

Power feed

Assembly Instructions to suit the X3 mill range



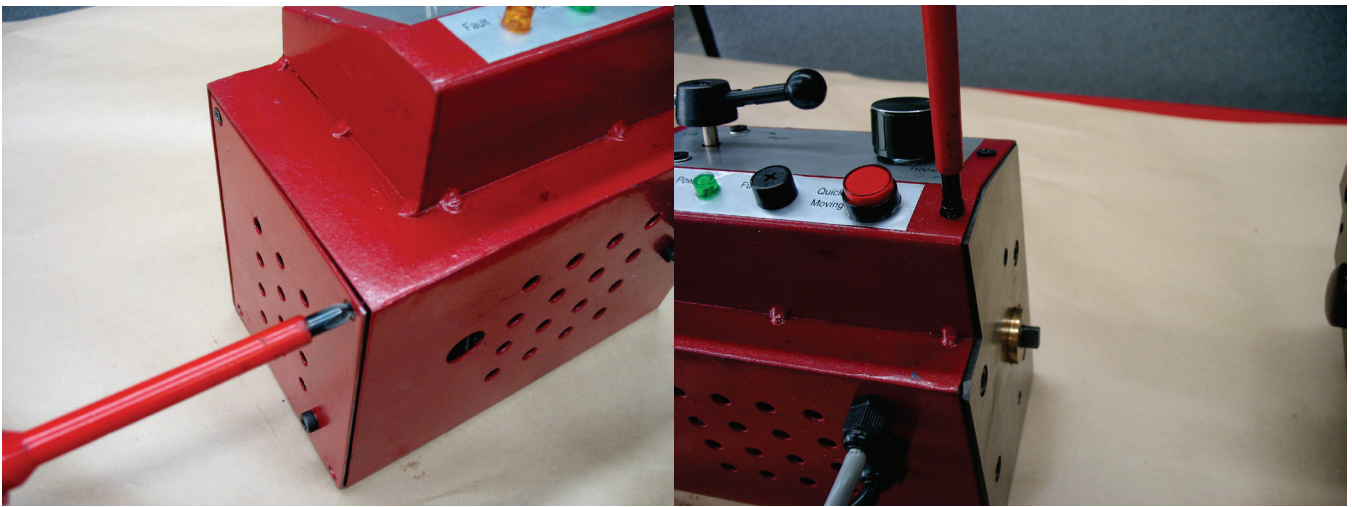
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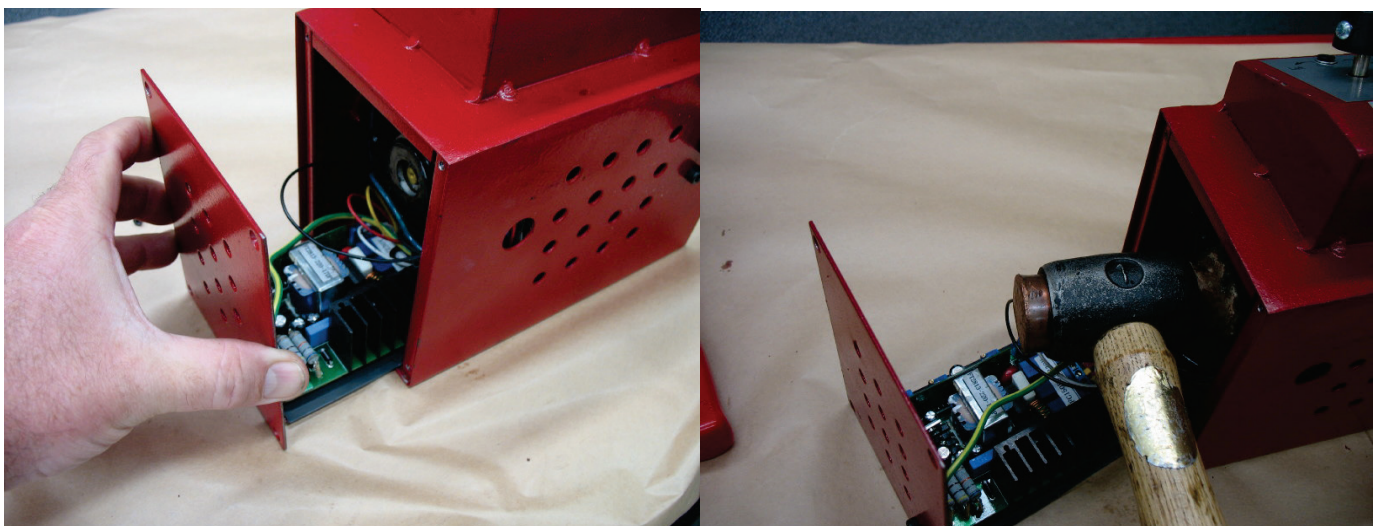
“PLEASE NOTE”

Great care must be taken to ensure that no wires are put under any stress or load throughout the installation procedure of this power feed unit

- # 1** With machine and power feed unit unplugged from the power source.
Remove the 8 screws that hold the end plates onto both ends of the power feed as shown below.



- # 2** Carefully pull out the left hand end plate and electronic control board attached to it.
Then remove the right hand mounting plate assembly complete with motor.
This may be a tight fit, so with great care you might have to hit the motor end cover from the opposite end to encourage its removal as shown below.

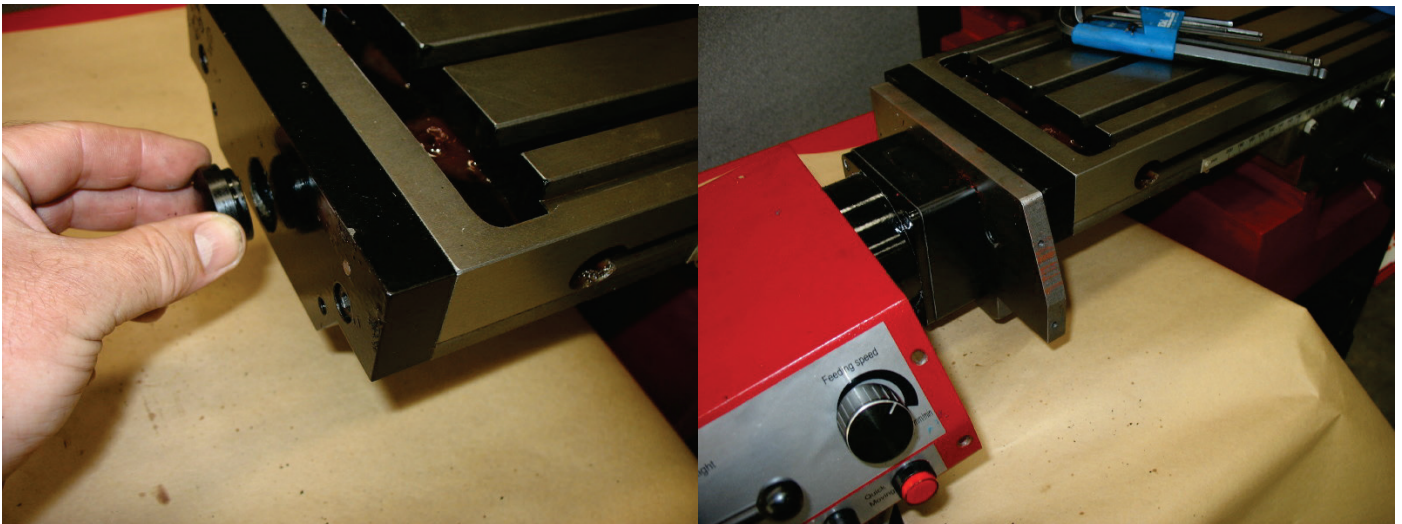


3 Remove the plug at the end of the leadscrew as shown

Ensure the end plate is clean and that no screws or dowel pins are protruding from it.

Please note that you will have to manually turn the lead screw to align the machined slot in the end of the leadscrew with that on the motor shaft before fitting together.

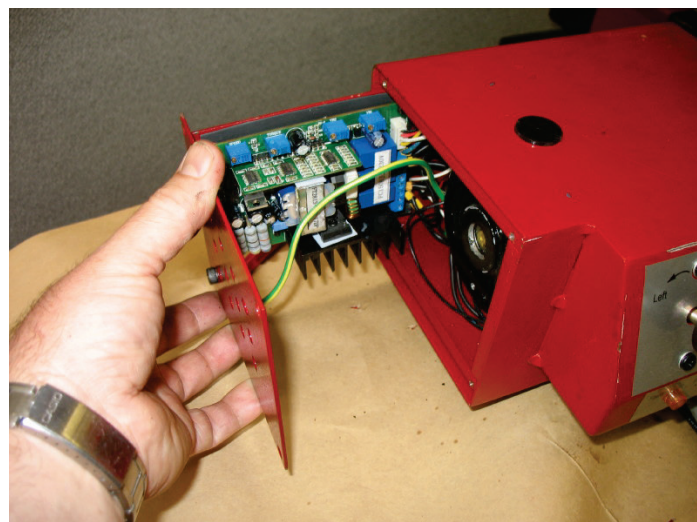
Mount motor plate assembly with the 2 x Socket Head Cap Screws supplied with power feed unit.



4 Position the power feed body over the motor and mounting plate and refit the 4 screws that hold it together.

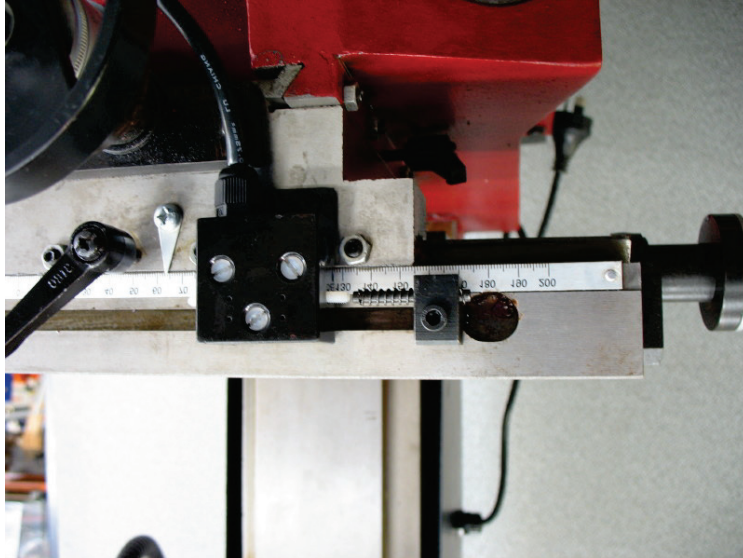
Then carefully refit the left hand end cover with circuit board and then screw that closed.

Ensure on reassembly of the above that no wires are being pulled out and that the access hole under the unit for maintenance of the lower motor brush is kept clear of all wires.



5 Install micro switch assembly as shown on the right hand side front of machine.
Ensuring nylon stop pins on the side of micro unit line up with the sliding stop blocks that are mounted as shown (One on the left side of the micro switch box and one on the right hand side.)

*NB: Two holes will have to be drilled and tapped into cross slide of machine.
And micro switch assembly will have to be opened to attach its backing plate to machine.*



6 After fitting of Power feed unit, micro stop assembly and sliding stop blocks.
Plug the power feed in and test and set maximum travel of the table.
Ensure the power flex to the micro switch is not getting caught on anything and nothing is interfering with the free movement of the table.

It is good practice to fit a fixed mechanical stop such as a roll pin or machine screw on the outer limits of the stop block travels to avoid accidental over travel of the table.