

POWER FEED INSTALLATION

Model M-9118 Table Feed

Alliant RT-50 and others



REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-57535	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Operation

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.*

Step 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.

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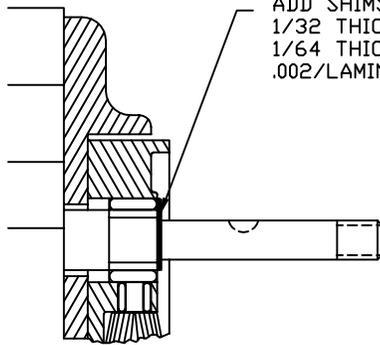


KEY IS REMOVED DURING SHIMMING



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

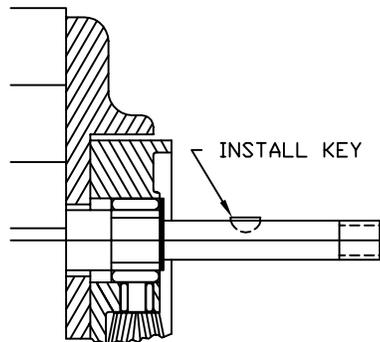


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.

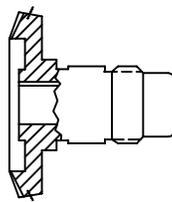


CONTROL HANDLE @ NEUTRAL POSITION

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.

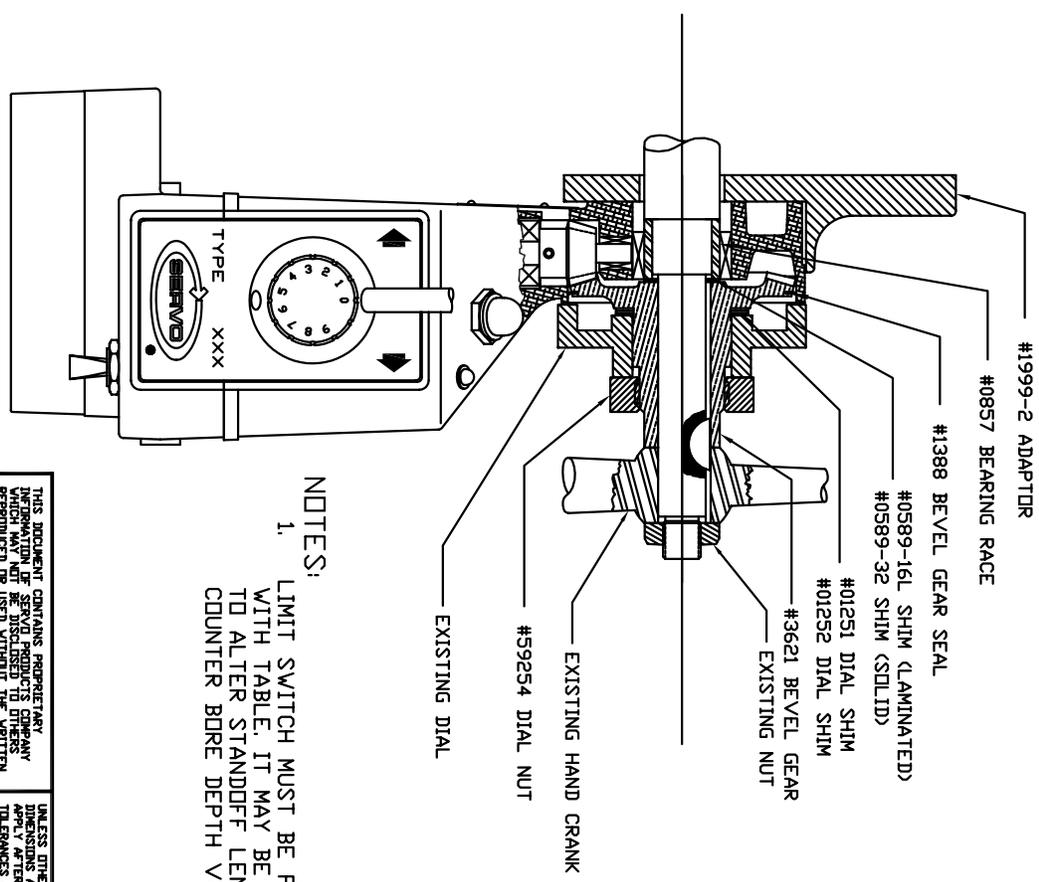
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BEVEL GEAR INSTALLATION

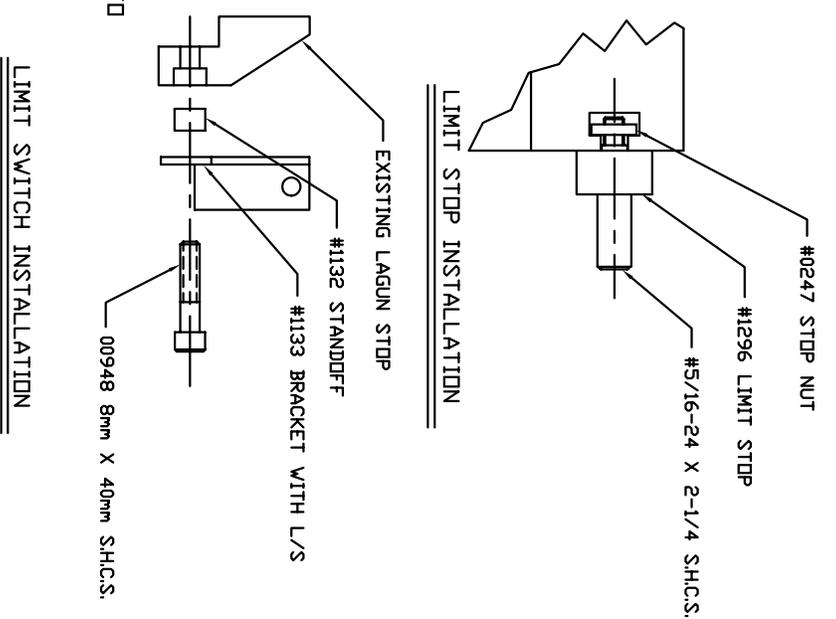
NA-5444 C

STEP 4
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



NOTES:
 1. LIMIT SWITCH MUST BE PARALLEL WITH TABLE. IT MAY BE REQUIRED TO ALTER STANDOFF LENGTHS DUE TO COUNTER BORE DEPTH VARIATIONS.



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE WITHIN 0.1 FLATNESS TO BE WITHIN 0.1 CONCENTRICITY TO BE WITHIN 0.1 0.05 MIN. DRAWING STANDARD PER ANSI Y14.5M-1992

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE FRACTIONS DECIMALS ANGLES	± 1/64	± .005	± 1/2°
MATERIAL	XX	XX	XX
FINISH			

CONTRACT NO.	APPROVALS	DATE
	BUNN	7/5/95
CHECKED		

SERVO PRODUCTS COMPANY
 34940 LAKELAND BLVD., EASTLAKE, OH 44095
INSTALLATION DRAWING
ALLIANT RT2-50
MODEL 9118

SIZE	CODE IDENT NO.	DRAWING NO.	REV.
B	0800-80520	NB-57535	A

COMPUTER NO. NS7535A.DWG
 SCALE 5/8
 SHEET 1 OF 1

4 3 2 1