 Cross Feed
Exacto, Maxmill, Supermax (2350)
Do All (2358)

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PREPARATION

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

**Step 2:** Slide the bearing race onto the lead screw. Slide the power feed over the bearing race. Line up the feed so that it sits square to the bearing housing. Using the power feed as a template, spot two holes in the bearing retainer plate.

**Step 3:** Remove the power feed and bearing race.

**Step 4:** Remove the four screws securing the bearing housing and remove from the mill. (The lead screw can now be used to jack the housing off the pins. The lead screw does not have to be removed from the mill.)

**Step 5:** Drill and tap two holes 1/4-20 x 7/8 deep.

**Step 6:** Reinstall the bearing housing back onto the mill.

POWER FEED INSTALLATION

**Step 1:** Screw the shaft extension to the lead screw and tighten. Using the hole provided as a pilot, drill 1/8 diameter through and pin the shaft extension in place using the 1/8 x 5/8 long roll pin. File smooth.

**Step 2:** Slide spacers and bearing race onto the lead screw.

**Step 3:** Slide the power feed onto the bearing race and secure with two 1/4-20 x 1-1/2” 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. Place the 4 mm key in the shaft extension and slide the handwheel onto shaft extension. Secure with the washer and locking nut provided.

LIMIT SWITCH INSTALLATION

Step 1: See limit switch installation on drawing NB-1538 enclosed.

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
0.002/LAMINATION

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR
WITH PENCIL TO CHECK BACKLASH.

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

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

LOosen SETSCREW

STEP 3
DOUBLE CHECK OF SHIMMING

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

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
Before turning on servo power feed,
2. Review all installation instructions and power feed operation
with clearance holes in bearing cap (2 p.c.s.)

Drill and tap two holes 1/4-20 x 7/8 deep into bracket

NOTE:

1. Counter length to suit
4mm key

1/8 X 5/8
#00064 ROLL PIN

2939 SHAFT EXTENSION

#01115 1/2-20 LOCK NUT

#01169 1/2 SAF WASH

WOODRUFF KEY

#01777 4MM X 5MM

#3201 BEVEL GEAR

#01225 SHIM WASHER DIAL

#01225 SHIM WASHER DIAL

#01225 SHIM WASHER DIAL

#0477 SPACER

#2981 SPACER

#1699 BEARING RACE

#0599-32 SOLID SHIM

#0599-101 LAUNDERED SHIM

#1388 BEVEL GEAR SEAL