

## CROSS FEED INSTALLATION INSTRUCTIONS

MODEL GB-550Y (OR GB-250Y)

Reference Drawing Enclosed:

Fig 7-A THE SEQUENCE OF THE CROSS FEED INSTALLATION

Fig 7-B THE CUTAWAY VIEW OF THE CROSS FEED INSTALLATION

Fig 8 LIMIT SWITCH INSTALLATION

### A. PREPARATION:

1. Remove the nut, handle and dial assembly from the shaft of the cross travel.
2. Remove the bearing retainer ring from the cross feed bearing bracket.
3. Replace the bearing retainer ring (Provided), Tighten using existing screws.
4. Mount the extensional shaft and bit the spining pin 3 x 16mm.

### B. DRIVE UNIT INSTALLATION (Refer to Fig. 7-A)

1. Push the spring pins into the bearing retainer ring, slide the bearing inner holder onto the lead screw.
2. Slide the bearing inner onto the bearing inner holder.
3. Slide the power feed onto the leadscrew and push in place.
4. Secure the power feed using two cap screws (Provided).

### C. BEVEL GEAR INSTALLATION:

See Fig 2 through Fig 5.

### D. DIAL AND HANDLE WHEEL INSTALLATION:

See page 1 the "DIAL AND HANDCRANK INSTALLATION".

E. LIMIT SWITCH INSTALLATION (Refer to Fig 8):

1. Mount the limit switch assembly to the bracket of limit switch.
2. Slide the bracket onto the right-hand of the cross table, tighten using two Hex. head screws (Provided).
3. Mount the T way lever which is assembled by two piece of T way lever.
4. Slide the travel stop onto the T way lever, tighten it in properly position.
5. Secure the cable using the cable clamp provided.

F. OPERATION:

See page 1 the "POWER TABLE FEED OPERATION".

G. PART LIST:

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>Q'TY</u>
123	BEARING RETAINER RING	1
124	BEARING INNER HOLDER	1
125	EXTENSIONAL SHAFT	1
126	SPRING PIN, 3 $\phi$ x 16mm	1
127	INSTALL KEY, 1/8" x 16mm	1
128	HANDLE	1
129	HEX. HEAD SCREWS, 5/16" x 1/2"	2
130	LIMIT SWITCH ASSEMBLY	1
131	T WAY LEVER	2
132	BRACKET, LIMIT SWITCH ASSEMBLY	1
133	HEX. HEAD SCREWS W/ NUTS, 5/16" x 1 $\frac{1}{4}$ "	2
134	SOCKET HEX. HEAD SCREWS, 5/16-24UNF x 1 $\frac{1}{4}$ "	2
135	PAN HEAD SCREWS, 3/16" x 1"	4

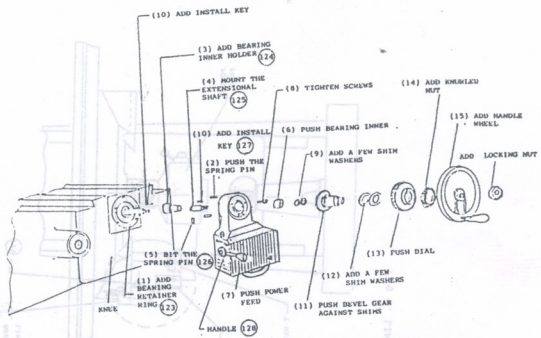


Fig 7-A THE SEQUENCE OF THE CROSS FEED INSTALLATION

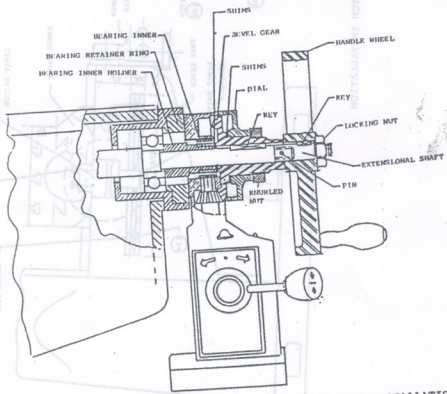


Fig 7-B THE CUTAWAY VIEW OF THE CROSS FEED INSTALLATION

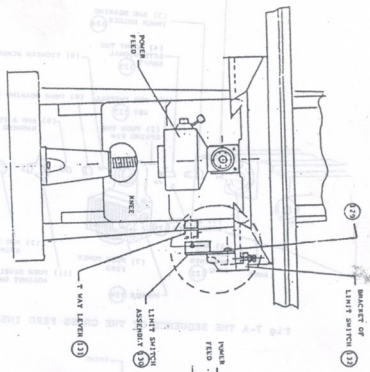


Fig. 8. LIMIT SWITCH INSTALLATION

