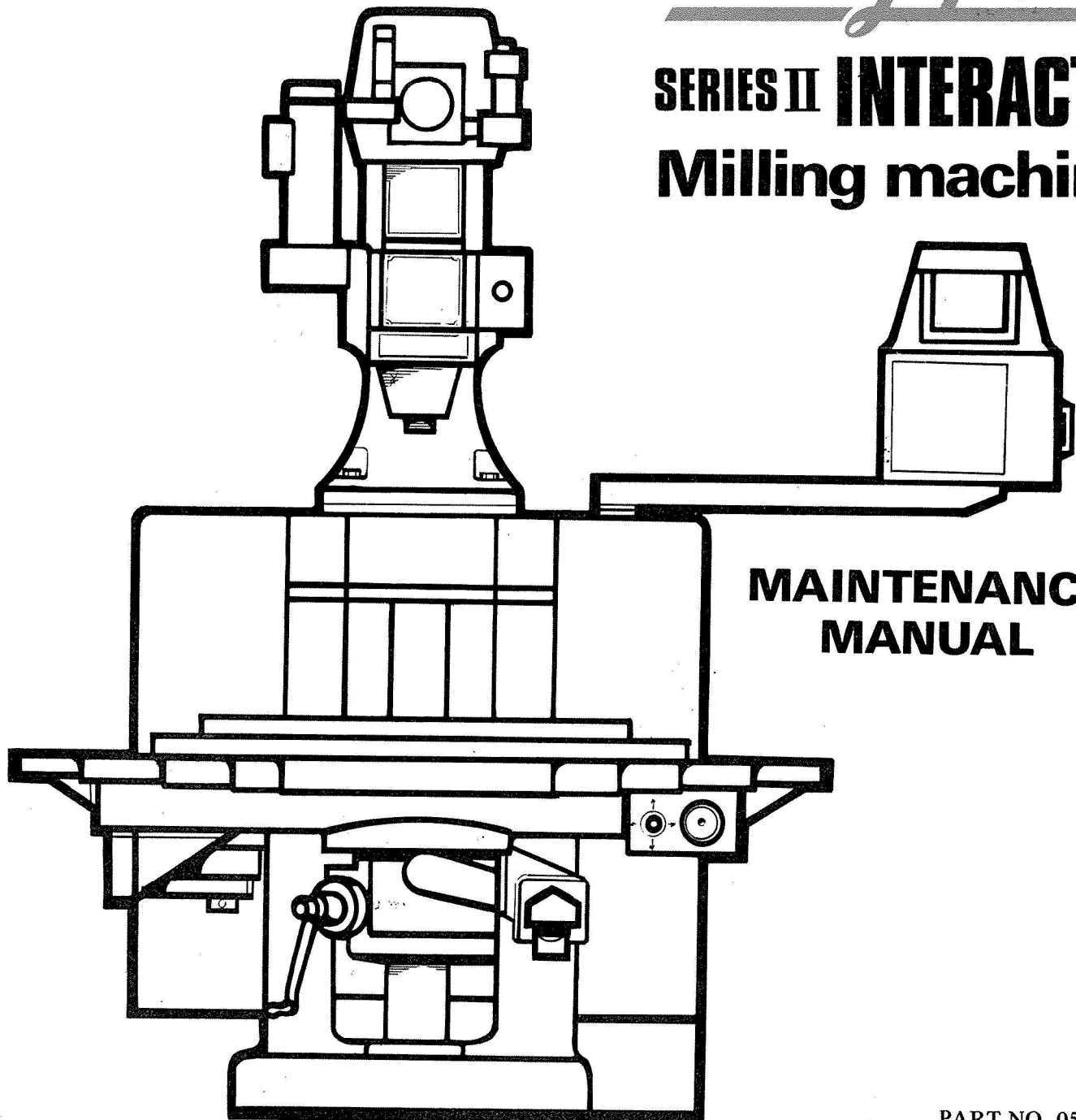


Bridgeport **TEXTRON**

Bridgeport

SERIES II INTERACT 2
Milling machine



**MAINTENANCE
MANUAL**

PART NO. 0596351

LIST OF CONTENTS

Section		Page
I	MACHINE INSTALLATION	1-2
	1.1 Preparation of the Machine Location	1-2
	1.2 Electrical Service	1-2
II	PREPARATION FOR OPERATION	2-1
	2.1 Cleaning the Machine	2-1
	2.2 Lubrication	2-1
III	MACHINE COMMISSIONING	3-1
	3.1 General	3-1
	3.2 Commissioning Procedure	3-1
IV	MACHINE MAINTENANCE - THEORY OF OPERATION	4-1
	4.1 The XY Servo Motor Drive	4-1
	4.2 Knee Drive	4-1
	4.3 Lubricating System	4-1
	4.4 The Z Axis Drive	4-2
	4.5 The Milling, Drilling and Boring Head	4-3
	4.6 Specification	4-4
V	POWER DISTRIBUTION	5-1
	5.1 Power Distribution	5-1
VI	CONTROL AND AXIS DRIVES	6-1
	6.1 Axis Drive Unit System Description	6-1
	6.2 Replacement of Axis Drive Unit	6-1
	6.3 Control System Description	6-3
	6.4 Fitting a New Controller	6-3
	6.5 Software Limits	6-4
	6.6 Controller Buffer Battery Replacement	6-5
VII	BASE ASSEMBLY AND MAINTENANCE	7-1
	7.1 Drive Belt Replacement	7-1
	7.2 X & Y Axis Drive Motor Replacement	7-3
	7.3 Table and Saddle Removal	7-8
	7.4 X & Y Axis Ballscrew	7-9
	7.5 Air Assist Pedestal	7-12
	7.6 Limit Switch Replacement	7-14
	7.7 Lubrication	7-17
	7.8 X & Y Axis Gibs	7-20
	7.9 Lost Motion & Backlash Compensation	7-22

LIST OF CONTENTS (Cont'd)

Section		Page
VIII	SERIES II INTERACT 2 HEAD ADJUSTMENT AND MAINTENANCE	8-1
	8.1 Lubrication	8-1
	8.2 Power Transmission	8-1
	8.3 Quill and Spindle	8-8
	8.4 Quill Limit Switches	8-15
	8.5 Alignment of Quill Housing Assembly to Drive Motor Housing Assembly	8-16
	8.6 Ball Quill Extension Inspection	8-17
IX	SPARE PARTS LIST	9-1
	9.1 Electrical Parts List	9-1
	9.2 Mechanical Parts List	9-2
X	PREVENTIVE MAINTENANCE	10-1
	10.1 Warranty	10-1
	10.2 Single Shift Operation and Using Coolant on all Operations	10-1
	10.3 Multiple Shift Operations and Punitive Environments	10-2
	10.4 Maintenance Summary	10-4
XI	FAULT FINDING	11-1