

## CROSSFEED BACKLASH ADJUSTMENT GN1324 & GN1339

Excessive backlash in the crossfeed can be coming from 3 different places.

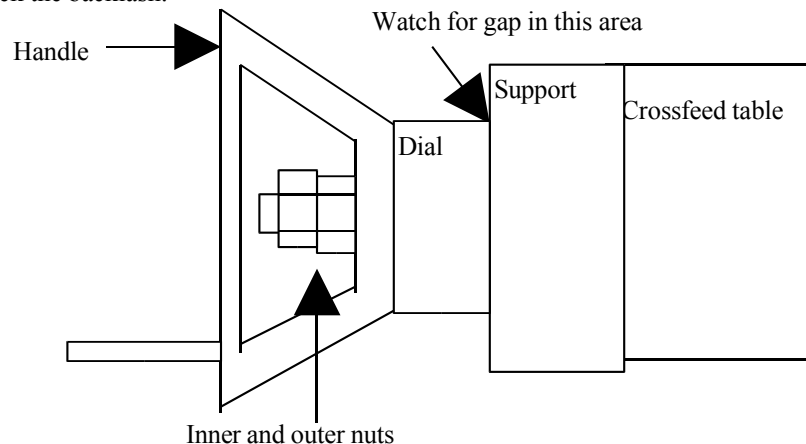
1. The fit of the crossfeed screw to the front screw mount.
2. The fit of the crossfeed screw into the brass crossfeed nut.
3. The fit of the brass crossfeed nut into the carriage casting.

There are adjustments for each of the above areas. Before making any adjustments to the crossfeed screw system, it is recommended that all the gibbs on the table and carriage system be checked and adjusted as per the owners' manual.

### CROSSFEED SCREW TO FRONT MOUNT

Slowly turn the crossfeed handle clockwise and watch the gap between the dial and the front screw support mount. Change directions and note if the gap increases slightly. If so this is a sign that there is some play in the mounting. To reduce this play, follow the procedure below.

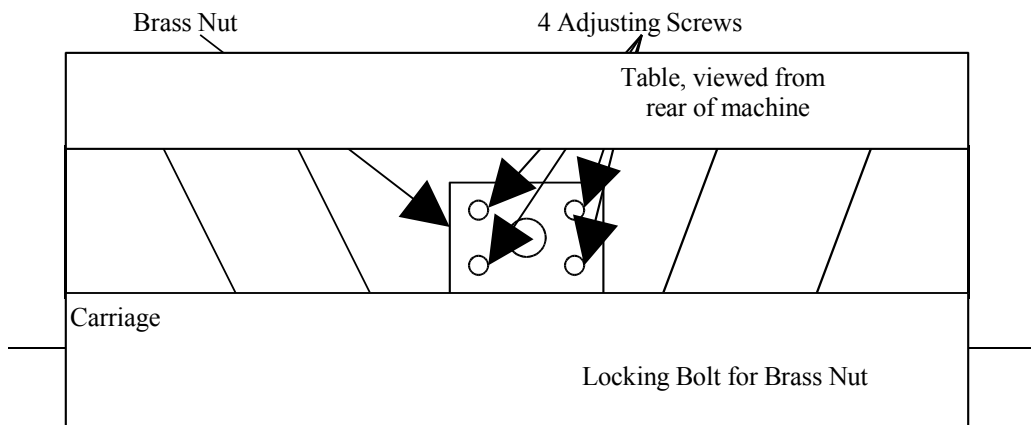
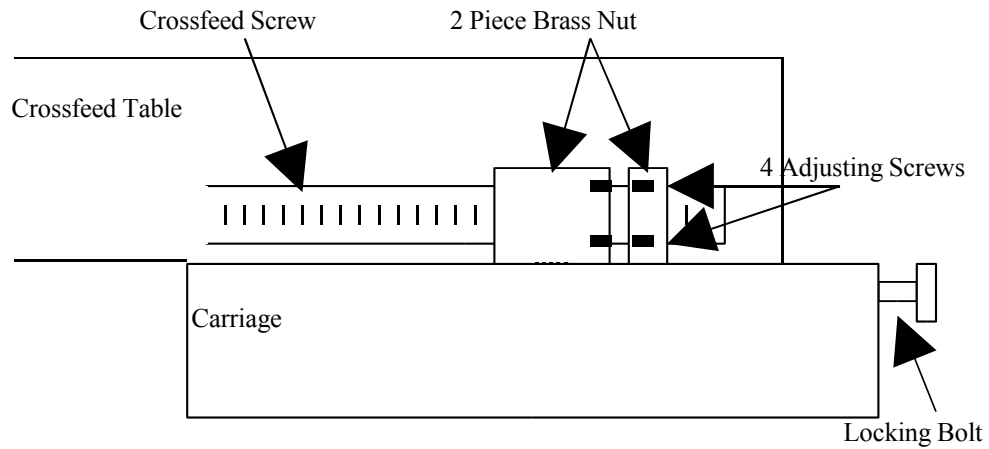
1. Loosen the two nuts that hold the crossfeed handle on the end of the screw.
2. Tighten the inner nut slowly while checking the ease of movement of the crossfeed handle. When the screw starts to get hard to turn, loosen the nut slightly so the screw turns free.
3. Hold the inner nut in place and tighten the outer nut against it to lock the nuts in position.
4. Recheck the backlash.



### CROSSFEED SCREW TO BRASS NUT & NUT TO CARRIAGE(locking bolt)

If there is still an excess of backlash after the above adjustments are made, the play will be either between the crossfeed screw and the brass nut or between the brass nut and the carriage. The following procedure covers both adjustments at the same time.

1. Remove the crossfeed screw rear support.
2. Loosen the hex head bolt that locks the brass nut into the carriage.
3. Crank the crossfeed table toward the operator side of the machine. Watch under the table from the backside and stop before the crossfeed screw comes out of the brass nut.



4. Slowly tighten the 4 adjusting screws on the brass nut, one at a time, until a slight drag is felt while turning the crossfeed handle.
5. Install the rear crossfeed support and tighten the locking bolt for the brass nut.
6. Recheck the backlash on the crossfeed.

If you find that the 4 adjusting screws are not staying in place, you can use a small amount of a thread-locking compound to keep the screws tight.