



# TURBO DRIVE INSTALLATION

## MODEL 4380T KNEE FEED

Sharp, Alliant & Others

- ➔ **NOTE** This Turbo Drive Knee Feed is configured for mounting the feed on the front of the knee with the keypad facing left. The lead screw pitch is 5 turns per inch left hand with 2 to 1 reducing bevel gear set from the jack shaft to the lead screw (jack screw). See **CAUTION** below before changing anything!

### CAUTION

The Turbo Drive power cable should be left **unplugged** until the drive is properly installed on the lead screw.

See the **Operation** manual to reverse the direction of travel or to change the lead screw pitch default. Turn **off** the Turbo Drive and **remove** the power plug from the wall before you attempt to change any jumpers or reverse the top housing.

### WARNINGS

**DO NOT** install and operate this power feed without the 8" safety handwheel Servo #1685-1 for the knee feed. This is required to prevent injury.

**Check handwheel clearances before operation.**

Clearances between the surfaces of the handwheel and the non-moving parts of the equipment on which the handwheel is installed must be at least one-fourth inch (1/4") to prevent injury.

**Do not operate** without proper clearance!

Prevent contact during fast traverses.

### WARRANTY CAUTION

There are **NO** user-serviceable parts inside the center or bottom housings. Removal of the motor, keyboard, or bottom housing screws **voids** the warranty.

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### REFERENCE DRAWINGS ENCLOSED

NA-58496	Bevel Gear Installation
NB-58839	Turbo Drive Installation
0800-80678	Turbo Drive Operation manual

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### PREPARATION

**Step 1:** Gather together the following items that you will need to complete this installation.

- lathe
- 3/8" electric hand drill
- #7 drill, 1/8" drill, 3/16" drill, #Q drill

- d) 1/4-20 tap, 3/8-24 tap
- e) 9/32" diameter transfer punch
- f) flat file
- g) 3/4" socket wrench
- h) set of inch hex wrenches
- i) grease
- j) clean shop rag

- Step 2:** Clean the power feed mounting area completely.
- Step 3:** Remove the drive clutch from the elevating jack shaft.
- Step 4:** Remove the dial nut, dial, and dial carrier. (Turn the dial carrier counterclockwise to remove.) Keep the dial for reuse later.
- Step 5:** Slip bearing race #0714 onto the jack shaft as shown. Slide the Turbo Drive over the bearing race and locate against front of the knee.
- Step 6:** Using a 9/32" diameter transfer punch, transfer three mounting holes from the feed to the bearing retainer. Remove the unit, the bearing retainer and all the parts just installed. Then drill and tap 1/4-20 UNC threads through the bearing retainer.
- Step 7:** Pull jack shaft out of knee. Hold inboard end up while removing to avoid damage to the pinion gear.
- Step 8:** Press the bearing off the jack shaft.
- Step 9:** Drill the end of the jack shaft .332" (#Q) diameter by 1-1/4" deep. The .332" diameter must be concentric to the shaft O.D. within .002" T.I.R. Chamfer 1/32" x 1/2" diameter. Tap 3/8-24 x 3/4" deep. **For best results, machining should be done in a lathe.**
- Step 10:** Screw the shaft extension #58537 onto the end of the jack shaft and tighten. Finish drill 1/8" diameter hole through threaded joint and pin with the 1/8" diameter x 5/8" long roll pin. File smooth.
- Step 11:** Reassemble and replace the jack shaft in the machine.
- Step 12:** Replace the bearing retainer.

## **TURBO DRIVE INSTALLATION**

- Step 1:** Slide spacer #57897 onto the jack shaft followed by spacer #6745 and the bearing race #0714 as shown.
- Step 2:** Slide the Turbo Drive onto the bearing race and push against the adaptor. Secure with two 1/4-20 x 1-1/8" long socket head cap screws.
- IF:** If the bearing race is not flush with the needle bearing in the unit within  $\pm .05$ ", then either shim behind the race or machine the spacer to correctly locate the race.

## BEVEL GEAR INSTALLATION

*Step 1:* Follow the drawing NA-58496 for installation of the bevel gear. Adjust for proper gear backlash.

## DIAL AND HANDWHEEL INSTALLATION

*Step 1:* After getting the proper gear 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. Three plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.

*Step 2:* In the following sequence, install the key, dial and dial nut #59254. Slide the handwheel #1685-1 and spacer #6811 in place and tighten with 1/2-20 locknut #01115.

## TURBO DRIVE OPERATION

See the separate **Servo Turbo Drive Operation** manual for complete operating instructions. Plug the unit into a properly grounded three-wire outlet supplying 110 volt single phase 50/60 Hz 6 amp power. Turn the control switch ON and follow the instructions in the manual or on the **Quick Reference** sheet for setting limits.

# SERVO PRODUCTS COMPANY

Web: [www.servoproductsco.com](http://www.servoproductsco.com)

### CALIFORNIA BRANCH

1355 W. Foothill Blvd.  
Azusa, CA 91702

Ph. 626.691.0121 Fax 626.334.7301

### HEADQUARTERS

34940 Lakeland Blvd.  
Eastlake, OH 44095

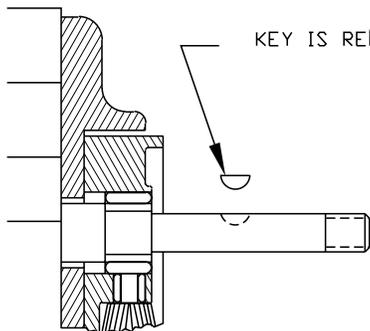
Ph. 440.942.9999 Fax 440.942-9100

### FLORIDA BRANCH

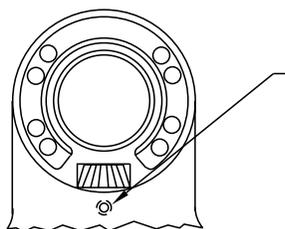
8950 131<sup>st</sup> Ave. N.  
Largo, FL 33773

Ph. 727.585.8555 Fax 727.585.6555

DO NOT PLUG IN POWER UNTIL ALL STEPS ARE COMPLETED.

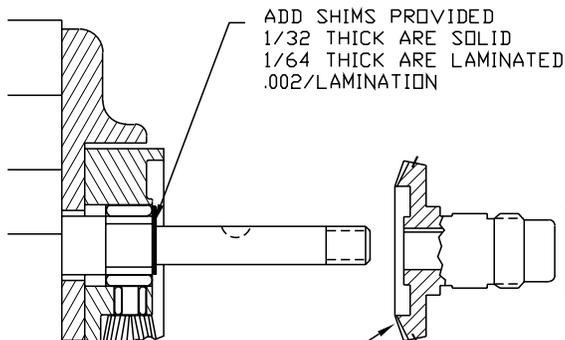


KEY IS REMOVED DURING SHIMMING

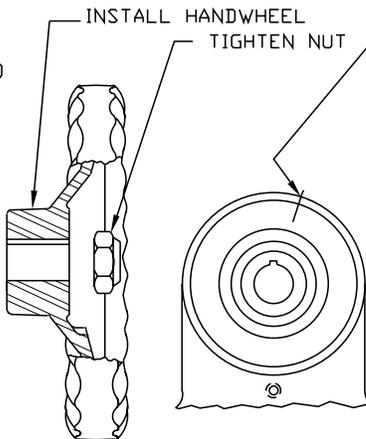


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)  
(TIGHTEN UPPER ONE ONLY)

**STEP 1**  
**PREPARATION**



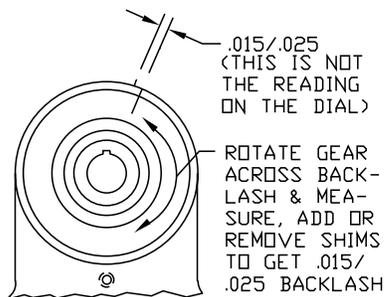
ADD SHIMS PROVIDED  
1/32 THICK ARE SOLID  
1/64 THICK ARE LAMINATED  
.002/LAMINATION



INSTALL HANDWHEEL

TIGHTEN NUT

SCRIBE ACROSS GEAR & HOUSING WHILE PUSHING GEAR AGAINST ONE SIDE OF THE BACKLASH



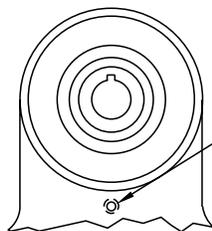
.015/.025  
(THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR ACROSS BACKLASH & MEASURE, ADD OR REMOVE SHIMS TO GET .015/.025 BACKLASH

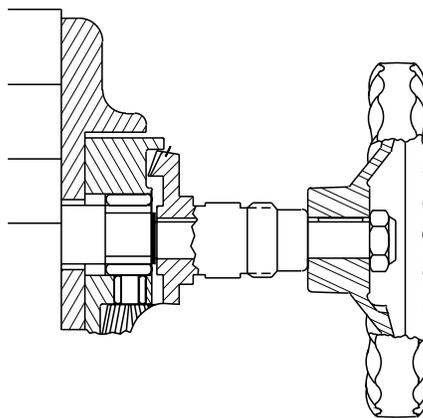
PUSH BEVEL GEAR AGAINST SHIMS.

**STEP 2**  
**SHIMMING BEVEL GEAR**

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

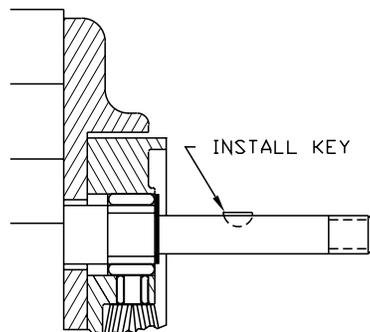


LOOSEN SETSCREW

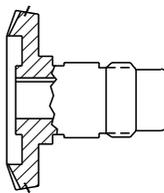


MANUALLY TURN HANDWHEEL. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED OR REMOVED, WHEN RE-SHIMMING, REPEAT STEPS 1 AND 2.

**STEP 3**  
**DOUBLE CHECK OF SHIMMING**



INSTALL KEY



SEAL

**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.

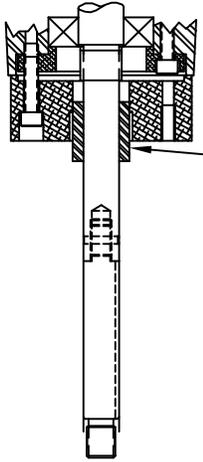
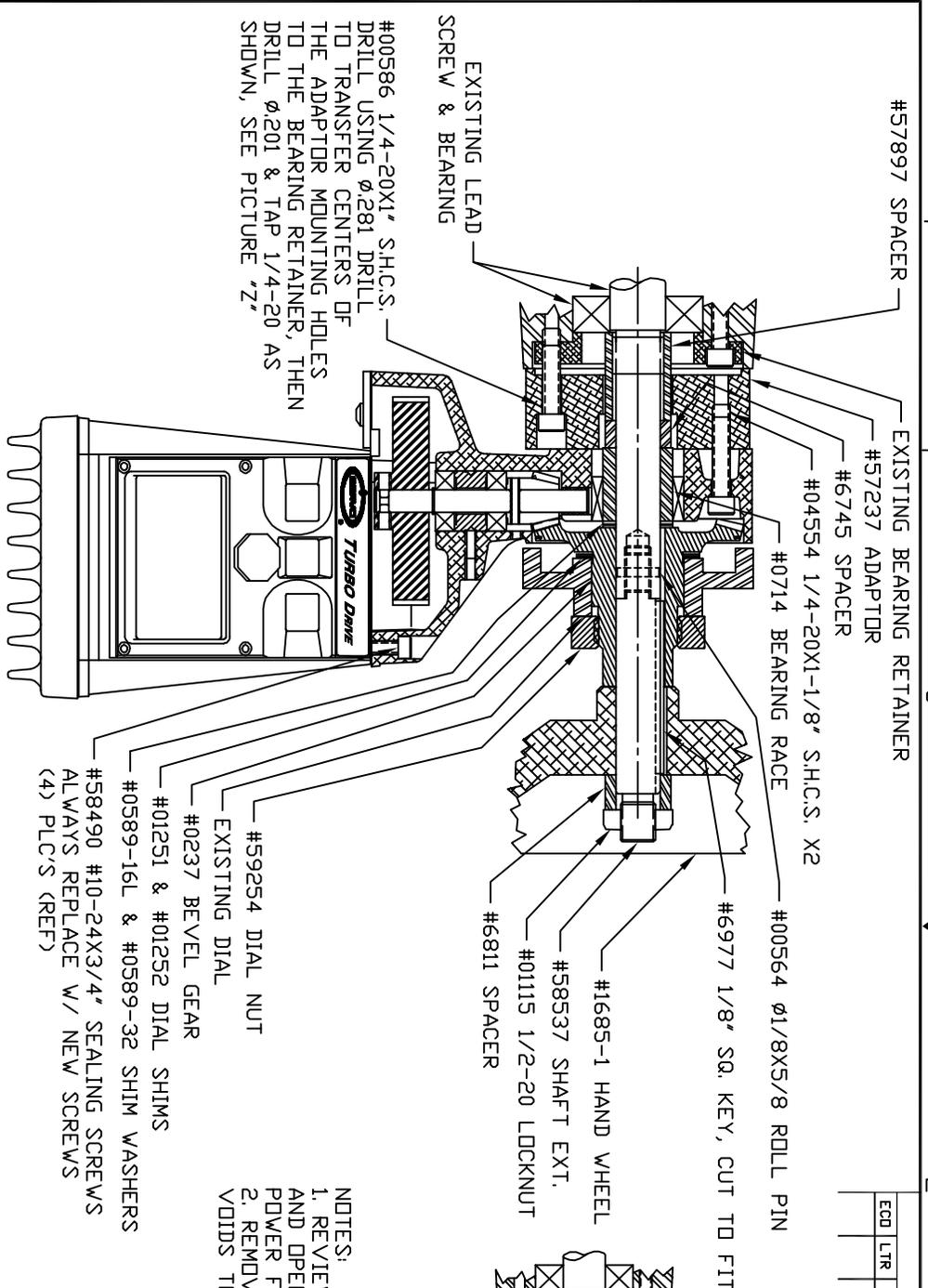


SERVO PRODUCTS COMPANY

BEVEL GEAR INSTALLATION

NA-58496

REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



PICTURE "Z"  
SCALE: 15/32

NOTES:  
1. REVIEW ALL INSTALLATION INSTRUCTIONS AND OPERATION SHEETS BEFORE TURNING ON SERVO POWER FEED.  
2. REMOVAL OF MOTOR, KEY PAD AND BOTTOM HOUSING VOIDS THE WARRANTY.

UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUNDNESS, CONCENTRICITY, CYLINDRICITY TO BE WITHIN ± TOTAL OR ±0.00/ft. REMOVE SHARP CORNERS AND EDGES .005 MIN. DIMS. STAMPED PER ANSI Y14.5M-1982

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CONTRACT NO.	APPROVALS	DATE
	T. KU	9/17/99

DRAWN	CHECKED
T. KU	

FINISH	COMPUTER NO.

SIZE	CODE IDENT NO.	DRAWING NO.	REV.
B	0800-80811	58839	

INSTALLATION DRAWING,  
MODEL 4380T  
SHARP

SERVO PRODUCTS COMPANY  
34940 LAKELAND BLVD., EASTLAKE, OHIO 44095

UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUNDNESS, CONCENTRICITY, CYLINDRICITY TO BE WITHIN ± TOTAL OR ±0.00/ft. REMOVE SHARP CORNERS AND EDGES .005 MIN. DIMS. STAMPED PER ANSI Y14.5M-1982

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APPLICATION	USED ON

SCALE	SHEET	OF
B	58839	