

Cross Slide Installation and Adjustment

When installing a new cross slide in your Davenport Model B or Servo B it is important that you follow a few simple steps. This will insure that you end up with proper fit and provide the proper function of your machine. You also have the option of putting on a wear plate if your machine is worn next to the slide.

Inspection and Installation

1. Check to be sure that the slide is in good shape and has been scraped (if you have a slide that requires scraping).
2. Check the slide base (the surface that meets the machine) on a surface plate or a scraping fixture. This surface must be flat so it does not distort the base as it is being tightened.
3. Check the machine slide pocket to be sure that all surfaces are clean and burr free. The slide base should be able to be placed into the pocket BY HAND, when it is in place it should slide back and forth. There should be NO side pressure on the base. **The slide pocket also must be checked for flatness.** A scraping die should be used to insure there is enough contact so the slide base does not distort.
4. Check to be sure that the slide is on a fresh scrape. The revolving head side of the slide has approximately .005 between the slide and the machine casting. This will allow the slide to be adjusted after seating itself and still have a small amount of running clearance. On a slide that has just been scraped try to keep the clearance around .003.
5. After the base has been installed and the slide has been checked for clearance, the **Spring, Plunger and Gib** must be in place in order to adjust the slide properly. Oil the slide and base. Push the slide in by hand and tighten the outside bolt until it holds the slide in place. **To achieve the correct adjustment:** using both screws, begin to back out the out side screw as you tighten the inside screw, the correct adjustment is at the point the slide pushes back by its self. Push the slide in a few times to make sure the slide will return on its own. After the slide has been adjusted the gib should have a slight amount of pressure applied to hold it in place (1/32 to 1/16 turn). This last adjustment should ALWAYS be done on the screw that pulls down on the gib: in the 1st position it will be the screw on the inside, in the 2nd position it will be the outside bolt.

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