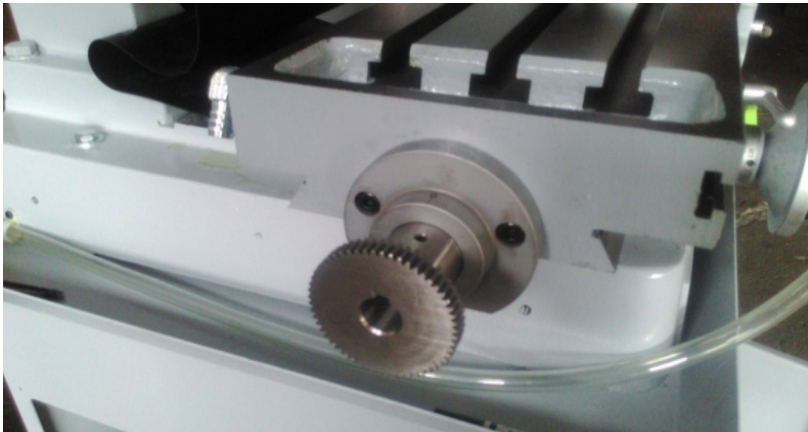


PM833T X Power feed install

1. Remove bolt for handle, dial nut, dial and collar for dial. It may be necessary to pry the collar off.



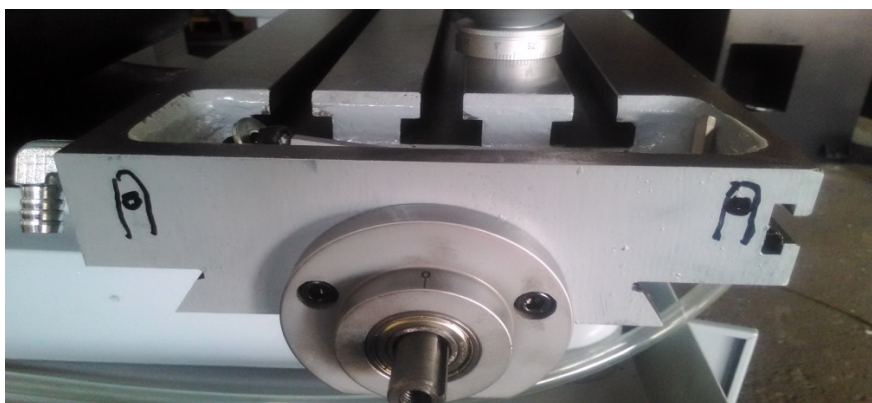
2. Install the gear. Make sure to use keyway. (Gear away from the table.) Tighten set screw.



3. Install X Axis Feed Adapter on to power feed as shown below.



4. Using C clamps, clamp adapter and motor to table as shown below, making sure gear on the power feed motor and the gear on the table mesh. Mark where holes need to be drilled and tapped.



5. Drill and tap holes in the location shown, drill and tap M8 x 1.25 (Double check hole location before drilling) After holes are drilled, you are ready to mount power feed. Mount feed and adjust so that the power feed gear and table gear mesh properly. You can set this mesh by installing a piece of paper in between the gears when assembling. Apply some grease to the gears, check for sound when rotating, and adjust if necessary. Install stop on the front of the table, adjust so that the stops will stop the feed before reaching the end of travel, and feed is now ready to use.
6. Install and adjust the table stops. Do not rapid travel while setting the stops, you could run off the end of the table.