

DYNAMO FEED INSTALLATION

Model D1000-2700 Table Feed

Hartford, Marena 942, Newport,
Webb, and others



PREPARATION

- Step 1:* Move the table to the extreme left-hand position.
- Step 2:* Remove the nut, handle, dial assembly, and key from the lead screw. Save the key for installation later.
- Step 3:* Remove the four cap screws from the bearing housing. Save the screws for installation later.
- 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 shaft spacer #5426, the bearing race #07159, and the second shaft spacer #5426 onto the lead screw.
- Step 2:* Slide the adaptor with the feed onto the bearing race.
- Step 3:* Secure the assembly to the end of the table with the saved 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.

IF: If necessary turn the second shaft spacer #5426 to the proper length. If the key does not engage the bevel gear, use provided spring pin #00596 as shown on the installation drawing NB-2778, detail A.

Step 2: With feed in neutral turn hand crank. If it turns freely in one direction but catches in the other direction backlash is too large. Reduce 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 washers are provided for this. Shim as required.

Step 2: Secure the dial using the dial nut. Slide the hand crank onto the end of the lead screw and tighten with the 1/2-20 lock nut.

LIMIT SWITCH INSTRUCTIONS

Step 1: Remove the standard table stop pieces and install the table stop pieces furnished. Put the standard stop back in position to prevent feed stops from being set beyond extreme table travel.

Step 2: Remove the T-shaped table stop piece and install limit switch using existing screws. Spacers may be required 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: Put the cable clamp on the cable and secure using 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.

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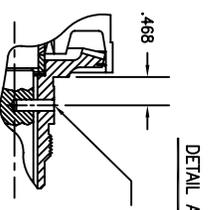
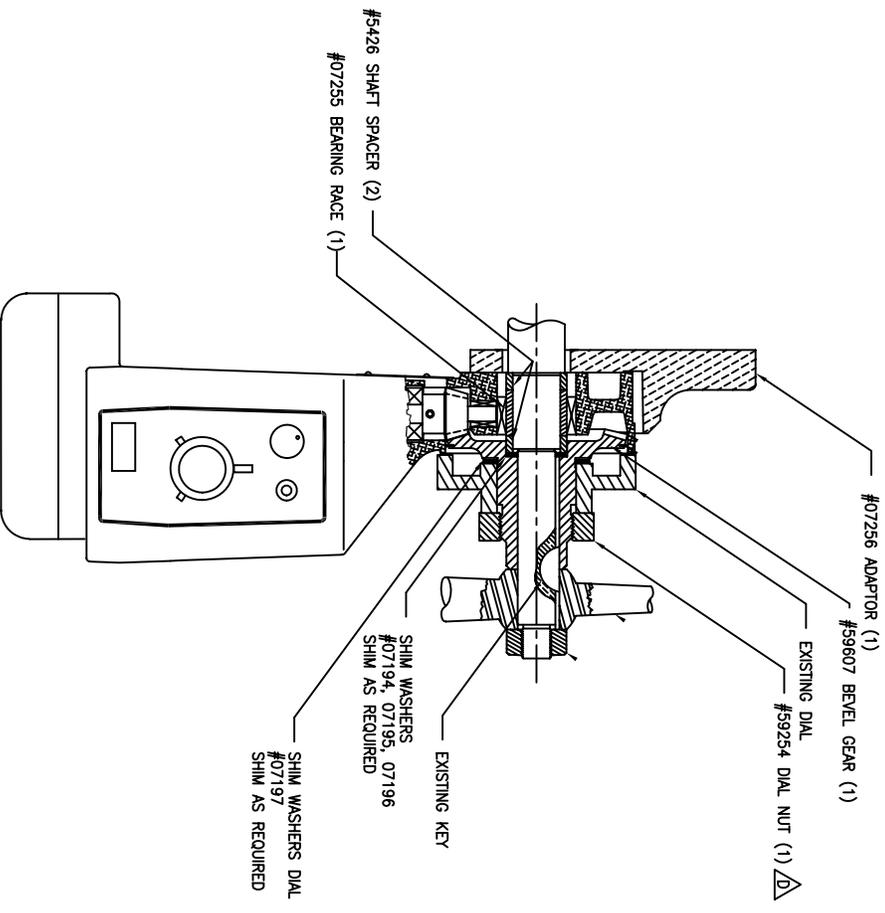
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REVISION		DATE	DRAWN	CHECKED
ECD	LTR	DESCRIPTION		



#00596 ROLL PIN
 DRILL ϕ .188 X .75 DP AFTER THE PROPER SHIMMING HAS BEEN DETERMINED.
 PIN WILL BE INSTALLED ONLY IF KEY DOES NOT ENGAGE BEVEL GEAR.

NOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATIONS BEFORE TURNING ON POWER FEED.

UNLESS OTHERWISE SPECIFIED, FINISH SHALL 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 AS FOLLOWS FRACTIONS DECIMALS ANGLES \pm 1/64 .XX \pm .005 \pm 1/2°	CONTRACT NO.	DATE
	APPROVALS	BIMA 7/09/09
FINISH	DRAWN	CHECKED
NOTED		
DID NOT SCALE DRAWING	COMPUTER NO.	

SERVVO PRODUCTS COMPANY
 34940 LABELAND BLVD, EASTLAKE, OHIO 44095

INSTALLATION DRAWING
MODEL 2700

SIZE	CODE IDENT NO.	DRAWING NO.	SHEET	OF
B	0800-80990	NB-59621	1	1

SCALE 1/2