

Service Bulletin 1015 Power Feed Adjustments

Date

Issued August 10, 2020

Product

Blue power feed units sold by LittleMachineShop.com

- 5111 Power Feed, Mini Mill
- 5112 Power Feed, HiTorque Mini Mill
- 5113 Power Feed, 5500 Bench Mill
- 5850 Power Feed, 5550 Deluxe Bench Mill
- 4699 Power Feed, HiTorque Large Bench Mill
- 5114 Power Feed, X3 & SX3 Mills

Issue

Adjusting the minimum speed.

Symptoms

The table moves too fast even when set to the slowest speed.

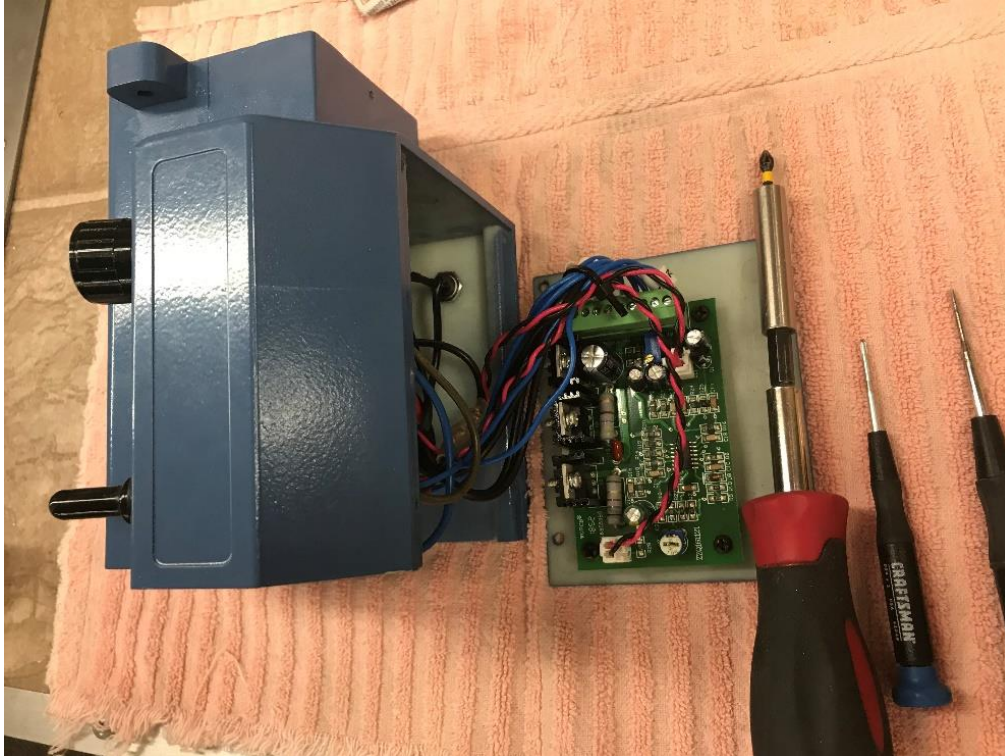
Electrical Safety

- Do not work on electrical equipment if you are not knowledgeable or comfortable.
- Always unplug the power before opening the devices.

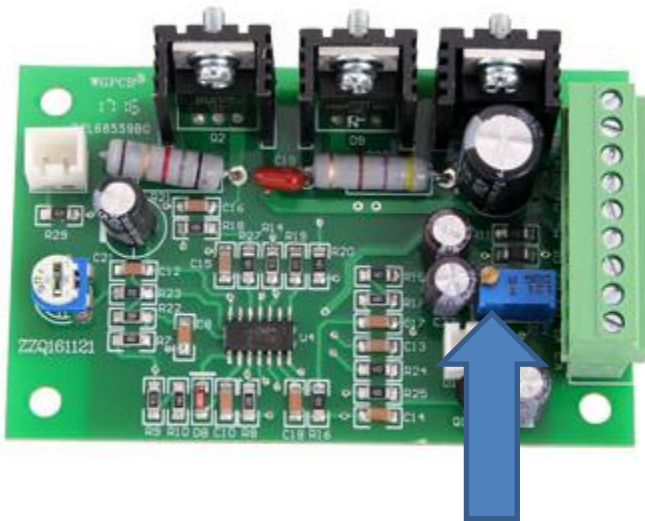
Solution

There is a potentiometer on the control board that controls the low speed. Follow these steps to adjust it.

1. Unplug the power and remove the power feed from the mill.
2. Remove the bottom cover from the power feed. The control board is mounted to this plate.



3. Locate the trimmer potentiometer on the control board as shown below.



Chris' Tip: Turn the potentiometer screw counterclockwise to decrease the minimum speed..

4. Use a small screwdriver to turn the potentiometer screw *counterclockwise* carefully several turns until it stops. The output shaft speed will now be “zero” RPM.
5. Turn the potentiometer screw five (5) turns *clockwise*. This will give an output shaft speed of 100-105 RPM which is a good low speed setting.

Chris' Tip: Around 100 RPM the change is about 7 RPM per revolution of the adjustment screw.

6. Replace the bottom cover and mount the power feed on your mill.