POWER FEED INSTALLATION
Model M-6500 Table Feed
Victor 16VSK or VK

REFERENCE DRAWINGS ENCLOSED
NA-5444 Bevel Gear Installation
NB-6876 Power Feed Installation
ND-6293 Type 150 Servo Drive
ND-6292 Type 140 Servo Drive
0800-80001 Servo Power Feed Operation

POWER FEED INSTALLATION

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: Slide spacer #6875 (with counterbored end against the lead screw support bearing) and bearing race #0682 onto the lead screw shaft.

Step 4: Slide the power feed over the bearing race and push it against the bearing housing.

Step 5: Select three mounting holes on the feed and transfer the hole locations to the bearing housing. Drill and tap 1/4-20 holes by 1/2" deep threads.

Step 6: Screw shaft extension #0683 onto the lead screw and tighten.

Step 7: Using the cross hole on the shaft extension as a pilot, drill 1/8 diameter through and pin in place using the 1/8 x 5/8" long roll pin. Both ends of the roll pin must be flush or below the shaft surface. File if necessary. Sand smoothly to maintain proper shaft diameter.

Step 8: Thoroughly clean all parts and lubricate.

Step 9: With the table in the extreme left-hand position, install the power feed using the three 1/4-20 x 1-3/4" long socket head cap screws.

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

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. Four washers are provided for this, two solid and two laminated. Shim as required.

Step 2: Screw the dial nut #2255 onto the bevel gear. Screw the spacer #6811 onto the shaft. Install the woodruff key #00791 and slide the existing handle onto the shaft. Screw the locking nut onto the shaft and tighten.

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. Place the limit switch spacers into the T-stop and install limit switch using 3/8-16 x 1-1/4" long socket head cap screws. See drawing NB-6876.

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
433 North Fair Oaks Avenue, Pasadena, CA 91103 USA
Phone: 800.521.7359 or 626.796.2460 Fax: 626.796.3845
Web: www.servoproductsco.com
Call for the location of our regional Service Centers.
**STEP 1**
PREPARATION

**STEP 2**
SHIMMING BEVEL GEAR

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

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.

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

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**
NOTES:

1. Review all installation instructions and power feed.

OPERATIONS BEFORE TURNOFF ON SERVO POWER FEED:

#00589-32 SOLID SHIM
#00589-16L LAMINATED SHIM

#5255 DIAL NUT

#0683 SHORT EXTENSION

#5881 SPACER

#0688 BEVEL GEAR

#0125 SHIM WASHER DIAM

#0125 SHIM WASHER DIAM

#0683 BEARING RACE

EXISTING BEARING HOUSING