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Primary Components

- Motor mount bracket
- M12 Bracket bolts
- M24 Jack Bolt
- M24 Jam Nut
- M16 Motor Bolts
- Motor mount plate
- Pinion
Lowering the Motor Assembly

(If possible, manually release the brake and push carriage to one end, exposing the motor assembly, making it easier to service.)

1) Loosen but DO NOT remove the M12 bracket bolts on the motor mount bracket side.
2) Loosen the M24 Jam nut.
3) Loosen M24 Jacking bolt and observe the motor mount plate and motor lowering from engagement in gear rack.
4) Once assembly is completely lowered, remove M24 Jacking bolt and (4) M12 Bracket bolts.
5) Motor and plate are now free of motor mount bracket and can be lifted out by crane or other means.
Detaching and Re-Attaching

Motor to Motor Plate

(After lowering and detaching the motor plate from the motor mount, you can begin this process).

1) Using a 17mm Allen, loosen the bolts connecting motor to motor plate.
2) Detach Motor from motor plate
3) To reattach motor to plate, line up, apply lortkite and torque (4) Motor bolts to 121 Ft lbs.
Attaching Motor Plate

Setting Pinnion Backlash

1) Align Motor and motor mount plate with Motor mount bracket
2) Start and tighten M12 bracket bolts finger tight
3) Start and tighten M24 Jacking bolt until contact is made with motor mount bracket
4) While using a 32mm socket on a ratchet, notice the motor assembly move upwards towards the rack as M24 jacking bolt is tightened.
5) Engage pinion into rack, leaving space (Backlash) of a minimum of .05mm, measure with a feeler gauge to ensure this backlash exists.
   - Step 5 must be completed with tooling on tool tray.
6) Once desired backlash is established, tighten and torque M24 Jam nut.
7) Tighten and torque M12 Bracket bolts to 97 ft.lbs.
8) Recheck backlash after all bolts are torqued.
9) With brake manually released, push carriage back to home position and continue set up to resume normal operation.