

DYNAMO FEED INSTALLATION

D1000-2350/2358 Cross Feed

Exacto, Maxmill, Supermax (2350)
Do All (2358)



PRERARATION

- Step 1:* Remove the nut, crank, dial assembly, and key from the lead screw.
- Step 2:* Slide the bearing race onto the lead screw. Slide the power feed over the bearing race. Line up the feed so that it sits square to the bearing housing. Using the power feed as a template, spot two holes in the bearing retainer plate.
- Step 3:* Remove the power feed and bearing race.
- Step 4:* Remove the four screws securing the bearing housing and remove from the mill. (The lead screw can now be used to jack the housing off the pins. The lead screw does not have to be removed from the mill.)
- Step 5:* Drill and tap two holes 1/4-20 x 7/8 deep.
- Step 6:* Reinstall the bearing housing back onto the mill.

POWER FEED INSTALLATION

- Step 1:* Screw the shaft extension to the lead screw and tighten. Using the hole provided as a pilot, drill 1/8 diameter through and pin the shaft extension in place using the 1/8 x 5/8 long roll pin. File smooth.
- Step 2:* Slide spacers and bearing race onto the lead screw.
- Step 3:* Slide the power feed onto the bearing race and secure with two 1/4-20 x 1-1/2" socket head cap screws.

BEVEL GEAR INSTALLATION

- Step 1.* Turn the leadscrew CW to ensure the leadscrew is extended out fully and shouldered against the bearing
- Step 2:* 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. of the INSTALLATION & OPERATION MANUAL. Add, remove or replace shims to obtain the .080/.085 in. (2.0 / 2.16 mm) dimension. Install the spacer, handcrank, and nut. Check that the dimension is still ok after the nut is tightened.
- Step 3:* With feed in neutral, turn hand crank. If it turns freely in one direction but catches in the other, the backlash is too large. Reduce the thickness of the shims. If rough engagement is heard or felt in BOTH directions you need additional shims.

DIAL AND HANDWHEEL 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, replace the dial and dial locking nut. Place the 4 mm key in the shaft extension and slide the handwheel onto shaft extension. Secure with the washer and locking nut provided.

LIMIT SWITCH INSTALLATION

Refer to the D-1000Y INSTALLATION & OPERATION MANUAL

OPERATION

See 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

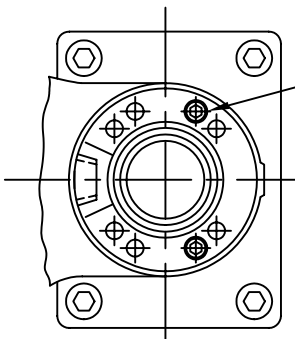
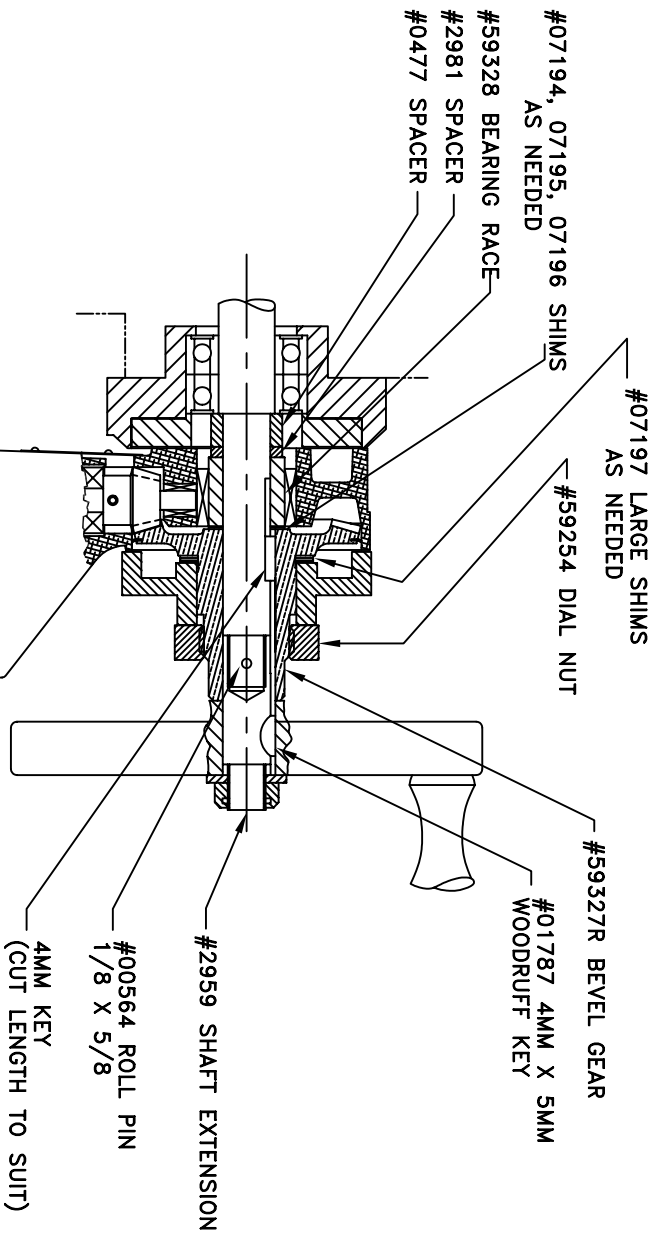
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- NOTE:**
1. DRILL AND TAP TWO HOLES 1/4-20 X 7/8 DEEP INTO BRACKET WITH CLEARANCE HOLES IN BEARING CAP (2 PLC'S.)
 2. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATION BEFORE TURNING ON POWER FEED.

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

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SERVOD PRODUCTS COMPANY
 34940 LAKELAND BL. EASTLAKE OH 44095 USA
MODEL 2350
INSTALLATION DRAWING
 SIZE CODE IDENT. NO. DRAWING NO. REV.
 B 0800-80959 NB-59620
 SCALE SHEET DF