POWER FEED INSTALLATION
Model M-2700 Table Feed
Hartford, Marena 942, Newport, Webb, and others

REFERENCE DRAWINGS ENCLOSED
NA-5444  Bevel Gear Installation
NB-2778  Power Feed Installation
ND-6292  Type 140 Servo Drive
ND-6293  Type 150 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, dial assembly, and key from the lead screw. Save the key for installation later.

Step 3: Remove the four cap screws from the bearing housing. Save the screws for installation later.

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 shaft spacer #5426, the bearing race #0246, and the second shaft spacer #5426 onto the lead screw.

Step 2: Slide the adaptor #0239-4 with the feed onto the bearing race.

Step 3: Secure the assembly to the end of the table with the saved cap screws.

BEVEL GEAR INSTALLATION

Step 1: Follow drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

If necessary turn the second shaft spacer #5426 to the proper length. If the key does not engage the bevel gear, use provided spring pin #00596 as shown on drawing NB-2778, detail A.

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. Two plastic (.030” thick) and five brass (.005” thick) washers are provided for this. Shim as required.

Step 2: Secure the dial using the dial nut. Slide the handcrank onto the end of the shaft and tighten with the 1/2-20 lock nut.
LIMIT SWITCH INSTRUCTIONS

Step 1: Remove the standard table stop pieces and install the table stop pieces furnished. Put the standard stop back in 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.

Step 3: Place the short spacers into the counterbored holes in the T-stop. Place the limit switch assembly on the spacers and install using the two 3/8-16 x 1” socket head cap screws.

Step 4: 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 5: Put the cable clamp on the cable and secure using 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

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

**STEP 2**
SHIMMING BEVEL GEAR

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.

**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

SeAL

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BEVEL GEAR INSTALLATION  
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