POWER FEED INSTALLATION  
Model M-6550 Cross Feed
Victor 16VSK or VK

REFERENCE DRAWINGS ENCLOSED
NA-5444  Bevel Gear Installation
NB-1538  Limit Switch Installation
NB-6877  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, dial hub, and key from the lead screw.

Step 2: Place the adaptor plate #6859 onto the existing bearing housing.

Step 3: Transfer three mounting holes from the adaptor plate to the bearing housing. Drill and tap 1/4-20 by 1/2" deep threads.

Step 4: Secure the adaptor plate to the bearing housing using the 1/4-20 x 1/2" long socket head cap screws. Torque all three screws to 120 in-lb.

DRIVE UNIT INSTALLATION

Step 1: Screw the shaft extension onto the lead screw and tighten.

Step 2: 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 remove burr.

Step 3: Slide the spacer #6235 and the bearing race #0682 onto the lead screw.

Step 4: Secure the power feed to the adaptor using the 1/4-20 x 1-1/8" 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. Four washers are provided for this, two solid and two laminated. Shim as required.

Step 2: In the following sequence, put on the dial locking nut, add spacer, insert the key, slide the existing handcrank and washer in place. Secure with the lock nut provided.
LIMIT SWITCH INSTALLATION

Step 1: See limit switch installation drawing NB-1538 enclosed.

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.
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
(THE 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.

STEP 2
SHIMMING BEVEL GEAR

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.

SERVO PRODUCTS COMPANY

BEVEL GEAR INSTALLATION

NA-5444 C
NOTES:
1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON SERVO POWER FEED

2. SEE DRAWING DD339 FOR INSTALLATION OF LIMIT SWITCH.

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#005L4 1/8 DIA. X 5/8 LC ROLL PIN

#059S-16L 3M X 5/8 LC KEY

#102S1 1/2-20 LOCK NUT

#6859 SHAFT EXTENSION

#5488 BEVEL GEAR

#225S DIAL NUT

#059S-25 SHIM WASHER

#1388 BEVEL GEAR SEAL

#0685 BEARING RACE

#6255 SPACER

#4-20 X 1/2 SHCS #0675(3)
INSTALLATION DRAWING

LIMIT SWITCH CROSS FEEDS

NOTES:

1. CROSS TRAVEL STOP ASSEMBLY MAY BE MOUNTED ON EITHER SIDE OF KNEE.

2. WHEN MILL IS ASSEMBLING ATTACHMENT MOUNT LIMIT SWITCH. STOPS A TRACK ON OPP. SIDE.

3. REFER TO DRAWING ONLY. INSTALLATION SHOWN IS A REFERENT MILL.

STOP BAR & ANCHOR

- OZ CLEARANCE BETWEEN

- 6& APPROX.

5/16-18 UNC X 2 HOLE

- 1/2 CLEARANCE

MOUNTED ON LEFT SIDE OF SADDLE

MOUNTED ON LEFT MOUNTING ONLY

ON LEFT HAND MOUNTING ONLY

rear head screws & cover used

unit switch box using A-117 cover

& attach to bar from saddle. Install

remove cover from unit switch box

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