

LEADSCREW BACKLASH ADJUSTMENT

GN1300 SERIES MACHINES

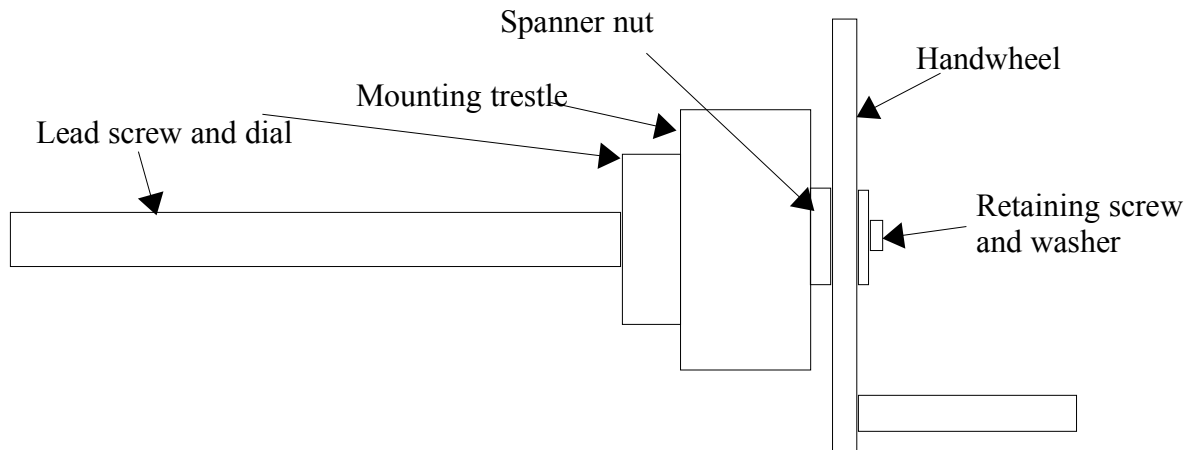
Excessive backlash in the longitudinal feed can come from two places.

1. The fit of the longitudinal feed screw to the right hand mounting trestle.
2. The fit of the half nut to the feed screw.

Screw to mount backlash

Engage the half nut lever. Slowly turn the longitudinal feed screw clockwise as viewed from the right end of the machine and watch the gap between the dial and the feed screw mounting trestle. Reverse the direction you are turning the feed screw and see if the gap increases slightly. If so then there is some play in the mounting. To reduce the play, accomplish the following.

1. Remove the screw in the right end of the longitudinal feed screw.
2. Unscrew the handle from the end of the feed screw.
3. Using a punch and a small hammer, tighten the spanner nut about 1/8 of a turn and recheck the play in the screw.
4. If the play is acceptable, replace the handle and retaining screw. If more adjustment is needed, repeat the step above.



Half nut to screw backlash

Worn threads on the half nut can cause excessive backlash in the longitudinal direction. Half nuts are made of a brass like material and do wear out over a period of time. The only fix for a worn half nut is to replace the worn nut with a new one.