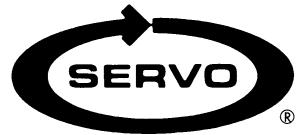


DYNAMO FEED INSTALLATION

Model D1000-9530 Cross Feed

Clausing Kalamazoo and others



PREPARATION

- Step 1:** Move the saddle to the front of the mill.
- Step 2:** Remove the nut, handle, dial assembly, and key from the lead screw. Save the key for installation later.
- Step 3:** Slide the #0774 alignment bushing (.630 ID x 1.000 OD) onto the lead screw.
- Step 4:** Slide the #57237 adaptor over the bearing race and against the front of the knee.
- Step 5:** Orient and transfer three mounting holes from the adaptor to the existing bearing retainer. Remove the alignment bushing.
- Step 6:** Remove the bearing retainer to drill and tap 1/4-20 thru. Then reinstall.
- Step 7:** Screw the shaft extension onto the lead screw.
- Step 8:** Slide the #57237R bevel gear onto the lead screw to ensure proper fit. Then remove the bevel gear.
- Step 9:** Using the hole provided as a pilot, drill 1/8" diameter through the lead screw. Pin the shaft extension to the lead screw with the 1/8 diameter x 5/8" long roll pin. File smooth.

POWER FEED INSTALLATION

- Step 1:** Slide the #57237 adaptor onto the lead screw (1.12 dia. counterbore facing outside).
- Step 2:** Slide the #0774 alignment bushing onto the lead screw and into the adaptor for proper alignment of the adaptor.
- Step 3:** Secure the adaptor to the bearing retainer using three 1/4-20 x 1" long socket head cap screws.
- Step 4:** Remove the alignment bushing.
- Step 5:** Slide the #0773 spacer, the #1230 spacer and #59328 bearing race onto the lead screw.
- Step 6:** Slide the power feed onto the bearing race and secure to the adaptor using two 1/4-20 x 1" long socket head cap screws.

BEVEL GEAR INSTALLATION

- Step 1:** Use the 3 mm parallel key you saved before for the bevel gear installation.
- Step 2:** Follow directions on p.5, **DYNAMO INSTALLATION MANUAL**

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. Shim washers are provided for this. Shim as required.

Step 2: Put on the dial locking nut. Slide the handcrank onto the end of the shaft extension and tighten with the 1/2-20 nut.

LIMIT SWITCH INSTALLATION

See the **DYNAMO INSTALLATION AND OPERATION MANUAL**.

OPERATION

See the **DYNAMO 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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EXISTING BEARING RETAINER

EXISTING LEADScrew
AND BRACKET57237
ADAPTORSHIM WASHERS AS NEEDED
SHIM WASHERS AS NEEDED

EXISTING DIAL

DIAL NUT

#59327R BEVEL GEAR
#07177 HANDLE WASHER (2)

KNEE

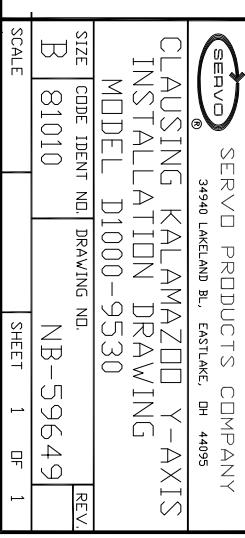
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0773 SPACER

00586 SOCKET HD. SC.
1/4-20 X 1.0 (5)1230
SPACER#00564 1/8 X 5/8 ROLL PIN
#07251 1/2-20 NUT
#07258 3 X 3 X 25 KEY
#57099 SHAFT EXTENSION
EXISTING HANDCRANKNOTES: 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED
OPERATIONS BEFORE TURNING ON POWER FEED.CLAUSING KALAMAZOO Y-AXIS
INSTALLATION DRAWING
MODEL D1000-9530

SIZE	CODE IDENT NO.	DRAWING NO.	SCALE	SHEET
B	81010	NB-59649	REV. A	1 OF 1

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