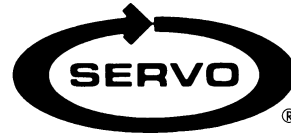


POWER FEED INSTALLATION

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.

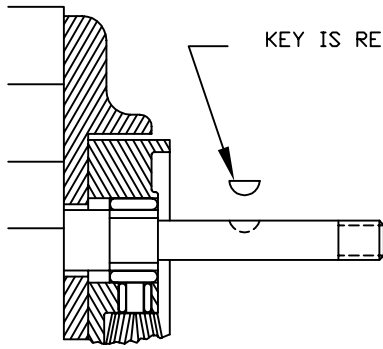
Clearances between the surfaces of the hand crank and the non-moving parts of the equipment on which the hand crank is installed must be at least one-fourth inch (1/4") to prevent injury. Modification of existing hand crank or replacement may be required.

Do not operate without proper clearance!

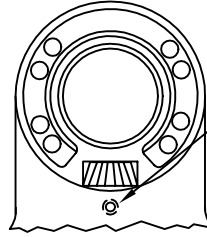
Prevent contact during fast traverses.

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.

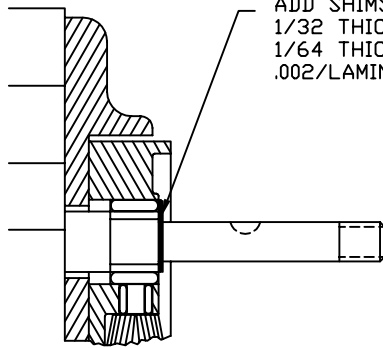


KEY IS REMOVED DURING SHIMMING

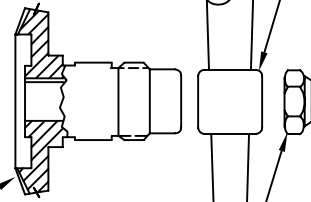


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1
PREPARATION



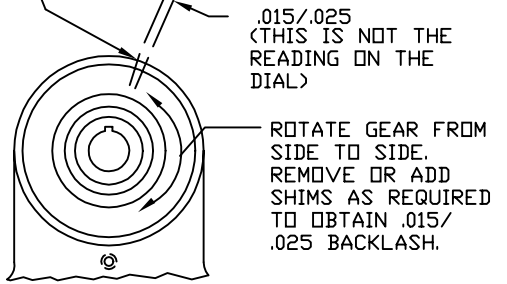
ADD SHIMS PROVIDED
1/32 THICK ARE SOLID
1/64 THICK ARE LAMINATED
.002/LAMINATION



PUSH BEVEL GEAR
AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR
WITH PENCIL TO CHECK BACKLASH.



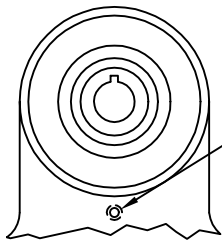
.015/.025
(THIS IS NOT THE
READING ON THE
DIAL)

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

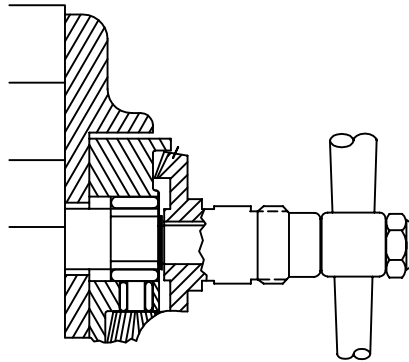
TIGHTEN NUT.

STEP 2
SHIMMING BEVEL
GEAR

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



LOOSEN SETSCREW

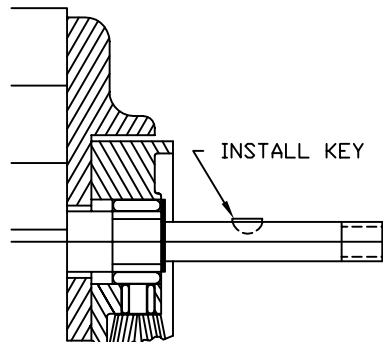


WITH POWER FEED IN
NEUTRAL POSITION, TURN
HANDCRANK. IF EXCESSIVE
GEAR NOISE OR BINDING
OCCURS, SHIMS NEED TO BE
ADDED. WHEN ADDING SHIMS,
REPEAT STEPS 1 AND 2.



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)

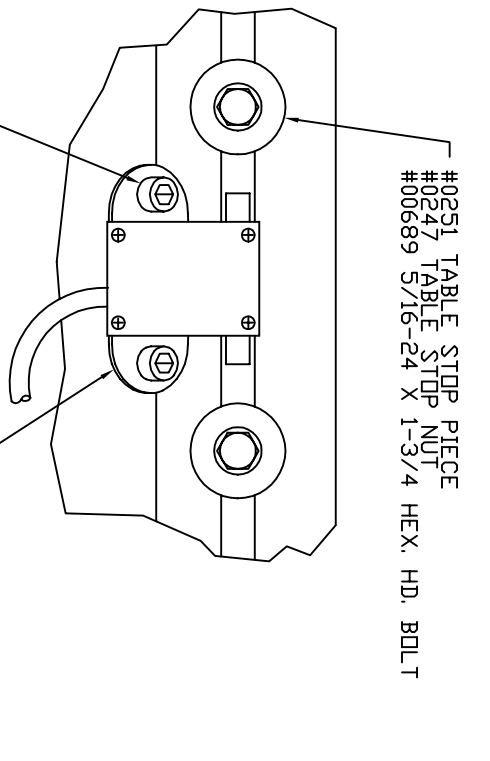
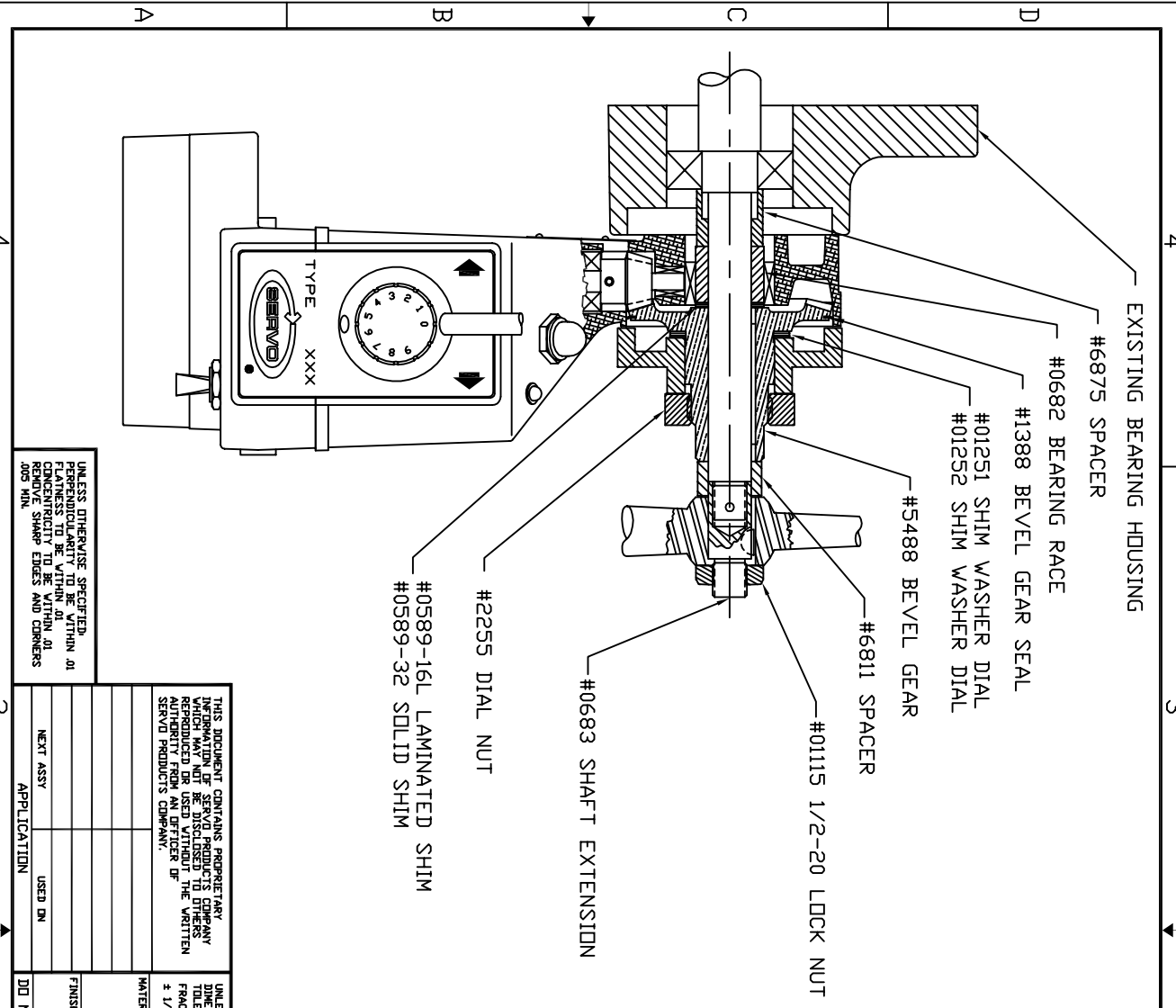
PICTURES IN THIS DRAWING ARE FOR
REFERENCE ONLY. SEE INSTALLATION
DRAWING OF CORRESPONDING MODEL
FOR EXACT PARTS CONFIGURATION.

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BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4
LUBRICATION




NOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON SERVO POWER FEED.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE WITHIN 0.1 FLATNESS TO BE WITHIN 0.1 CONCENTRICITY TO BE WITHIN 0.1 REMOVE SHARP EDGES AND CORNERS 0.05 MIN.

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS ANGLES ± 1/64 .XX ± .05 ± 1/2 DEG. MATERIAL FINISH NOTED

CONTRACT NO.	APPROVALS	DATE
	DRAWN J. TUCKER	2/11/97
	CHECKED	


SERVO PRODUCTS COMPANY
 433 N. FAIR OAKS AVE., PASADENA, CALIFORNIA 91109
MODEL 6500
INSTALLATION DRAWING
 VICTOR 16VSK OR VK
 SIZE CODE IDENT. NO. DRAWING NO. NB-6876
 SCALE 5/8 SHEET 1 OF 1

A B C D 4 3 2 1