POWER FEED INSTALLATION  
Model M-4900 Table Feed  
Clausing Kondia  

REFERENCE DRAWINGS ENCLOSED  
NA-5444  Bevel Gear Installation  
NB-6236  Power Feed Installation  
ND-6293  Type 150 Servo Drive  
ND-6292  Type 140 Servo Drive  
0800-80001  Servo Power Feed Operation

PREPARATION  

*Step 1:* Remove the nut, handcrank, dial assembly, and key from the right-hand end of the table.  

*Step 2:* Remove the bearing retainer from the end bracket and replace with the bearing retainer provided.

POWER FEED INSTALLATION  

*Step 1:* Slide the bearing race and adaptor onto the lead screw and secure to the bearing retainer with 1/4-20 x 1/2" long socket head cap screws. Remove bearing race.  

*Step 2:* Screw the shaft extension onto the lead screw and tighten.  

*Step 3:* Using the hole provided as a pilot, drill 1/8" diameter through the shaft and pin in place using the 1/8 diameter x 5/8" long roll pin. File smooth.  

*Step 4:* Slide the spacer and bearing race onto the lead screw.  

*Step 5:* Secure the power feed to the adaptor using 1/4-20 x 1" long socket head cap screws.  

BEVEL GEAR INSTALLATION  

*Step 1:* Use the woodruff key provided and slide the bevel gear in place.  

*Step 2:* 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. Two plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.  

*Step 2:* In the following sequence, put on the dial locking nut, slide the handle in place, and tighten with the 1/2-20 lock nut.
LIMIT SWITCH INSTALLATION

Step 1: Install the limit switch as shown on the installation drawing ND-6236.

Step 2: 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 3: Secure the cable using the cable clamp provided. Use the screw provided to attach the clamp to the right-hand side of the chip scraper.

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
Web: www.servoproductsco.com

CALIFORNIA BRANCH
14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800  Fax 626.961.2444

HEADQUARTERS
34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999  Fax 440.942-9100

FLORIDA BRANCH
8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555  Fax 727.585.6555
**STEP 1**
PREPARATION

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

**STEP 2**
SHIMMING BEVEL GEAR

**INSTALL HANDCRANK.**

**MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.**

**ROTATE GEAR FROM SIDE TO SIDE. REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN 0.015/0.025 BACKLASH.**

**PUSH BEVEL GEAR AGAINST SHIMS.**

**TIGHTEN NUT.**

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

**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**

**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.

**SERVOD PRODUCTS COMPANY**

**BEVEL GEAR INSTALLATION**

NA-5444 C
Operations Before Turning On Servo Power Feed.

Notes: 1. Review All Installation Instructions And Power Feed.