

POWER FEED INSTALLATION

Model M-3800 Table Feed

Comet 3KV/VH 10x50



REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-5499	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Installation

PREPARATION

- Step 1:* Remove the nut, handle, and dial assembly from the right-hand end of the table.
- Step 2:* Remove the four cap screws holding the bearing housing in place.
- Step 3:* 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 in place over the shaft.
- Step 2:* Slide the power feed onto the shaft and push in place.

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

- Step 3:* Move the table to the extreme left-hand position and then tighten the four 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 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, put on the dial locking nut, replace the key in the shaft (if removed), slide the handle in place, and add 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 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" long 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.

SERVO PRODUCTS COMPANY

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Call for the location of our regional Service Centers.

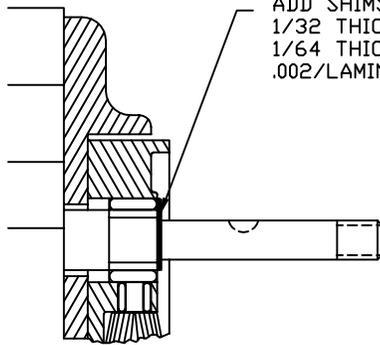


KEY IS REMOVED DURING SHIMMING



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.

TIGHTEN NUT.

STEP 2
SHIMMING BEVEL
GEAR

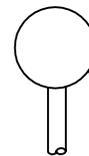
CAUTION: IF BACKLASH
IS NOT PROPERLY SET
BEFORE TURNING UNIT ON,
BEVEL GEAR MAY BE
DESTROYED.



LOOSEN SETSCREW

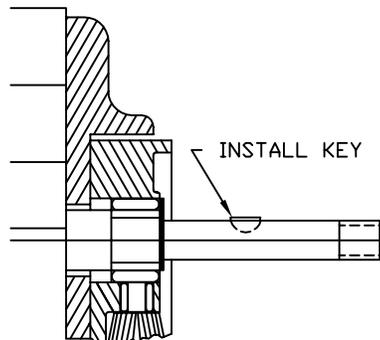


WITH POWER FEED IN
NEUTRAL POSITION, TURN
HANDCRANK. IF EXCESSIVE
GEAR NOISE OR BINDING
OCCURS, SHIMS NEED TO BE
ADDED. WHEN ADDING SHIMS,
REPEAT STEPS 1 AND 2.



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.

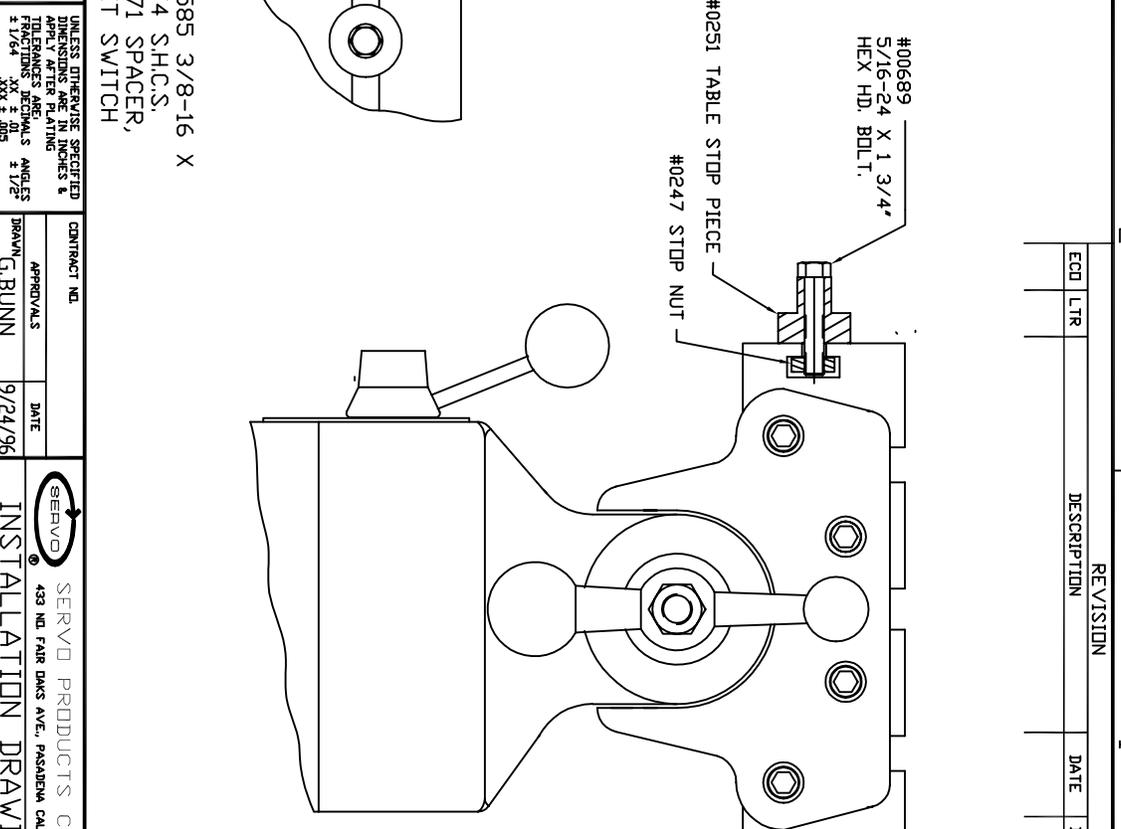
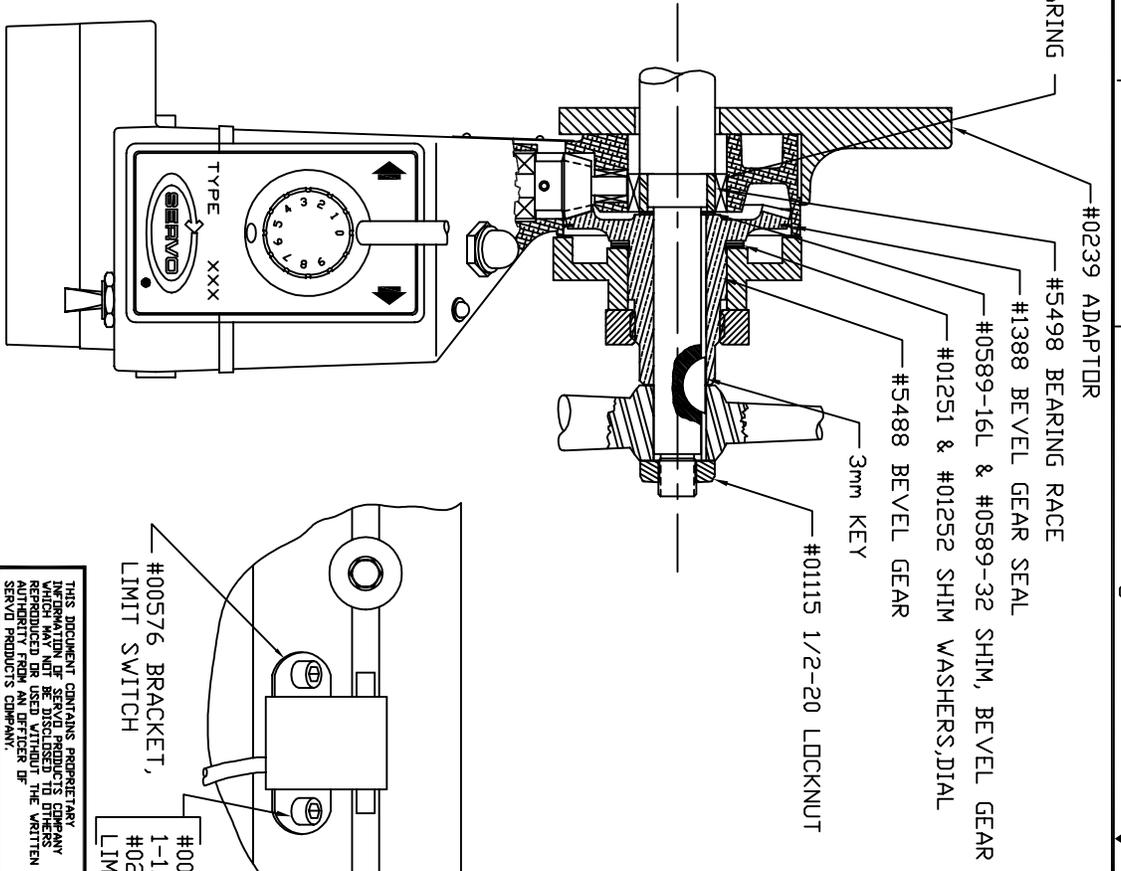
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BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				



UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUNDNESS, CONCENTRICITY, CYLINDRICITY TO BE WITHIN .01 TOTAL OR .040/√R. SURFACE ROUGHNESS WITHIN 125/√R. REMOVE SHARP CORNERS AND EDGES .005 MIN. DRAWING STANDARD PER ANSI Y14.5M-1982

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS: DECIMALS ± 1/64 .XX ± .005 ANGLES ± 1/2° MATERIAL NOTED CHECKED

APPROVALS	DATE	CONTRACT NO.
DRAWN G. BUHN	9/24/96	
CHECKED		
FINISH		
APPLICATION	USED ON	
NEXT ASSY		

COMPUTER NO.	NBS499A.DWG
DID NOT SCALE DRAWING	


SERVO PRODUCTS COMPANY
 433 N. FAIR OAKS AVE., PASADENA, CALIFORNIA 91103
INSTALLATION DRAWING
MODEL 3800 VH
10 X 50 TABLE
 SIZE CODE IDENT. NO. DRAWING NO. SHEET OF
 B 0800-80032 NB-5499 A

