

DYNAMO FEED INSTALLATION

Model D1000-9118 Table Feed

Alliant RT-50 and others



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:* Fasten the adaptor plate to the table with the four original cap screws but leave the screws slightly loose. Slide the power feed onto the bearing race and against the adaptor.
- NOTE:** On some machines the drive pinholes do not line up with the adaptor. Remove and discard the pins in such cases.
- Step 3:* Secure the power feed to the adaptor with two M6 x 25 mm long screws. Tighten the adaptor mounting 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. Two plastic (.030" thick) and five brass (.005" thick) washers are provided for this. Shim as required.
- Step 2:* Put on the dial locking nut.
- Step 3:* Place the key in the shaft (if removed).
- Step 4:* Slide the hand crank onto the end of the shaft, then install the 1/2-20 lock 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 the limit switch using the existing screws. A spacer may be required to space the limit switch from the 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. The T-stops are often not symmetrical and may need to be ground to obtain proper operation.*

Step 3: Put the cable clamp on the cable and secure using the right-hand chip scraper screw.

OPERATION

See Dynamo D-1000X INSTALLATION AND 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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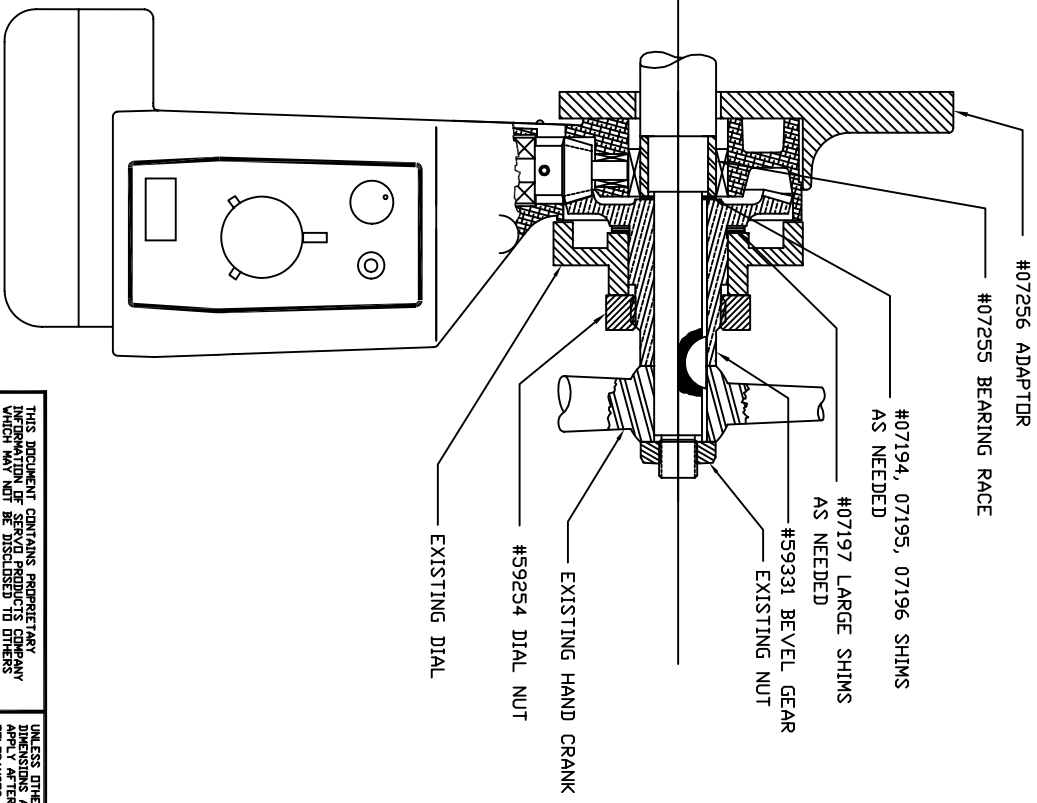
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REVISION		DATE	DRAWN	CHECKED
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DESCRIPTION				



UNLESS OTHERWISE SPECIFIED, FINISHES SHALL BE WITHIN 0.1 FLATNESS TO BE WITHIN 0.1 CONCENTRICITY TO BE WITHIN 0.1 REMOVE SHARP EDGES AND CORNERS 0.05 MIN. DIMETING STANDARD PER ANSI Y14.3M-1992

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & DECIMALS ARE TO BE IN 1/64 FRACTIONS. ANGLES $\pm 1/2^\circ$. MATERIAL XX $\pm .005$ FINISH

	CONTRACT NO.	APPROVALS	DATE
USED IN		DRAWN: BIMA	7/20/09
NEXT ASSY	APPLICATION	CHECKED	

SERV-O PRODUCTS COMPANY
 34940 LABELAND BLVD, EASTLAKE, OH 44095
INSTALLATION DRAWING
 ALLIANT RT2-50
 MODEL D1000-9118

SIZE	CODE IDENT NO.	DRAWING NO.	REV.
B	0800-81000	NB-59631	
SCALE 5/8		SHEET	OF

4 3 2 1 4 3 2 1