POWER FEED INSTALLATION
Model M-5600 Table Feed
Johnford MV54

REFERENCE DRAWINGS ENCLOSED
NA-5444 Bevel Gear Installation
NB-6721 Power Feed Installation
ND-6293 Type 150 Servo Power Feed
ND-6292 Type 140 Servo Power Feed
0800-80001 Servo Power Feed Operation

PREPARATION

Step 1: Gather together the following items that you will need to complete this installation.
   a) soft hammer
   b) 3/4” socket wrench
   c) set of inch hex wrenches
   d) grease
   e) clean shop rag

Step 2: Move the table to the extreme left.

Step 3: Remove the nut, handle and dial assembly from the right-hand end of the table.

Step 4: Remove the four cap screws holding the bearing housing in place.

Step 5: Using a soft hammer, tap the bearing housing off. Clean the end surface of the table.

POWER FEED INSTALLATION

Step 1: With the table in the extreme left-hand position, install the adaptor #0239 with the four cap screws. (On some mills the drive pin holes do not line up with the adaptor. Remove pins. The four cap screws will suffice.)

Step 2: Slide the bearing race onto the lead screw.

Step 3: Slide the power feed onto the bearing race and push flush to the end of the adaptor. Secure with two (2) 1/4-20 x 1.0" socket head cap screws.

BEVEL GEAR INSTALLATION

Step 1: Follow the drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

DIAL AND HANDCRANK 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 replace key if removed, dial and dial locking nut. Slide handle in place and tighten with locking nut.

**LIMIT SWITCH INSTALLATION**

**Step 1:** Remove the stop pieces and install the stop pieces furnished. Put 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. Place limit switch spacers into the tee stop and install the limit switch using 3/8-16 x 1-1/4” cap screws.

**Step 3:** The T-stop is retained to act as a positive stop where required for manual operation.

➤ **NOTE** For proper electrical operation the limit switch should be engaged .40 inch before the mechanical stop to allow for coasting of the table. The T-stop is often not symmetrical and may need to be ground for 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.

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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.

0.015/0.025
THIS IS NOT THE
READING ON THE
DIAL.

STEP 2
SHIMMING BEVEL GEAR

PUSH BEVEL GEAR
AGAINST SHIMS.

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

TIGHTEN NUT.

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

LOosen SETSCREW

STEP 3
DOUBLE CHECK OF SHIMMING

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

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BEVEL GEAR INSTALLATION
NA-5444 C

REMOVE GEAR, PACK WITH GREASE.
(DO NOT USE SILICONE TYPE GREASE)
REPLACE GEAR.
(Do NOT lose ANY SHIMS)

PICTURES IN THIS DRAWING ARE FOR
REFERANCE ONLY. SEE INSTALLATION
DRAWING OF CORRESPONDING MODEL
FOR EXACT PARTS CONFIGURATION.