

DYNAMO FEED INSTALLATION

D1000-9811 Knee Feed

Acer Mill



PREPARATION

- Step 1:* Remove the drive clutch, dial, nut, and key from elevating jack shaft. Save the key for installation later.
- Step 2:* Remove the bearing retainer.
- Step 3:* Screw the shaft extension into the jack shaft and tighten. Use the handwheel and key on the shaft extension to apply torque. Using the hole provided as a pilot, drill 1/8" diameter through the shaft and pin the extension with 1/8 diameter x 5/8" long roll pin. File smooth.
- Step 4:* Install the bearing retainer provided using the #03594 M6x1 x 16 mm socket head cap screws.

POWER FEED INSTALLATION

- Step 1:* Slide the spacer bearing onto the jack shaft.
- Step 2:* Slide the bearing race onto the lead screw.
- Step 3:* Slide the power feed onto the bearing race and secure to the bearing retainer using the 1/4-20 x 1" long socket head 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. 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 2:* 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, put on the dial locking nut and washer #04603. Place the square key #04986 in the shaft, and slide the handwheel in place. Add the washer and locknut.

LIMIT SWITCH INSTALLATION

Refer to the D-1000Z INSTALLATION & OPERATION MANUAL

NOTE: MILLS HAVING COLUMNS WIDER THAN THE KNEE MAY NEED LONGER STANDOFFS AND SCREWS, OR DIFFERENT MOUNTING. DEPENDING ON WHICH SIDE OF THE KNEE THE SWITCH IS MOUNTED, THE SWITCH MAY HAVE TO BE TURNED OVER TO WORK CORRECTLY. TEST THE SWITCH STOPPING DIRECTION MANUALLY BEFORE MOUNTING.

OPERATION

See the 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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