

Rebuild Carriage (Y) Transmission on FlexJet-E and CrystalPress

Kits #109280, Procedure P/N 111112 Rev 0



14140 NE 200th St.
Woodinville, WA 98072
1.425.398.8282
www.ioline.com

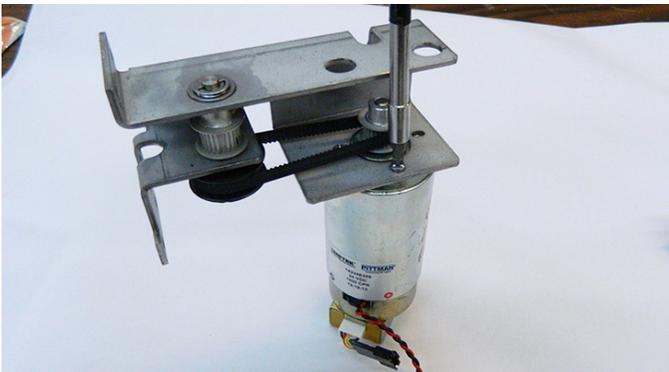
Tools required:



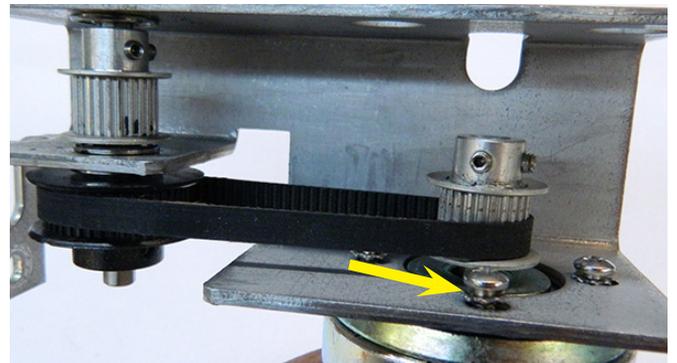
Step 1: Allen wrench 1/16"(set screws), 11/32" socket wrench and a Phillips screwdriver.



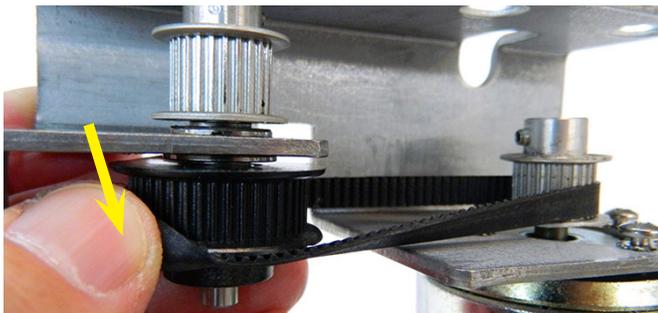
Step 2: New Transmission bracket (for large motor).



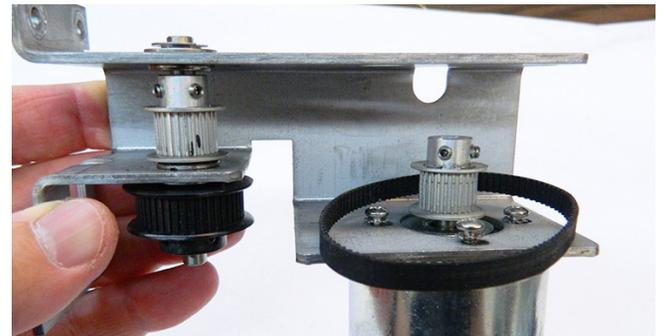
Step 3: Partially unscrew the (4) screws that secure the motor to the bracket. See step 4.



Step 4: With the (4) screws partially unscrewed, you will be able to remove the y belt. See step 5.



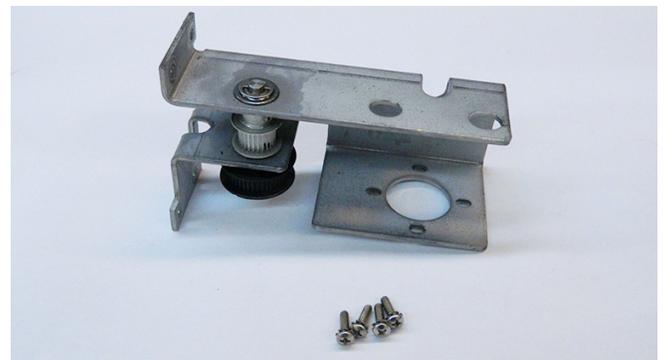
Step 5: The motor can shift towards the black pulley enabling you to slide the Y belt off the pulley as shown. **NOTE: You may need to turn the pulley as you remove the belt.**



Step 6: You can now remove the Y belt. **NOTE: Discard this old belt. The kit includes a new one.**



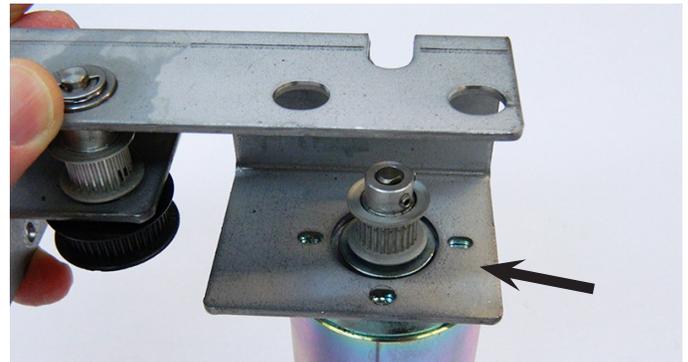
Step 7: Remove the (4) screws from the motor. You can slide the motor down and out from the bracket. The pulley will fit through the hole.



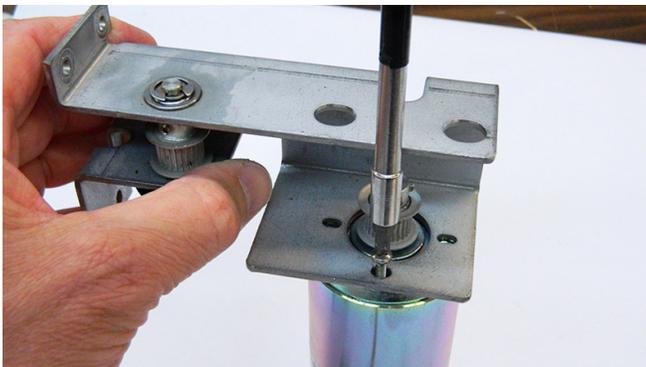
Step 8: The motor is now ready for the new Transmission bracket.



Step 9: Slide the bracket onto the old motor as shown. Orient the wires on the base of the motor at the 7 o'clock position. See step 18 for wire orientation.



Step 10: Align the screw holes on the motor bracket with the screw holes on the motor (arrow).



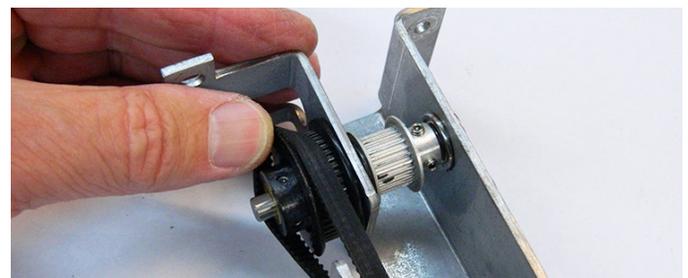
Step 11: Partially screw down all 4 screws. **NOTE: Do not tighten at this time.**



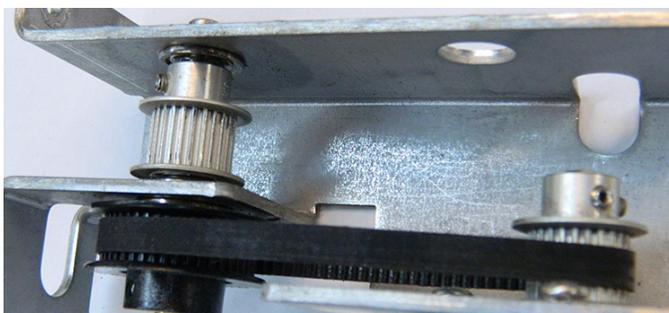
Step 12: Second screw shown.



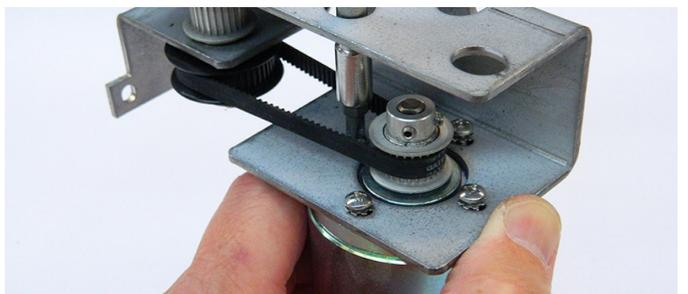
Step 13: All 4 screws are partially tightened.



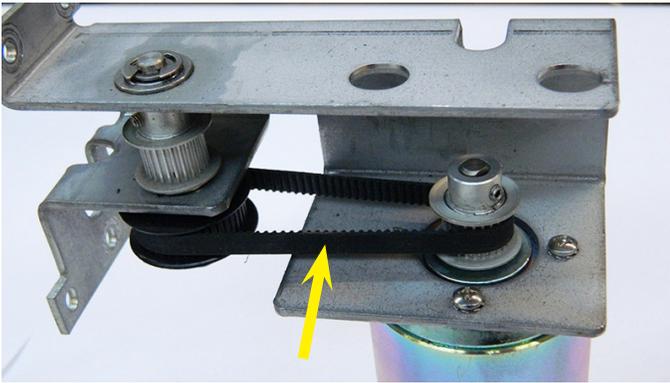
Step 14: With one end of the new belt wrapped around the small pulley on the motor, wrap the other end around the black pulley as shown. Turn the big pulley by hand while keeping pressure on the belt to guide it into the pulley grooves.



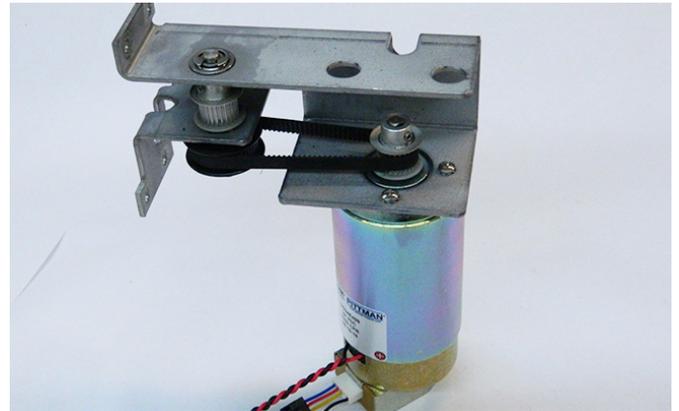
Step 15: Shown is how the belt should appear around both pulleys.



Step 16: **Proper belt tension is important.** To achieve this, with one hand, wrap 4 fingers around the motor body and press on the back of the bracket with your thumb as shown. Maintain firm pressure while the four screws are tightened.



Step 17: This is how it should appear. Belt tight and all 4 screws tightened down. NOTE: Test the belt by pushing it in (arrow). It should be tight.



Step 18: You are now ready to place the motor and the bracket back on your machine.**FINISHED**