

DYNAMO FEED INSTALLATION

Model D1000-1380 Knee Feed

Kondia G, FV-1, Hurco SM1 and others



PREPARATION

- Step 1:* Remove the drive clutch from the elevating jack shaft.
- Step 2:* Remove the dial and nut.
- Step 3:* Remove the bearing retainer.
- Step 4:* Pull the jack shaft out of the knee. **Hold inboard end up** while removing to avoid damage to the pinion gear.
- Step 5:* Remove the dial holder (unscrew) and press the bearing off the jack shaft.
- Step 6:* Drill and ream the end of the jack shaft .4375" diameter by 13/16" deep. The .4375 diameter must be concentric to the shaft o.d. within .002 TIR. Chamfer 1/32 x 1/2 diameter. **For best results, machining should be done in a lathe.**
- Step 7:* Press the shaft extension into the end of the jack shaft. Using the hole provided as a pilot, drill 1/8" diameter through and pin the shaft extension to the jack shaft with the 1/8 diameter x 5/8" long roll pin. File smooth.
- Step 8:* Replace the bearing onto the jack shaft.
- Step 9:* Replace the jack shaft in the machine.
- Step 10:* Secure Dynamo bearing retainer in place of the Kondia retainer.

POWER FEED INSTALLATION

- Step 1:* Slide the spacer #6740 over threads followed by shim #04867.
- Step 2:* Slide the spacer #0477 onto the lead screw.
- Step 3:* Slide the bearing race onto the jack shaft against the #0477 spacer.
- Step 4:* Add the adaptor and secure using the three 1/4-20 x 3/4" long socket head cap screws supplied. Using drawing ND-3216-D, check the .125 dimension.
- IF:* If necessary, remove the bearing race and the #0477 spacer. Machine the length of the spacer per Note 1.
- Step 5:* With the spacer and bearing race in place, slide the power feed and secure with 1/4-20 x 1" long socket head cap screws provided.

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, place the key in the shaft extension, 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

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

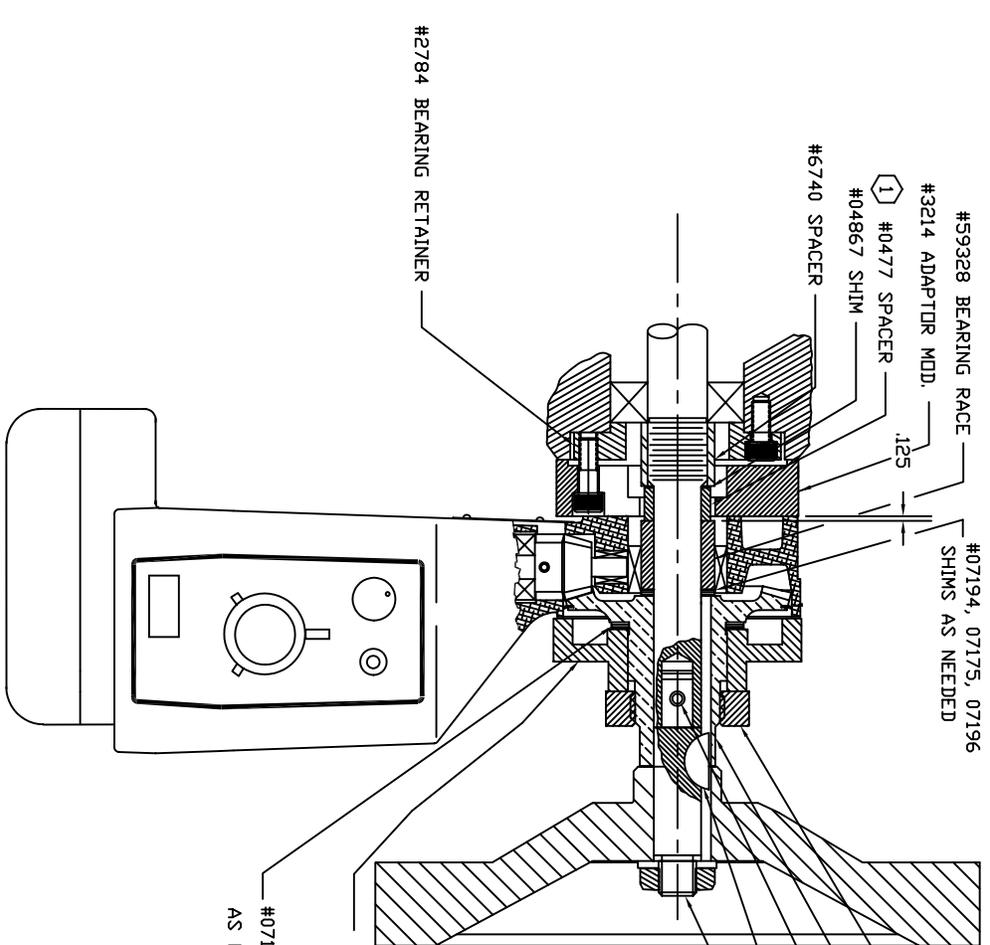
14254 Valley Blvd., Unit A
City of Industry, CA 91746
Ph. 626.961.7800 Fax 626.961.2444

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



- NOTES:
1. MACHINE LENGTH OF SPACER SD MAX. PROJECTION IS AS NOTED.
 2. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED OPERATION BEFORE TURNING ON SERVO POWER FEED.

REVISION		DATE	DRAWN	CHECKED
ECD	LTR			
DESCRIPTION				

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND DECIMALS ARE IN THOUSANDS. ANGLES ARE IN DEGREES. TOLERANCES ARE ± 1/64" XX ± .005 MATERIAL NOTED FINISH NOTED DID NOT SCALE DRAWING

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION OF SERVO PRODUCTS COMPANY WHICH MAY NOT BE DISCLOSED TO OTHERS WITHOUT THE WRITTEN AUTHORITY FROM AN OFFICER OF SERVO PRODUCTS COMPANY.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & DECIMALS ARE IN THOUSANDS. ANGLES ARE IN DEGREES. TOLERANCES ARE ± 1/64" XX ± .005 MATERIAL NOTED FINISH NOTED DID NOT SCALE DRAWING

CONTRACT NO.	APPROVALS	DATE
	BRAUN BIMA	7/02/09
	CHECKED	


SERVO PRODUCTS COMPANY
 34940 LABELAND BLVD, EASTLAKE, OH 44095
INSTALLATION DRAWING
 MODEL D1000-1380
 SIZE CODE IDENT. NO. 0800-80983 DRAWING NO. NB-59614
 SCALE 5/8 SHEET OF