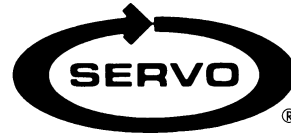


# POWER FEED INSTALLATION

## Model M-3800 Table Feed

### Comet 3KV/VH 10x50



#### REFERENCE DRAWINGS ENCLOSED

NA-5444	Bevel Gear Installation
NB-5499	Power Feed Installation
ND-6293	Type 150 Servo Drive
ND-6292	Type 140 Servo Drive
0800-80001	Servo Power Feed Installation

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#### PREPARATION

- Step 1:* Remove the nut, handle, and dial assembly from the right-hand end of the table.
- Step 2:* Remove the four cap screws holding the bearing housing in place.
- Step 3:* 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 in place over the shaft.
- Step 2:* Slide the power feed onto the shaft and push in place.

**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:* Move the table to the extreme left-hand position and then tighten the four cap screws.

#### BEVEL GEAR INSTALLATION

- Step 1:* Follow drawing NA-5444 for installation of the bevel gear. Adjust for proper gear backlash.

#### 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 to keep chips from entering the gear train. Four washers are provided for this, two solid and two laminated. Shim as required.
- Step 2:* In the following sequence, put on the dial locking nut, replace the key in the shaft (if removed), slide the handle in place, and add the locking 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 two cap screws holding the T-shaped table stop bracket.

**Step 3:** Place the short spacers into the counterbored holes in the T-stop. Place the limit switch assembly on the spacers and install using the two 3/8-16 x 1" long socket head cap screws.

**Step 4:** The T-stop is retained to act as a positive stop where required for manual operation.

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

## OPERATION

See separate *Servo Power Feed Operation* sheet. Plug the unit into a source of 120 volt, 50 or 60 cycle power.

### 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!

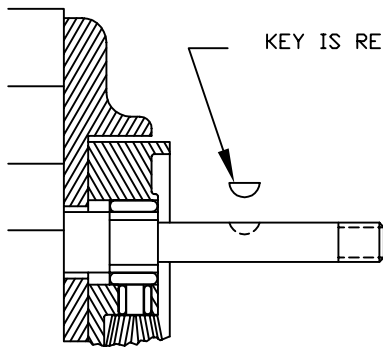
Prevent contact during fast traverses.

## SERVO PRODUCTS COMPANY

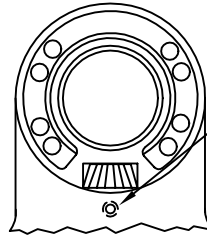
433 North Fair Oaks Avenue, Pasadena, CA 91103 USA  
Phone: 800.521.7359 or 626.796.2460 Fax: 626.796.3845

Web: [www.servoproductsco.com](http://www.servoproductsco.com)

Call for the location of our regional Service Centers.

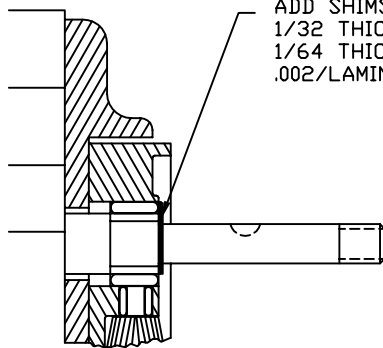


KEY IS REMOVED DURING SHIMMING

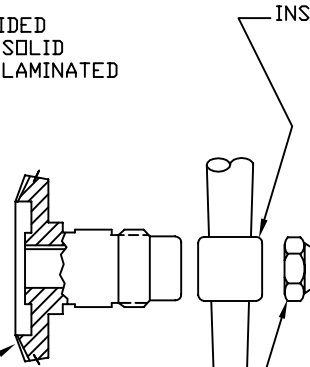


TIGHTEN SLIGHTLY (HOLDS BEVEL PINION STATIONARY DURING SHIMMING.)

STEP 1  
PREPARATION



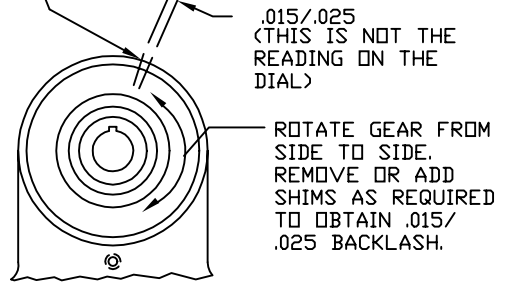
ADD SHIMS PROVIDED  
1/32 THICK ARE SOLID  
1/64 THICK ARE LAMINATED  
.002/LAMINATION



PUSH BEVEL GEAR AGAINST SHIMS.

INSTALL HANDCRANK.

MARK HOUSING AND BEVEL GEAR WITH PENCIL TO CHECK BACKLASH.



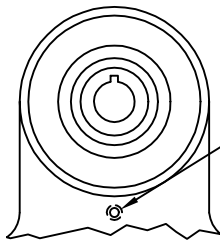
.015/.025  
(THIS IS NOT THE READING ON THE DIAL)

ROTATE GEAR FROM SIDE TO SIDE.  
REMOVE OR ADD SHIMS AS REQUIRED TO OBTAIN .015/.025 BACKLASH.

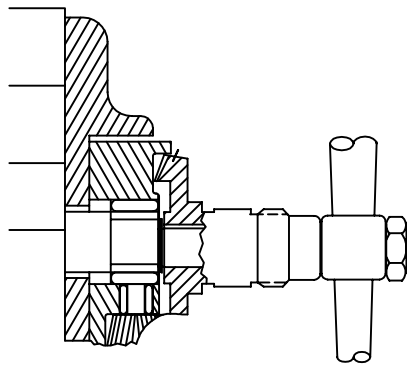
STEP 2  
SHIMMING BEVEL GEAR

TIGHTEN NUT.

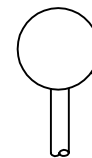
**CAUTION:** IF BACKLASH IS NOT PROPERLY SET BEFORE TURNING UNIT ON, BEVEL GEAR MAY BE DESTROYED.



LOOSEN SETSCREW

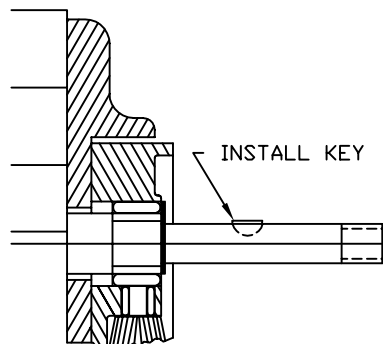


WITH POWER FEED IN NEUTRAL POSITION, TURN HANDCRANK. IF EXCESSIVE GEAR NOISE OR BINDING OCCURS, SHIMS NEED TO BE ADDED. WHEN ADDING SHIMS, REPEAT STEPS 1 AND 2.



CONTROL HANDLE @ NEUTRAL POSITION

STEP 3  
DOUBLE CHECK OF SHIMMING



INSTALL KEY



SEAL

REMOVE GEAR, PACK WITH GREASE. (DO NOT USE SILICONE TYPE GREASE) REPLACE GEAR. (DO NOT LOSE ANY SHIMS)

PICTURES IN THIS DRAWING ARE FOR REFERENCE ONLY. SEE INSTALLATION DRAWING OF CORRESPONDING MODEL FOR EXACT PARTS CONFIGURATION.

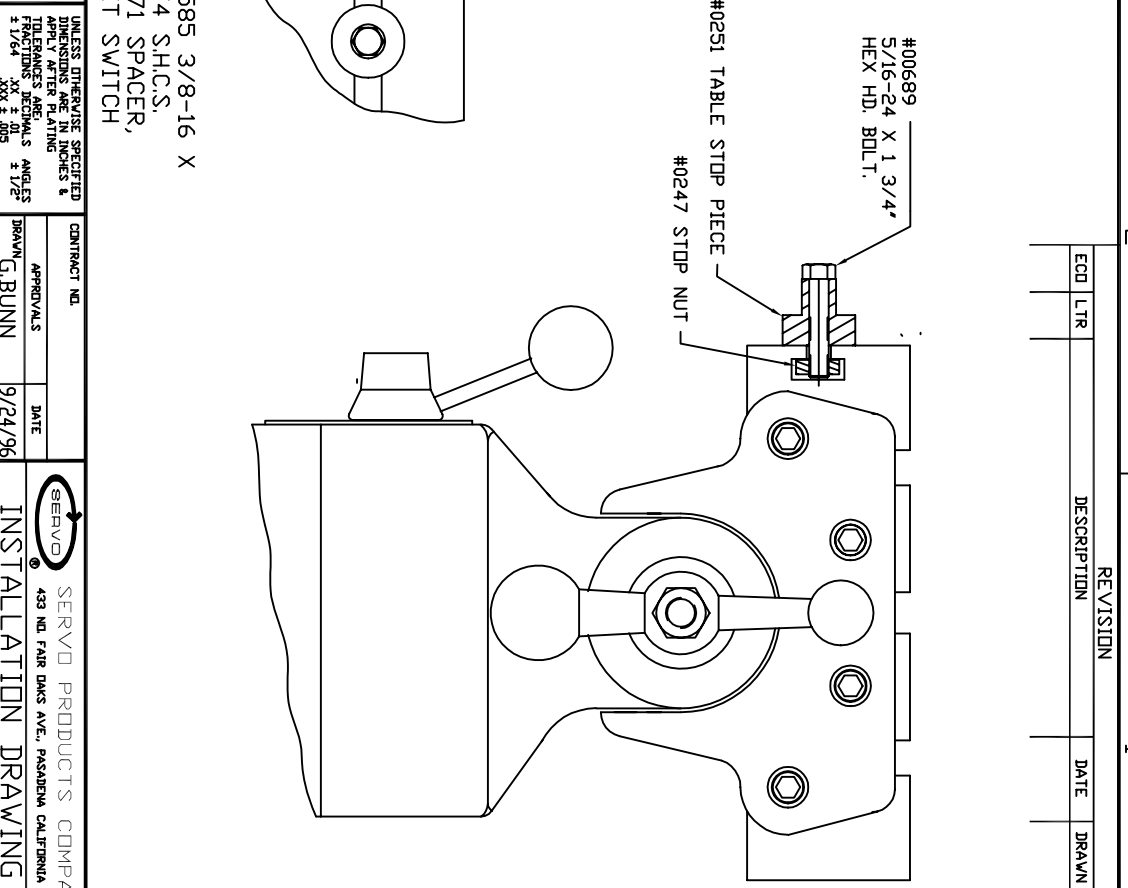
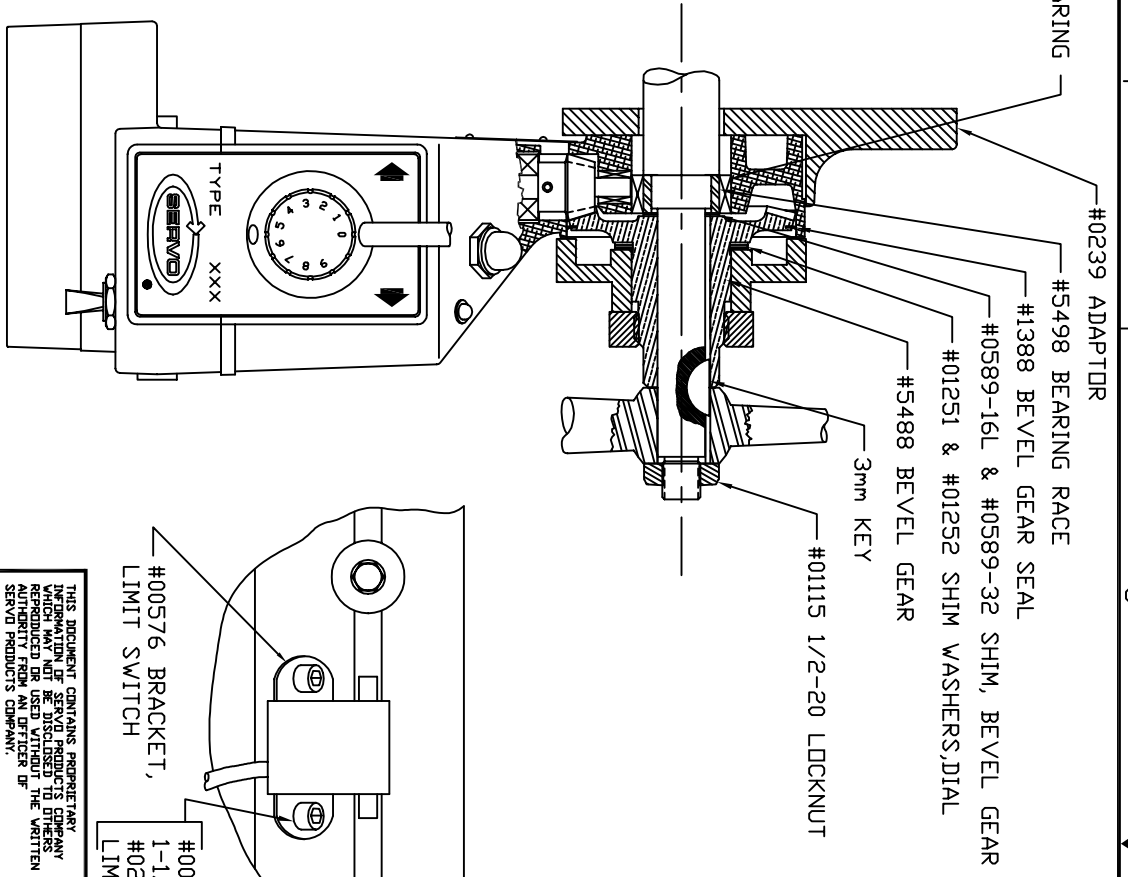
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BEVEL GEAR INSTALLATION

NA-5444 C

STEP 4  
LUBRICATION

REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				




UNLESS OTHERWISE SPECIFIED PERPENDICULARITY, PARALLELISM, STRAIGHTNESS, FLATNESS, ROUNDNESS, CONCENTRICITY, CYLINDRICITY TO BE WITHIN .01 TOTAL OR .040/√R. SURFACE ROUGHNESS WITHIN 125 REMOIVE SHARP CORNERS AND EDGES .005 MIN. DRAWING STANDARD PER ANSI Y14.5M-1982

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & TOLERANCES ARE AS FOLLOWS FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± .005 ± 1/2°

FINISH	NOTED	CHECKED
MATERIAL		
APPLICATION	USED ON	
NEXT ASSY		

CONTRACT NO.	APPROVALS	DATE
	G. BUINN	9/24/96
DID NOT SCALE DRAWING		
COMPUTER NO.		
NBS499A.DWG		


**SERVO PRODUCTS COMPANY**  
 433 N. FAIR OAKS AVE., PASADENA, CALIFORNIA 91103  
**INSTALLATION DRAWING**  
**MODEL 3800 VH**  
**10 X 50 TABLE**  
 SIZE CODE IDENT. NO. DRAWING NO. SHEET OF  
 B 0800-80032 NB-5499 A