

POWER FEED INSTALLATION

Model M-5000 Table Feed

Acra 9x45, 10x54 and Concord



REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-6295	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Operation

PREPARATION

- Step 1:* Move the table to the extreme left.
- Step 2:* Remove the nut, handle, and dial assembly from the right-hand end of the table.
- Step 3:* Remove the four cap screws holding the bearing housing in place.
- 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 bearing race onto the lead screw.
- Step 2:* Slide the adaptor with the power feed onto the bearing race and push flush to the end of the table.

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

- Step 3:* With the table in the extreme left-hand position, install the adaptor #0239-4 with 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 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, replace the key (if removed), dial, and dial locking nut. Slide the handle in place and tighten with 1/2-20 lock 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 two cap screws holding the T-shaped table stop. Install the limit switch using the two existing socket head cap screws.

Step 3: 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 4: Put the cable clamp on the cable and secure to 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

Web: www.servoproductsco.com

CALIFORNIA BRANCH

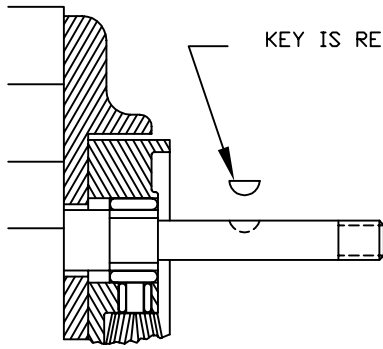
14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

HEADQUARTERS

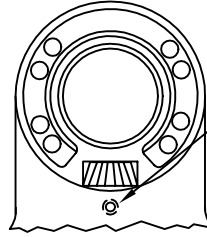
34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555

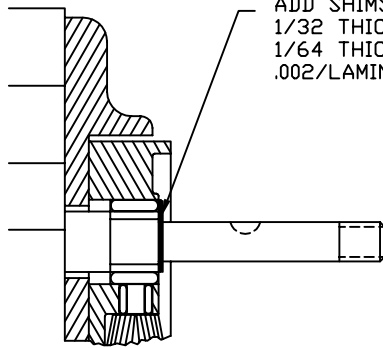


KEY IS REMOVED DURING SHIMMING

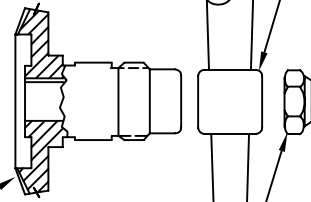


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1
PREPARATION



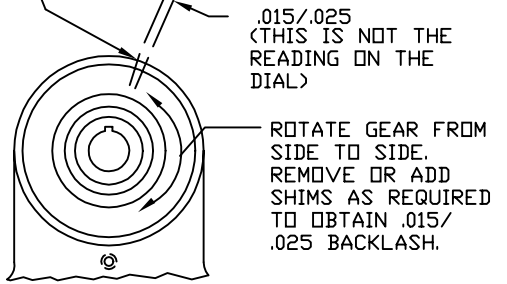
ADD SHIMS PROVIDED
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION



PUSH BEVEL GEAR
AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR
WITH PENCIL TO CHECK BACKLASH.



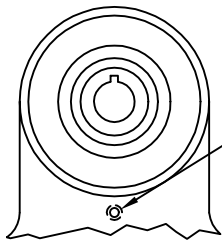
.015/.025
(THIS IS NOT THE
READING ON THE
DIAL)

ROTATE GEAR FROM
SIDE TO SIDE.
REMOVE OR ADD
SHIMS AS REQUIRED
TO OBTAIN .015/
.025 BACKLASH.

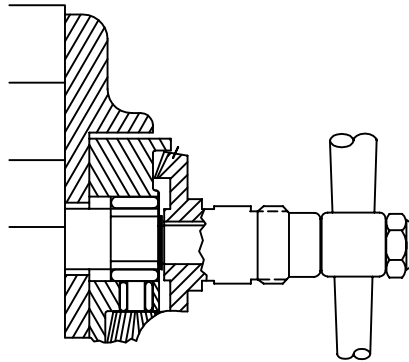
TIGHTEN NUT.

STEP 2
SHIMMING BEVEL
GEAR

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



LOOSEN SETSCREW

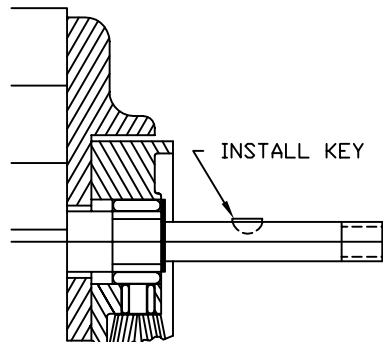


WITH POWER FEED IN
NEUTRAL POSITION, TURN
HANDCRANK. IF EXCESSIVE
GEAR NOISE OR BINDING
OCCURS, SHIMS NEED TO BE
ADDED. WHEN ADDING SHIMS,
REPEAT STEPS 1 AND 2.



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.

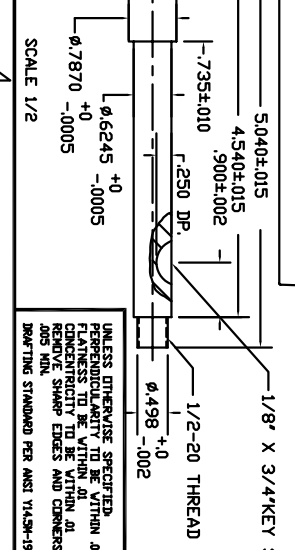
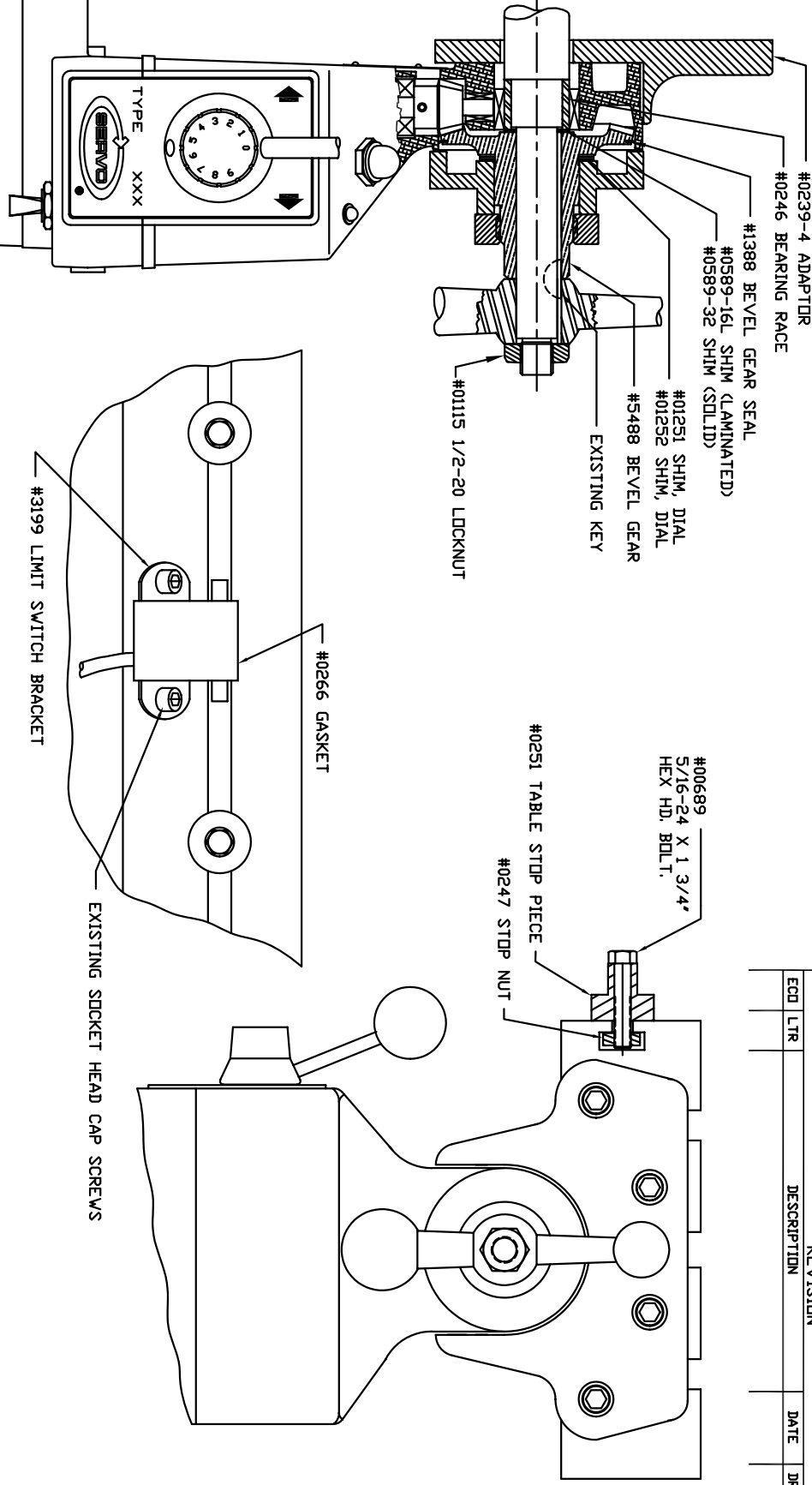
SERVO PRODUCTS COMPANY

BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



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

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVOD PRODUCTS COMPANY WHICH MAY NOT BE DISCLOSED TO OTHERS WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVOD PRODUCTS COMPANY.

CONTRACT NO.	APPROVALS	DATE
	BRAUN G. BUNN	6/26/95

SERVOD PRODUCTS COMPANY
 34940 LAKELAND BLVD., EASTLAKE, OH 44095
INSTALLATION DRAWING
 MODEL 5000 10 X 54
 9 X 45
 SIZE CODE IDENT. NO. DRAWING NO. REV.
 B 0800-80168 NB-6295 A
 SCALE 5/8 SHEET DF

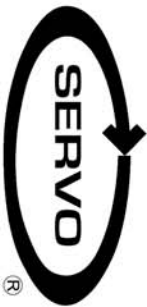
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS: DECIMALS ± 1/64 XX ± .005 ANGLES ± 1/2° MATERIAL NOTED CHECKED

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVOD PRODUCTS COMPANY WHICH MAY NOT BE DISCLOSED TO OTHERS WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVOD PRODUCTS COMPANY.







APPROVALS: BRAUN G. BUNN, DATE: 6/26/95







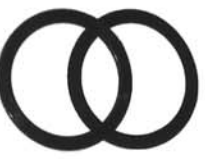

SIZE CODE IDENT. NO. DRAWING NO. REV.: B 0800-80168 NB-6295 A





SCALE 5/8 SHEET DF



M-5000 TABLE FEED PARTS IDENTIFICATION LIST

- 
00579
 Clamp
 Qty = 1
- 
01050
 Clamp
 Qty = 1
- 
00688
 Phil Pan Hd Screw
 Qty = 1
- 
0266
 Limit Switch Gasket
 Qty = 1
- 
3199
 Limit Switch Bracket
 Qty = 1
- 
06928
 Phil Pan Hd Screw
 Qty = 4

- 
00689
 Hex Hd Bolt
 Qty = 2
- 
0247
 Stop Nut
 Qty = 2
- 
0251
 Limit Stop
 Qty = 2
- 
01115
 Lock Nut
 Qty = 1
- 
59254
 Dial Nut
 Qty = 1
- 
01251
 Brass Shim
 Qty = 5
- 
01252
 Plastic Shim
 Qty = 2
- 
5488
 Bevel Gear
 Qty = 1

- 
0589-32
 .032 Shim
 Qty = 2
- 
0589-16L
 .016 Shim
 Qty = 2
- 
0246
 Bearing Race
 Qty = 1
- 
00586
 Soc Hd Cap Screw
 Qty = 2

- 
00595
 Roll Pin
 Qty = 2
- 
00596
 Roll Pin
 Qty = 2

