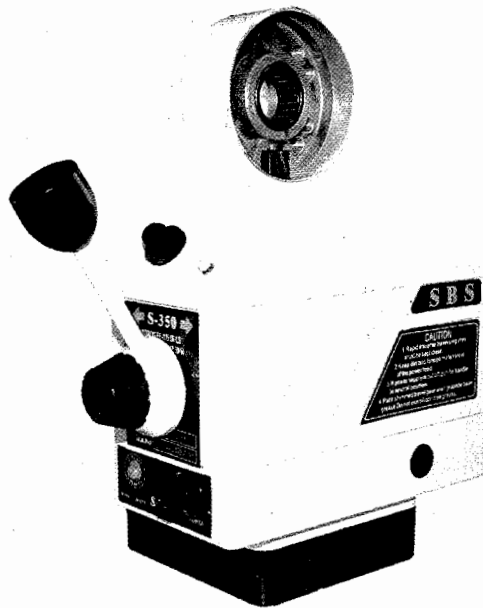


HT · SBS[®]

POWER FEED

FOR MILL USE

USER'S GUIDE



Baoji Aerospace Huake Electromechanical
Industrial Co., Ltd

NOTICE

Dear Customer:

Thanks for purchase this advanced Power Feed,we will provide services to meet your demands.

- Please check the part list carefully after open the packge.
- Please read the user's guide carefully before use.

※ Please keep this guide for further use.

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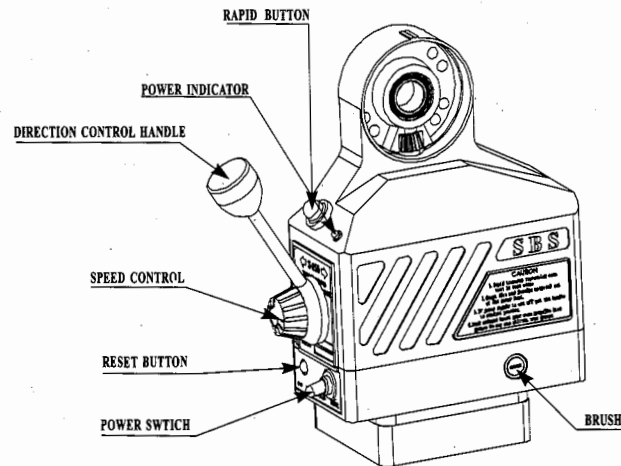
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Specifications are subject to change without notice.

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I. Power Feed feature

1. About Power Feed



2. Specification

TYPE	SBS350	SBS235	SBS240	SBS240W
AC 50/60Hz	AC110V	AC110V	AC220V	AC220V
VARIABLE SPEED RANGE	0-140rpm	0-120rpm	0-120rpm	0-120rpm
RAPID SPEED	180rpm	160rpm	160rpm	160rpm
TORPUE	20Nm	15.5Nm	20Nm	20Nm
NOISE	<66dB	<68dB	<70dB	<70dB
WEIGHT	5.8Kg	6.1Kg	6.1Kg	6.1Kg
VOLUME	240×120×270 cm ³			

3. This Power Feed can assemble along X axis or Y axis by users need, and it can also assemble horizontal.

II. Assembly

You can assemble this Power Feed as follows:

Assemble along X axis

Preparation(Chart 1)

1. Move work table to extreme left-hand position.

Leave sunk screw, slot, hand crank, dial, bearing flange only.

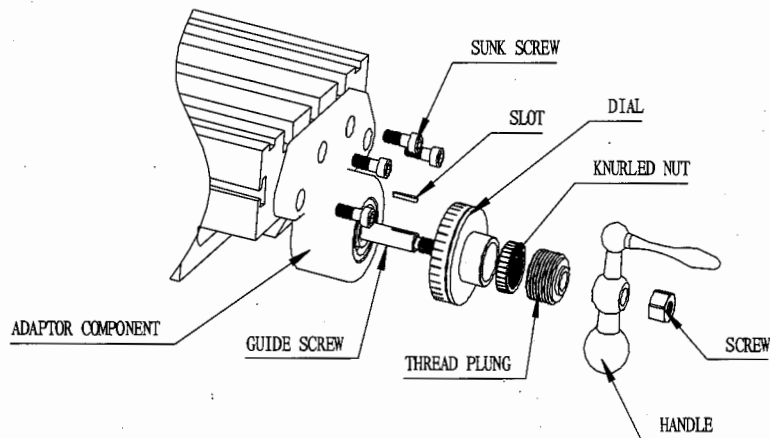


Chart (1)

Assemble Power Feed(Chart 2)

Assembly order:

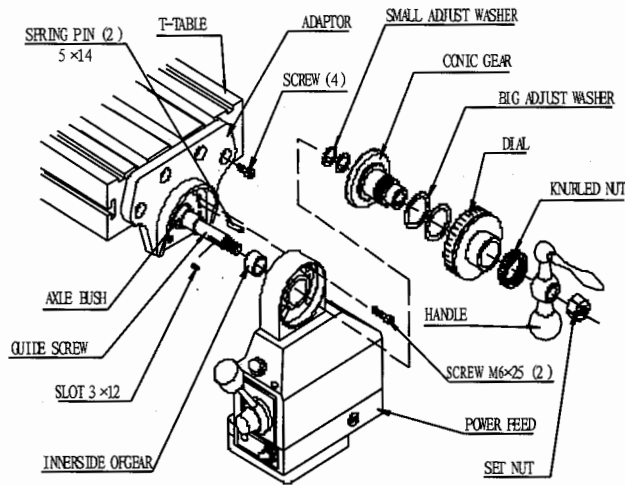


Chart (2)

CAUTION:

Small adjust washer is used to adjust the clearance between the conic gear of the Power Feed and small conic gear of mill. Proper clearance will make mill work smoothly and steadily. So before you assemble and tighten it, you should experience the clearance manually.

No clearance will make mill work unsteady and noisy. Add Small adjust washer, if it occurs. Big clearance will make gears work unsteadily. Remove adjust small washer if it occurs.

You should adjust proper clearance many times before the Power Feed will work smoothly and steadily.

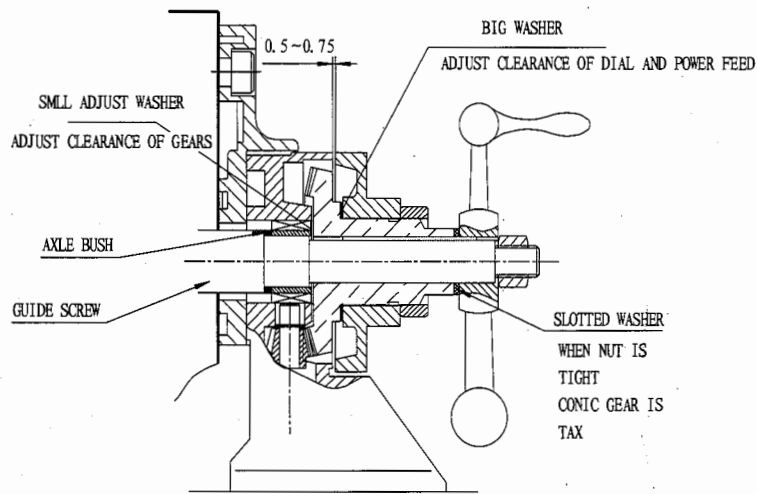


Chart (3)

Assemble limit switch(Chart 3)

Illustrate as follows:(without travel stop shell)

1. Set travel stop on the middle of mill body under T-table.
2. Adjust and tighten the limit switch on the T-table.
3. Leave enough cable for T-table move use.

Assemble along Y axis

Preparation

1. Move Y axis to extreme inner-side position.
2. Remove the hand crank,dial and bearing flange from T-table.
3. Remove original adaptor.

Assemble Power Feed(Chart 4)

Illustrate as follows:

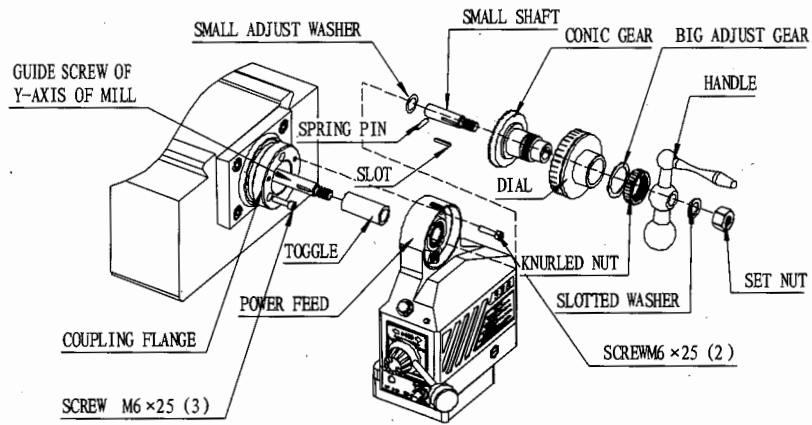


Chart (4)

1. Connect small shaft to guide screw in purpose of lengthen it. then drill a $\Phi 5$ (Thru) on connect places, finally tighten the two by spring pin insiding the hole.
2. Assemble as illustration.

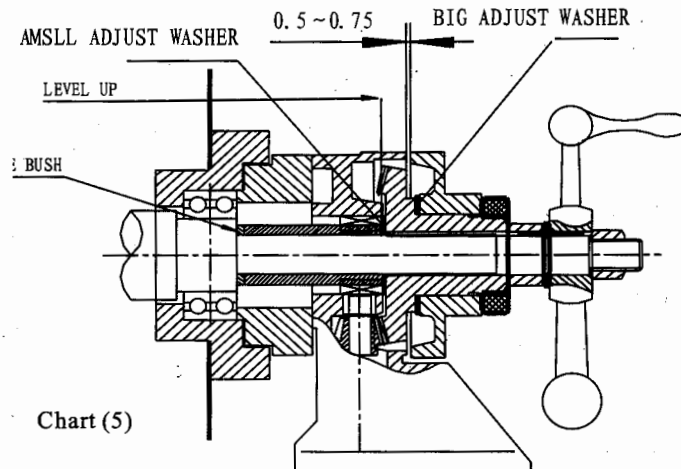


Chart (5)

3. Adjust way is the same to X axis.

Assemble limit switch (without water protector

Chart 6)

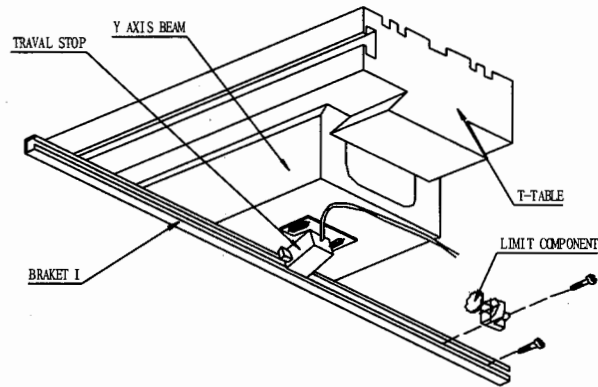


Chart (6)

1. Make (M8×1.25 Depth 20) in the place that under the beam of Y axis.
2. Tighten travel stop by M8×1.25×15) screw.
3. Locate and tighten bracket following the travel stop onto the beam of Z axis.
4. Locate limit switch onto bracket.
5. Leave enough cable for work table move use.

Horizontal Assemble

SBS240W ILLUSTRATION OF ASSEMBLY

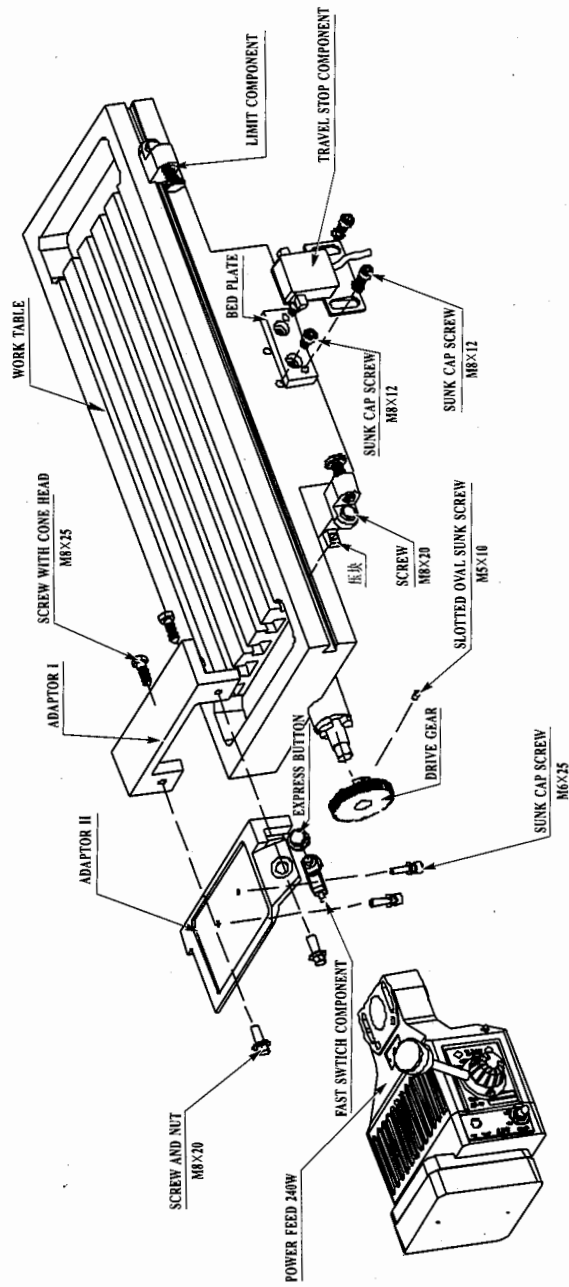


Chart (7)

Preparation

1. Move work table to extreme left-hand position.
2. Remove the hand crank, dial and bearing flange from T-table.
3. Install an extension shaft for T-tables then assemble drive gear, if necessary.
4. Remove two screws (2-M × 25) from original small adaptor.

Assemble Power Feed

1. Tighten the Power Feed on the big adaptor.
2. Adjust Power Feed to obtain proper clearance of the drive gear.
3. Tighten screws of the drive gear.
4. Tighten two screws (2-M × 25) of small adaptor.
5. Lubricate the drive gear by graphite grease.

Assemble limit switch

1. Replace the original limit switch by provided ones
2. Adjust limit switch position to meet all occasional use.

III. Operation (refer to illustration of the Power Feed)

1. Make sure the power supply is "OFF", the direction handle is on the middle position.
2. Use power supply as follows (SBS350, SBS235 110V; SBS240, 220V; SBS240W 220V).

3. Check the circuit: when power supply is "ON" , indicator glows.or else, when power supply is "OFF", indicator does not glow. It means the Power Feed work well.

4. Direction change handle.

To control the direction of the drive gear. If the handle is right, the table will move right-ward. If the handle is left, the table will move left-ward.

5. Reset button.

When Power Feed overload, it will protect the mill by cutting off the power supply. After load is in safe range, press reset button to resume.

▲Operational Warnings

Rapid change the direction may occur gear break. Make sure the Power Feed stop when direction change.

6. Speed control knob

The bigger of the number the higher of the speed. It changes the speed smoothly by your needs.

7. Rapid button

Press this button to obtain the max speed of the Power Feed, resume normal speed after unlock it.

8. To prevent Power Feed work from uncontrol situation, make sure the Power Feed is in the default set before everyday use.

IV. Care and maintenance

1. Check abrasion of gears once a year. Make sure the gears is filled with enough graphite grease.
2. Check brush no less than 8mm once every half of year.

V. Troubleshooting

Go through this section if you experience difficulty in operating the Power Feed. Should any problem persist, call the Power Feed service line at the number listed for assistance.

- The power does not turn on.
Check that the system is turned on.
Check that the protection button set off.
Check that the AC adaptor and the AC power cord are properly inserted in.
Check that the correct AC adaptor for this product is being used.
Check that the AC adaptor connector is clean. If not, wipe it with a dry, soft cloth.
- The Power Feed can only work in rapid speed.
Check that the brush is worn out.
Check that the electronic element is failure.
- The Power Feed can only work in single direction.
Check that the limit switch is failure.
Check that the travel switch is failure.
- The Power Feed can work except in rapid speed.
Check that the fast switch is failure.

● The Power Feed work with great noisy.

Check that the clearance of gears need to adjust.

Check that the plastic geart is failure.

VI. After sale service

We provide one year limited warranty after sales. Any failure caused by quality will charge free. We also provide maintenance charge cost price, if warranty is expired.

EXTENT OF LIMITED WARRANTY

This limited warranty does not cover any costs relating to removal or replacement of any Power Feed that is permanently affixed to your mill.

This limited warranty does not cover damages due to externalcauses, including accident, problems with electrical power, usage not in accordance with product instructions, misuse, neglect, alteration, repair, improper installation, or improper testing.

All express and implied warranties are limited in duration to the limited warranty period.No warranties apply after that period.

HOW TO OBTAIN WARRANTY SERVICE

To request warranty service, contact Branch within the warranty period during normal business hours excluding holidays.

East area: 0574-87490431

South area: 0769-81112961/2 (Fax)

0757-26915936

VII. Accessory lists

X axis accessories

NAME	COUNT	PURPOSE
Adaptor	1	Connet Power Feed to mill
Socket cap screw M6×25	2	Connet Power Feed to adaptor
Axle bush	1	Connect small shaft to guide screw
Spring dowel 5×14	2	Locate both Power Feed and adaptor
Small adjust washer (81-280.6-2 80.4-280.2-2)	8	Adjust clearance between two conic gears
Big adjust washer (81-2; 80.6-280.4-2; 80.2-2)	8	Adjust the clearance of dial and Power Feed
Conic gear component	1	Transmit torque
Slotted washer	1	Adjust the position of the hand
Limit component	2	Work with limit switch
Screw M5×10	2	Set line string
Washer 5	2	
Line string L=100	2	Set cables
Conductor block	2	Assemble cables

Y axis accessories

NAME	COUNT	PURPOSE
Connectted coupling flange	1	Connect Power Feed to mill
Socket cap screw M6×25	5	Mill flanged disc (3)
		Power Feed flanged disc (2)
Small shaft	1	Lengthen guide screw
Spring pin 5×14	2	Connect guide screw and small shaft
Toggle	1	Assemble Power Feed and bearing
Axle bush	1	Connect guide screw and bearing
Small adjust washer (81-280.6-2 80.4-280.2-2)	8	Adjust the clearance of two gears
Big adjust washer (81-2; 80.6-280.4-2; 80.2-2)	8	Adjust the clearance of dial and Power Feed
Conic gear component	1	Transmit torque
Slotted washer	1	Adjust position of handle
Limit component	2	Work with limit switch
Screw M5×10	2	Set conductor
Conductor block	2	Assemble cables
Washer 5	2	
Line string L=100	2	Set cables
Bracket	2	Set limit switch
Screw M5×25	4	Set bracket

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