

Tool Tray Transfer Motor Assembly



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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.

M12 Bracket Bolts



Detaching and Re-Attaching Motor to Motor Plate

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

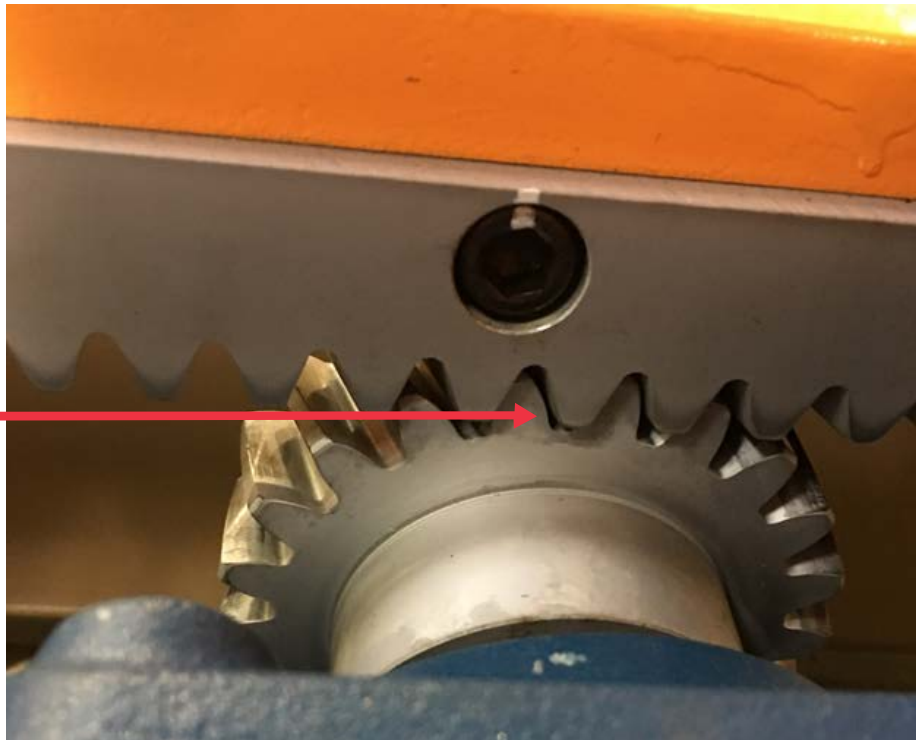
- 1) Using a 17mm Allen, loosen the bolts connecting motor to motor plate.
- 2) Detach Motor from motor plate
- 3) To reattach motor to plate, line up, apply loktite and torque (4) Motor bolts to 121 Ft lbs.



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.



Step 5