

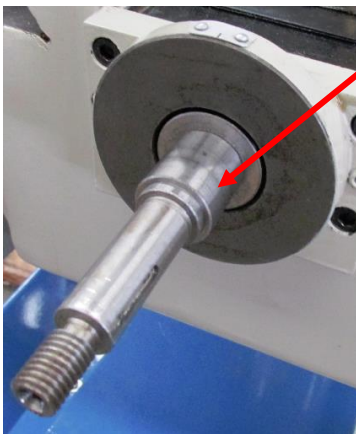
INSTRUCTIONS FOR FITTING

M229 Align "Y" Axis Power Feed
To HAFCO, M160D HM50, or M162D HM-53GV Mills. (Imported after 1 October 2015)
Also need to purchase # MQ8550 extension shaft kit.

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Remove "Y" axis hand wheel assembly, graduated dial and keyed bush to be left with shaft as shown on the right

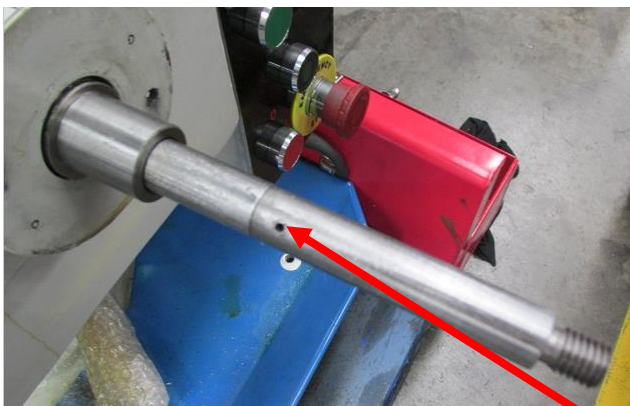
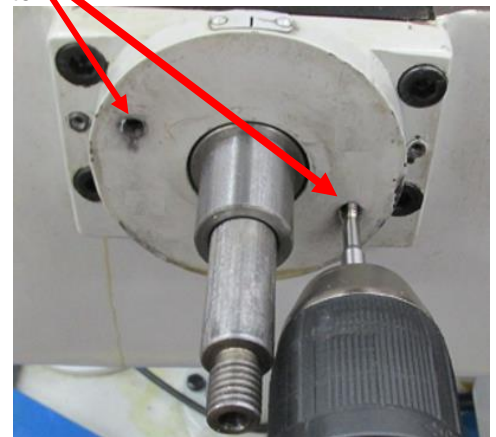


Using steel bearing bush 24 od x 16 id x 56.5 long supplied with Powerfeed Unit, Machine it to be 26mm long and bore it out 20mm Dia to fit over lead screw shaft. Slide it onto shaft up to the thrust bearing in bearing block on machine



Fit powerfeed over bush.
Set powerfeed square and mark position of 2 off the attachment holes, through power feed, onto the bearing block.

Remove Powerfeed & drill and tap 2 holes as needed 1/4" Whitworth, into machine bearing block where now marked. (or replace with M6 x 25mm socket head cap screws and drill and tap M6).



Screw new M12 extension shaft, (supplied with machine!) on tightly. Before Pinning it in place but firstly ensure Brass bevel gear supplied with powerfeed parts slides on and off freely all the way to the shoulder of shaft.

Then, over centre of fixing thread, drill 4mm diameter hole through shaft and fit 4mm dia x 16mm long black **ROLL PIN** that is supplied with powerfeed parts. File off excess roll pin.

Fit powerfeed back on and fasten with 2 screws into new tapped holes.

Fit the original piece of 3mm x 3mm x 20 long keystone back to the keyway in original shaft



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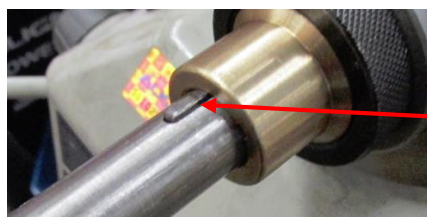
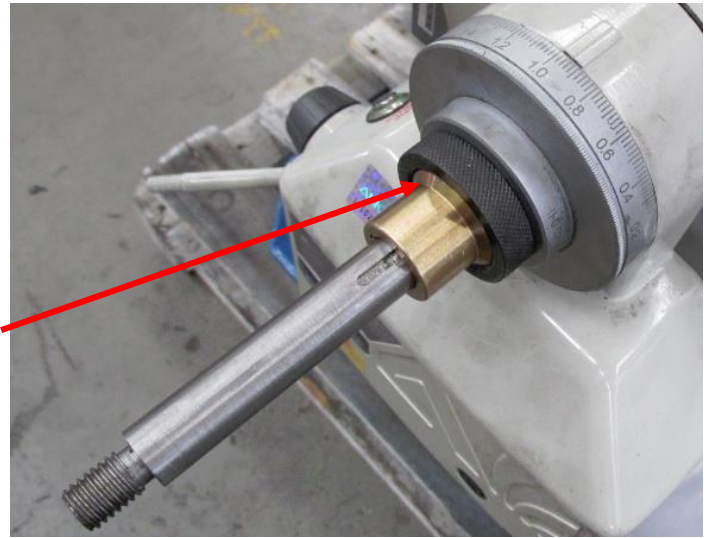
Slide on Brass Bevel gear and then fit original graduated on it.

NB: This brass gear may need to be removed on final setting, to get correct backlash on teeth between it and the pinion in powerfeed unit.
(shims before brass gear as per powerfeed manual)

Turn feed screw clockwise again to remove backlash.

Fit black knurled lock ring onto brass gear and lock it tight.

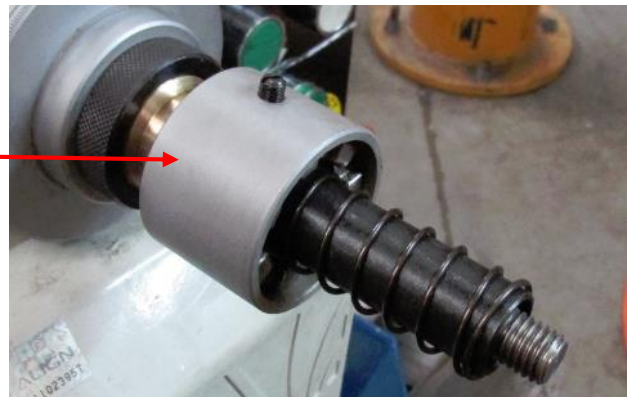
If when fully assembled locking the black knurled lock ring causes the graduated dial to hit and interfere on the powerfeed boss, then the larger Shims out of Powerfeed kit will need to be put on brass gear, before graduated dial goes on, to move dial out away from powerfeed unit as per instructions in powerfeed manual.



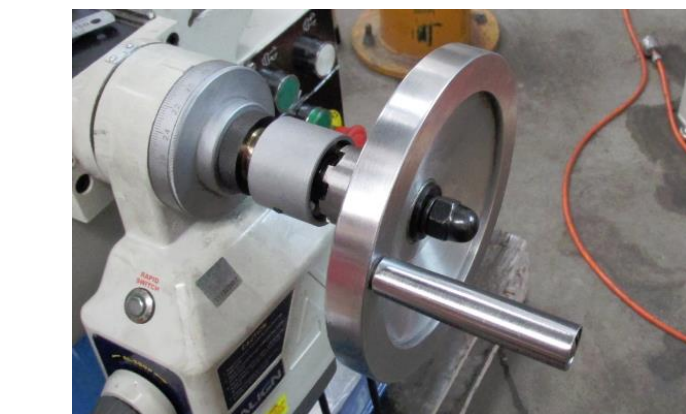
Ensuring feed screw is always turned clockwise to take our backlash.

Fit the new 3 x 3 x 12mm long keystone into the shaft in front of brass gear
(will have to cut shorter as needed to fit)

Fit castellated bush with oversleeve, black long bush and spring as shown



Now fit New Castellated bush into original handwheel and refit to shaft with flat washer lock washer and Dome nut to secure all on to shaft.



Final adjustment can be done

Firstly,, turning handwheel by hand to ensure powerfeed is not too far engaged on its gears and there is a rough engagement felt, If so shimming were needed small shims before brass gear as needed

Then on running powerfeed

Removing parts as needed to fit or remove the shim from the front and behind the brass gear as needed to get correct brass gear engagement and position of graduated dial

Trial and error is needed to get this correct...

Micro switch and table stops etc can now be fitted to mill....

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110V is needed for Powerfeed to be wired into.....