

DYNAMO FEED INSTALLATION

Model D1000-2300 Table Feed

Do All, Exacto, Maxmill, Select
and others



PREPARATION

- Step 1:* Move the table to the extreme left.
- Step 2:* Remove the nut, handle and dial assembly from the right-hand end of the table.
- Step 3:* Remove the four cap screws holding the bearing housing in place.
- Step 4:* 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.
- NOTE** *On some machines the drive pin holes do not line up with the adapter. Remove and discard the pins in such cases. The four cap screws are all that are necessary.*
- Step 2:* Slide the bearing spacer, then the bearing race onto the lead screw. Slide the power feed onto the bearing race and push flush to the end of the adaptor.
- NOTE** *Depending on the lead screw, the bearing race spacer may need to be shortened approximately 5/32" in order to get proper shimming of the bevel gear.*
- Step 3:* Secure the feed with two 1/4-20 x 1" socket head 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 handcrank and nut. Check to see the measurement is still ok after the nut is tightened.
- Step 2:* With feed in neutral turn hand crank. If it turns freely one way but catches in the other direction, backlash is too large. Reduce the shim thickness. 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 washer are provided for this. Shim as required.

Step 2: In the following sequence, replace the dial and dial locking nut, slide the handle in place and tighten with the locking 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 and install the limit switch using original screws. Spacers may be required to space the limit switch from the table.

□ NOTE

Step 1: For proper operation, the electrical limit switch should be engaged .4 inch before the mechanical stop to allow for coasting of the table.

Step 2: Put the cable clamp on the cable and secure to the right-hand chip scraper screw.

OPERATION

See DYNAMO INSTALLATION & OPERATION MANUAL

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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CALIFORNIA BRANCH

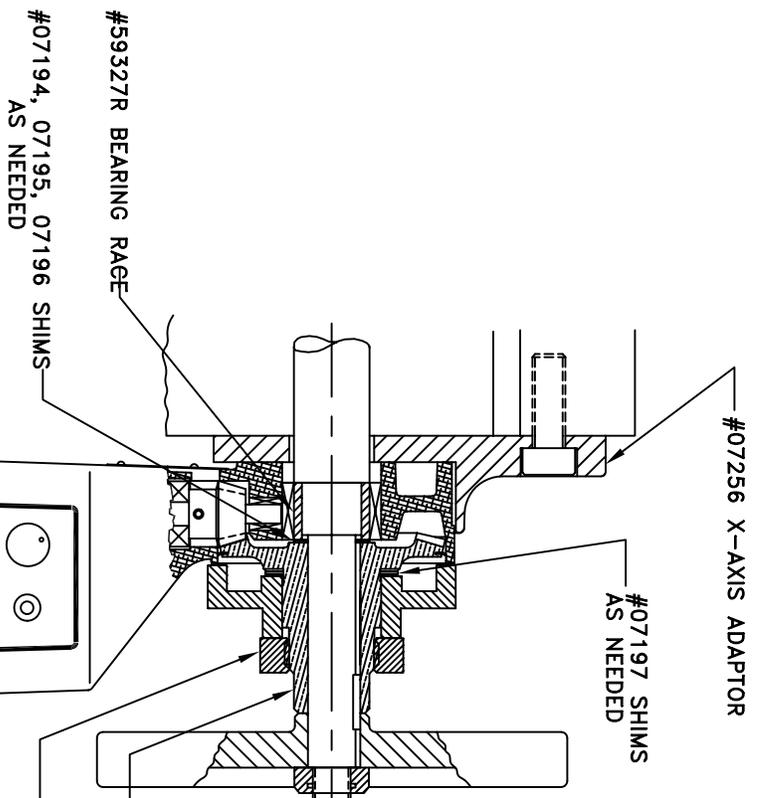
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NOTE:
 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATION INSTRUCTION BEFORE TURNING ON POWER FEED.

UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUNDNESS, CONCENTRICITY, CYLINDRICITY TO BE WITHIN .01 TOTAL OR .040/ft. SURFACE ROUGHNESS WITHIN 125 REMOVE SHARP CORNERS AND EDGES .005 MIN. DRAWING STANDARD PER ANSI Y14.5M-1982

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & DECIMALS ARE IN 1/64 FRACTIONS. ANGLES ARE IN DEGREES & MINUTES.	CONTRACT NO.
FINISH	APPROVALS
NOTED	DATE
DID NOT SCALE DRAWING	7/09/09
COMPUTER NO.	CHECKED


SERVOPRODUCTS COMPANY
 34940 LAKELAND BL. EASTLAKE OH 44095 USA
MODEL D1000-2300
INSTALLATION DRAWING
 SIZE: B CODE IDENT NO: 0800-80988 DRAWING NO: NB-59619 REV. 1
 SCALE: B SHEET: 1 OF 4