POWER FEED INSTALLATION
Model M-9118 Table Feed
Alliant RT-50 and others

REFERENCE DRAWINGS ENCLOSED

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PREPARATION

Step 1: Move the table to the extreme left-hand position.

Step 2: Remove the nut, handle and dial assembly from the right hand end of the table.

Step 3: Remove the four cap screws from the bearing housing.

Step 4: Using a soft hammer, tap the bearing housing off. Clean the end surface of the table.

POWER FEED INSTALLATION

Step 1: Slide the bearing race onto the lead screw.

Step 2: Slide the adaptor and feed onto the bearing race.

Step 3: Secure the adaptor to the end of the table with the existing 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. Two plastic (.030” thick) and five brass (.005” thick) washers are provided for this. Shim as required.

Step 2: In the following sequence, put on the dial locking nut, place the key in the shaft, and slide the handcrank in place. Then add the 1/2-20 lock nut.

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 the feed stops from being set beyond the extreme table travel.

Step 2: Remove the two cap screws holding the T-shaped table stop bracket.
Step 3: Place the short spacers into the counterbored holes in the T-stop, place the limit switch assembly on the spacers, and locate using the M8 cap screws.

Step 4: 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.

Stop 5: Secure the cable using the cable clamp provided. Use the screw provided to attach the clamp to the right-hand side of the chip scraper.

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

STEP 2
SHIMMING BEVEL GEAR

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.

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

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

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

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
LIMIT SWITCH INSTALLATION

LIMIT STOP INSTALLATION

EXISTING DIAL
#9912 DIAL OUT
EXISTING HAND CRANK

#9912 DIAL IN
#9913 DIAL SHIM
#9913 DIAL SHIM (SOLID)
#9912 DIAL SHIM (MINIMUM)
#9925 DIAL SHIM
#9925 DIAL SHIM (MINIMUM)
#9926 BLANK CLEVIS END CHOKER
#9926 BLANK CLEVIS END CHOKER (MINIMUM)

 existing gear seal
#9999-2 ADAPTOR

NOTES: