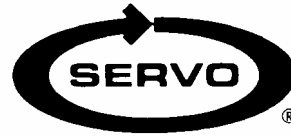


DYNAMO FEED INSTALLATION

Model D1000-3700 Table Feed

Alliant, Sharp First, 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 milling machine.
- Step 3:* Remove the four cap screws from the bearing housing. Save the screws.
- Step 4:* Using a soft hammer, tap the bearing housing off. Clean the end surface of the table.
- Step 5:* Remove the spacer.

POWER FEED INSTALLATION

- Step 1:* Slide the bearing race onto the lead screw.
- Step 2:* Mount the adapter plate on the power feed, then slide the power feed onto the lead screw and secure the assembly to the end of the table with the four saved 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 cap screws are all that is necessary.*

- Step 3:* With the table in the extreme left-hand position, tighten the four 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 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: In the following sequence, put on the dial locking nut and slide the handle in place. Add the 1/2-20 lock nut and tighten.

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 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 4: Put the cable clamp on the cable and secure using 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.

SERVO PRODUCTS COMPANY

Web: www.servoproductsco.com

CALIFORNIA BRANCH

14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

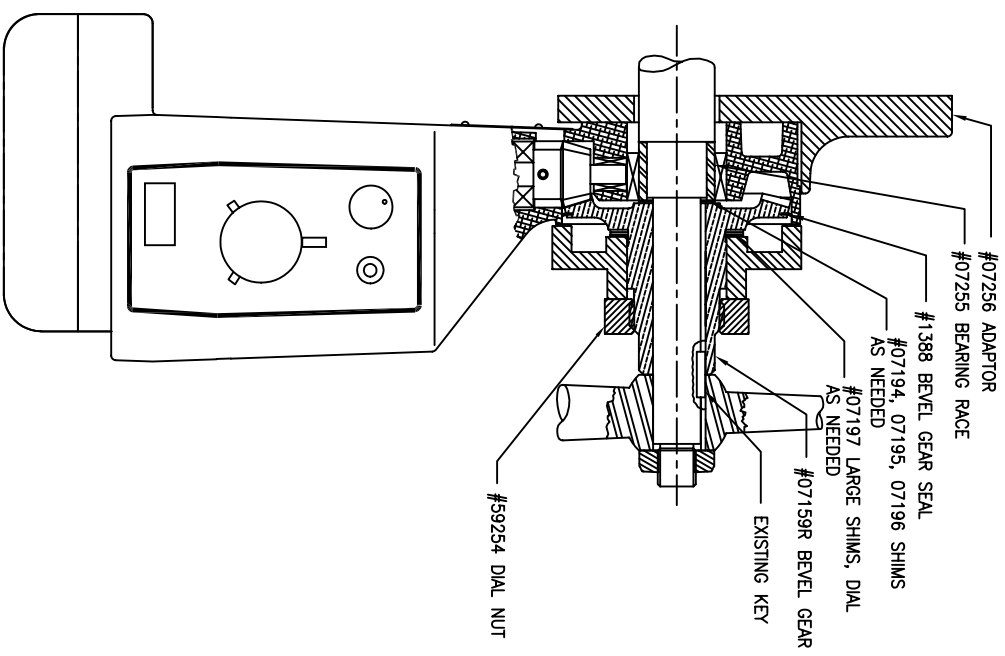
HEADQUARTERS

34940 Lakeland Blvd.
Eastlake, OH 44095
Ph. 440.942.9999 Fax 440.942-9100

FLORIDA BRANCH

8950 131st Ave. N.
Largo, FL 33773
Ph. 727.585.8555 Fax 727.585.6555


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SHARP FIRST & ALLIANT
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