

DYNAMO FEED INSTALLATION

Model D1000-1500 Table Feed

Lagun Mill



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 adapter and feed onto the bearing race.
- Step 3:* Secure the adapter to end of table with existing cap screws.

BEVEL GEAR INSTALLATION

- Step 1:* Install two of the thickest shim washers, then the bevel gear. Measure the gap between the back face of the gear and the front face of the power feed, as shown in FIG.A. Add, remove or replace shims as needed to obtain the .080/.085 in. (2.0 / 2.16 mm) measurement. Install the hand crank and nut. Check to see the measurement is still ok after the nut is tightened.
- Step 2:* With the feed in neutral turn hand crank. If it turns freely in one direction but catches in the other direction backlash is too large. If rough engagement is heard or felt in BOTH directions you need additional shims.

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 shim washers are provided for this. Shim as required.
- Step 2:* In the following sequence, put on the dial locking nut and slide the hand crank in place. Add the washer and the 1/2-20 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 feed stops from being set beyond extreme table travel.

Step 2: Remove the T-shaped table stop bracket and install limit switch using same screws. Spacers may be needed to space limit switch from table.

☐ NOTE For proper operation, the electrical limit switch should be engaged .4 inch before the mechanical stop to allow for coasting of the table.

Step 3: Secure the cable using the cable clamp provided. Attach the clamp to the right hand chip scraper screw.

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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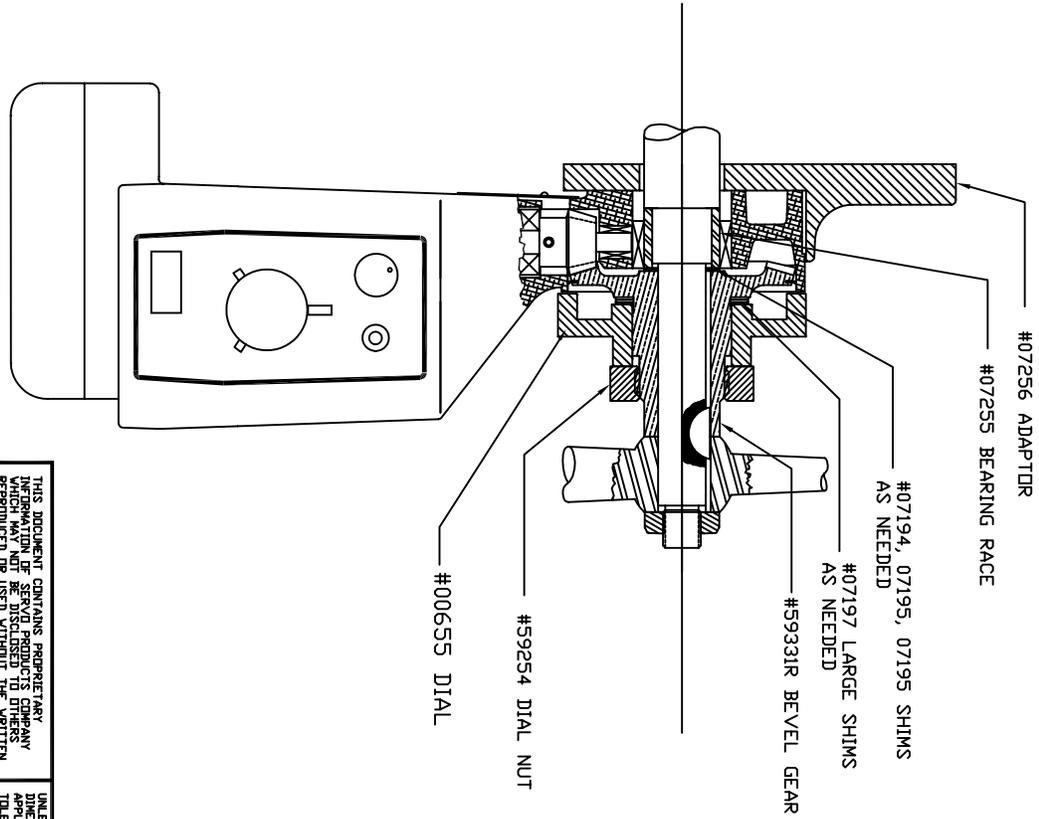
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REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				



UNLESS OTHERWISE SPECIFIED, FINISHES TO BE WITHIN .01 FLATNESS TO BE WITHIN .01 CONCENTRICITY TO BE WITHIN .01 REMOVE SHARP EDGES AND CORNERS .005 MIN. DIMETING STANDARD PER ANSI Y14.3M-1992

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APPLICATION	USED IN	NEXT ASSY

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

CONTRACT NO.	APPROVALS	DATE
	BIMBA	7/27/09
	CHECKED	

COMPUTER NO.	DID NOT SCALE DRAWING


SERVOPRODUCTS COMPANY
 34940 LABELAND BLVD., EASTLAKE, OH 44095
INSTALLATION DRAWING
LAGUN
MODEL 1500
 SIZE CODE IDENT. NO. DRAWING NO. REV.
 B 0800-81013 NB-59644 A
 SCALE 5/8 SHEET DF