

DYNAMO FEED INSTALLATION

Model D1000-4400 Table Feed

Supermax 1-1/2, 16VA



PREPARATION

- Step 1:* Remove the nut, crank, dial assembly and key from the right-hand side of the mill. Using the bearing retainer as a template, spot three holes.
- Step 2:* Drill and tap 1/4-20 x 1/2" socket head cap screw.
- Step 3:* Screw the shaft extension onto the lead screw and tighten.
- Step 4:* Using the hole provided as a pilot, drill 1/8" diameter hole through and pin in place using the 1/8 x 5/8" diameter roll pin. File smooth.

POWER FEED INSTALLATION

- +Step 1:* Secure bearing retainer B-5692 to table with three 1/4-20 x 1/2" long socket head cap screws.
- Step 2:* Slide the spacer and bearing race onto the lead screw.
- Step 3:* Slide the power feed over the bearing race and secure with two 1/4-20 x 1.0" 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. 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. Four shim washers are provided for this. Shim as required.
- Step 2:* In the following sequence, put on the dial locking nut and slide the handle in place. Add the 1/2-20 lock nut and tighten.

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 piece and install limit switch using existing screws. Spacers may be required to space limit switch from 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.

Step 4: Put the cable clamp on the cable and secure using the right-hand chip scraper screw.

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

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CALIFORNIA BRANCH

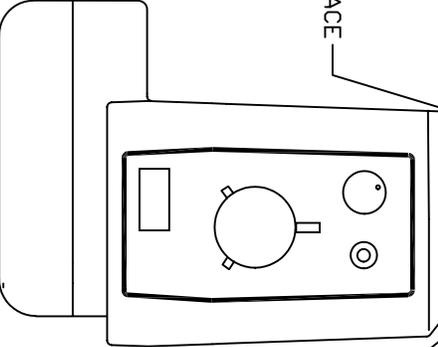
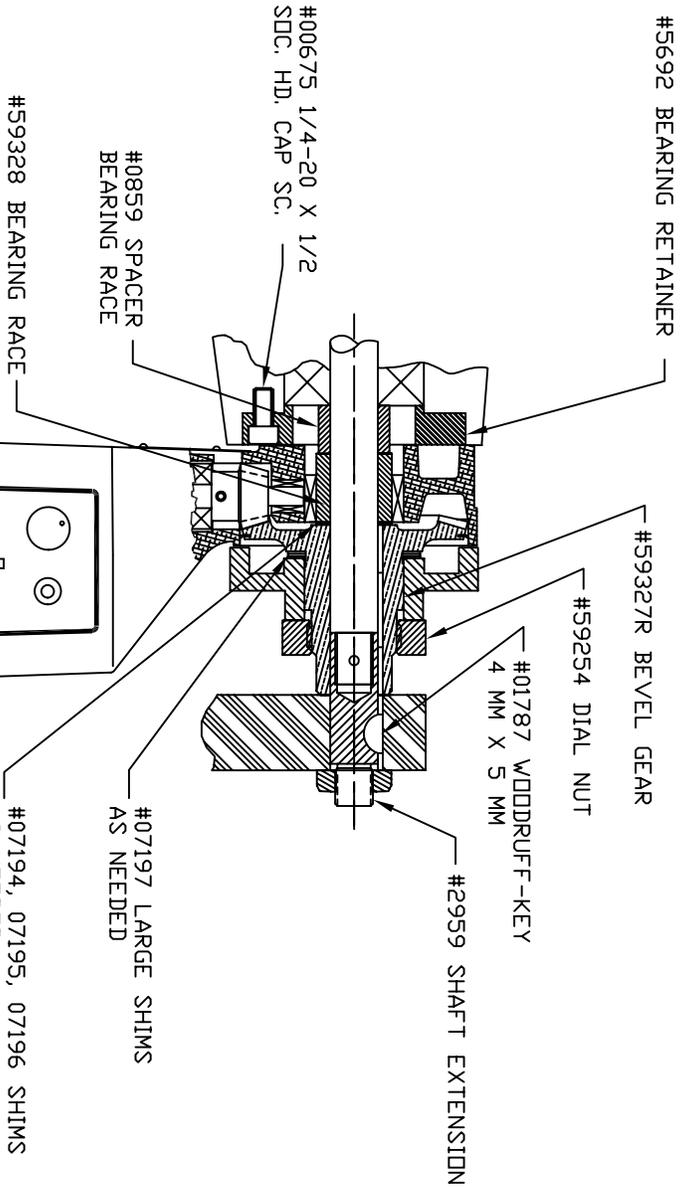
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NOTE :
 1. REVIEW ALL INSTALLATION INSTRUCTIONS AND POWER FEED
 OPERATIONS BEFORE TURNING ON POWER FEED .

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

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 INFORMATION OF SERVOPRODUCTS COMPANY
 WHICH MAY NOT BE DISCLOSED TO OTHERS
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 SERVOPRODUCTS COMPANY.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & FRACTIONS ARE IN TOLERANCES ARE IN DECIMALS .005 ± 1/64 .005 ± .005	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES & FRACTIONS ARE IN TOLERANCES ARE IN DECIMALS .005 ± 1/64 .005 ± .005	CONTRACT NO.	APPROVALS	DATE
MATERIAL	NOTED	DRAWN	BIMA	7/14/09
FINISH		CHECKED		
NEXT ASSY	USED ON	COMPUTER NO.		
APPLICATION				

SERVOPRODUCTS COMPANY
 34940 LABELAND BLVD, EASTLAKE, OH 44095
SUPERMAX YCM 16VA
 INSTALLATION DRAWING
 MODEL 4400
 SIZE CODE IDENT NO. 08600
 80991
 SCALE B
 DRAWING NO. NB-59622
 SHEET 1 OF 1
 REV.