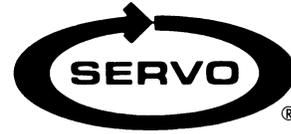


POWER FEED INSTALLATION

Model M-6600 Table Feed

Edison Mill



REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-6888	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 with the four cap screws. (On some mills the drive pin holes do not line up with the adaptor. Remove the pins. The four cap screws are sufficient.)

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

Step 3: Slide the power feed onto the bearing race and push it flush to the end of the adaptor. Secure with two 1/4-20 x 1" long 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 HANDWHEEL 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 the key (if removed), dial and dial locking nut and spacer #2981. Slide the handle in place and tighten with locking nut.

LIMIT SWITCH INSTALLATION

Step 1: Remove the standard stop pieces. Install the 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 bracket. Place the limit switch spacers into the T-stop and install limit switch using the two 3/8-16 x 1-1/4" long 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. Secure using 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

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Call for the location of our regional Service Centers.

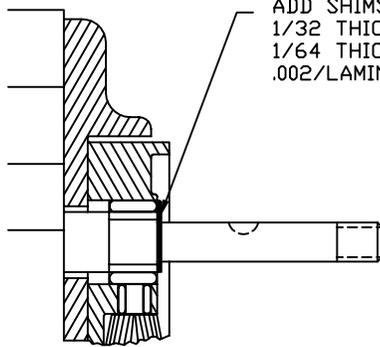


KEY IS REMOVED DURING SHIMMING



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

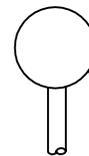
CAUTION: IF BACKLASH IS NOT PROPERLY SET BEFORE TURNING UNIT ON, BEVEL GEAR MAY BE DESTROYED.



LOOSEN SETSCREW

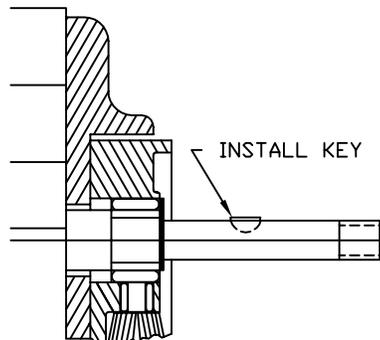


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.



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)

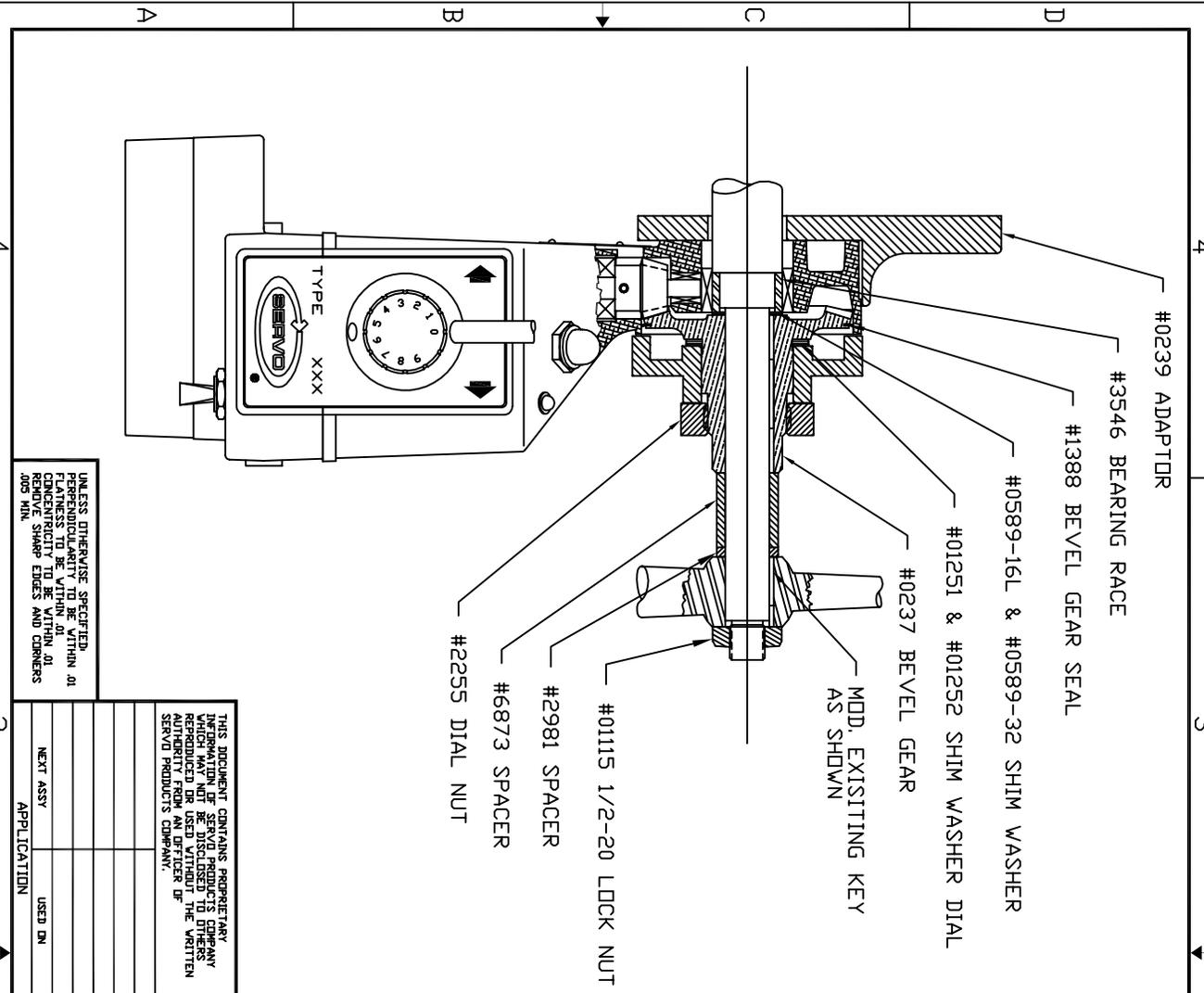
PICTURES IN THIS DRAWING ARE FOR REFERENCE ONLY. SEE INSTALLATION DRAWING OF CORRESPONDING MODEL FOR EXACT PARTS CONFIGURATION.

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BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4
LUBRICATION



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

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE WITHIN 0.100 MIN. FLATNESS TO BE WITHIN 0.005 IN. CONCENTRICITY TO BE WITHIN 0.010 IN. REMOVE SHARP EDGES AND CORNERS.

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± .005 ± 1/2° ± 1/2°

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


SERVO PRODUCTS COMPANY
 433 N. FAIR OAKS AVE., PASADENA CALIFORNIA 91103
MODEL 6600
INSTALLATION DRAWING
EDISON

SIZE	CODE IDENT. NO.	DRAWING NO.
B	0800-80375	NB-6888
SCALE 5/8		
SHEET 1	OF 1	

APPLICATION USED ON NEXT ASSY