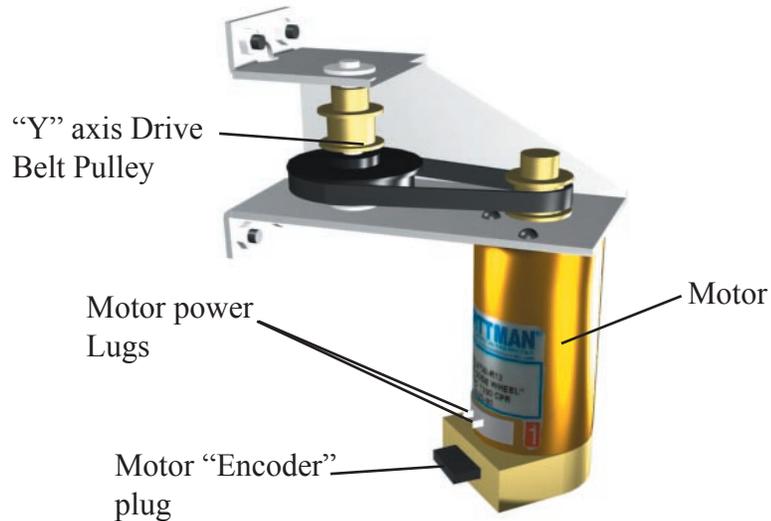


**SERVICE BULLETIN FOR THE “Y” AXIS TRANSMISSION**



***Electrostatic discharge preventative measures must be adhered to during all assembly replacement procedures.***

1. Shut off the plotter and remove the power and computer data cables.
2. Remove the left end cover.
3. Loosen the allen screw on the belt tensioner until the body of the tensioner hits the end plate. Do not remove the screw.
4. Grasp one of the metal “T”-connectors on the end of the Y-Axis belt and pull it out and toward the center of the carriage until it pops free. Make sure that the tensioner assembly is not tangled in the belt. Remove the other end of the belt from the carriage.
5. Pull the Y Axis belt through the holes in the right end plate. The belt may have to be threaded through the pulleys in the Y Axis transmission.
6. Disconnect the motor power cables (Red and black), and the encoder plug-in (Black connector at the bottom of the motor) from the base of the motor. *See Fig. on next page.*
7. Loosen and remove the four 11/32” nuts that hold the Y Axis transmission onto the end plate.
8. Install the new transmission on the end plate with the motor body pointing down. Secure the assembly with the 11/32” nuts from the previous step.

9. Reconnect the power cables with the red wire attached at 1 and the black wire attached at 2, and the encoder plug-in at the base of the motor.
10. Thread the Y Axis belt through the access slots in the end plate and around the empty pulley in the transmission. It is very important to make sure that there are no twists in the belt and that the belt teeth properly engage the pulley.
11. Insert one of the metal “T”-connectors into the grooves on the back of the carriage body.
12. Align the tensioner assembly with the indentations on the end plate and apply light tension to the belt by tightening the allen screw.
13. Move the carriage to the far right.
14. Adjust the belt tension by tightening the belt tensioner until the spring scale measurement at the center with the belt pulled 1” out from the normal position is 320 +/-20 grams.
15. Plug the power cord into the Plotter and into a wall outlet. Move the carriage back and forth across the traverse extrusion with the keypad keys while watching the Y Axis belt. If there is excessive noise or if the belt is badly misaligned the 11/32” nuts can be loosened and the transmission can be adjusted slightly to achieve proper alignment.
16. Cable tie the wire bundles together to ensure that they do not interfere with moving parts and end cover replacement.
17. Reconnect the computer data cable and perform test plots. Reassemble the plotter in the reverse order that it was disassembled.
18. If problems arise contact Ioline customer service.

