POWER FEED INSTALLATION  
Model M-3800 Table Feed  
Comet 3KV/VH 10x50

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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.

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**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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Call for the location of our regional Service Centers.
STEP 1
PREPARATION

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.

TIGHTEN SLIGHTLY (HOLDS
BEVEL PINION STATIONARY
DURING SHIMMING)

TIGHTEN NUT.

STEP 2
SHIMMING BEVEL
GEAR

PUSH BEVEL GEAR
AGAINST SHIMS.

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.

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

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.

STEP 4
LUBRICATION

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BEVEL GEAR INSTALLATION

NA-5444  C

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