

Flexure Replacement Product P/N 111197-80



Procedure P/N 111198 REV 0

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Step 1: Tools needed: Anti-static wrist strap, philips screw driver, 11/32" socket wrench, 5/64" Allen wrench, a 9/64" Allen wrench, and a wire cutter.



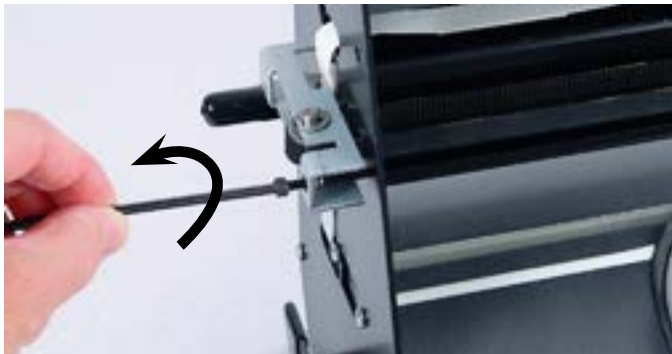
Step 2: Items that will be used to replace the old flexures. Part # 111197-80.



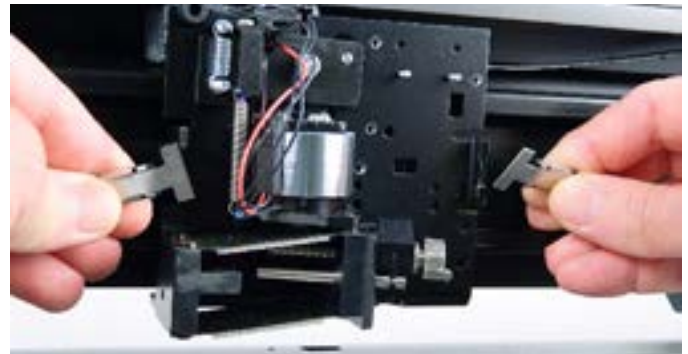
Step 3: Turn off and un-plug both the power cable and the communication cable.



Step 4: With the Phillips screw driver, remove both the 2 screws (arrows) from the left end cover.



Step 5: You need to loosen the Y belt. Use the 9/64" Allen wrench. (Pliers would also work for this step). Turn screw counter clockwise 2 full turns.



Step 6: With the Y belt loose, remove the silver T shape clips from the carriage base as shown. **NOTE: Wrist strap should be worn at this time.**



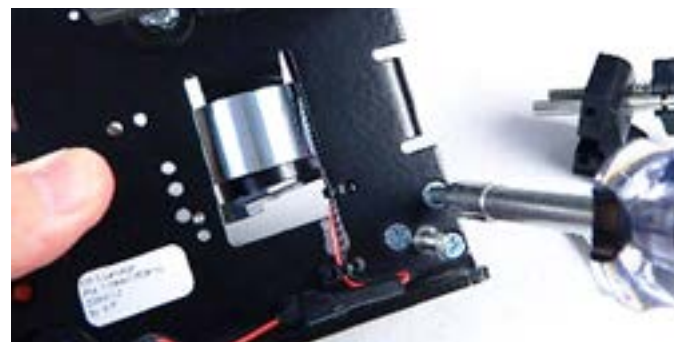
Step 7: Remove c-stick assembly, then the carriage by pressing down, then pull out from the bottom.



Step 8: If the carriage has the white cable ties, cut both of them with the wire cutters and discard.



Step 9: After the cable ties are removed, you can pull the ribbon cable out until it releases from the carriage board as shown.



Step 11: Remove all 3 screws with the phillips screw driver and set wheel and the 3 screws aside for reassembly.



Step 13: The flexure mechanism is ready for the next step of the removal of the (4) black screws.



Step 15: remove the (2) top black screws from the top flexure. You can dispose of the 2 damaged/bent flexures.



Step 10: Remove the nut from the wheel with the 11/32 socket wrench then slide off the wheel. This will expose the 3 screws that will need to be removed.



Step 12: With the 5/64 allen wrench (The smaller of the 2 allen wrenches), remove both (2) of the silver screws from the bottom flexure as shown. This is the point that the flexure mechanism can be removed. **NOTE: The flexure mechanism and the black jaw can be removed from the carriage at this time.**



Step 14: Remove the (2) bottom black screws to release the bottom flexure.



Step 16: This shows the black 'Flexure Block' that will hold the new flexures that you received. (Including all the new screws that will be needed). **IMPORTANT: The 3 screw holes (Not shown) are in the back of this block. They will face the carriage plate.**



Step 17: Place the new flexure (top) on the Flexure Block and secure the (2) black screws. **NOTE:** The 'Stiffener' is on the bottom of both flexures. Repeat for the bottom flexure. **IMPORTANT: Make sure that the flexure is seated against the lip of the flexure block before tightening (arrow).**



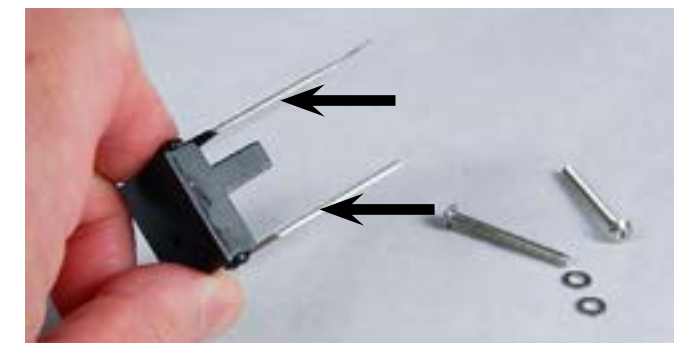
Step 19: Place the jaw (arrow) between the 2 flexures and start the one silver screw with (2) washers. You can slide these screws in (no threads in the black jaw).



Step 21: With the flexure unit pressed flush against the carriage plate, you are ready to thread the 2 screws into the coil base plate (arrow).



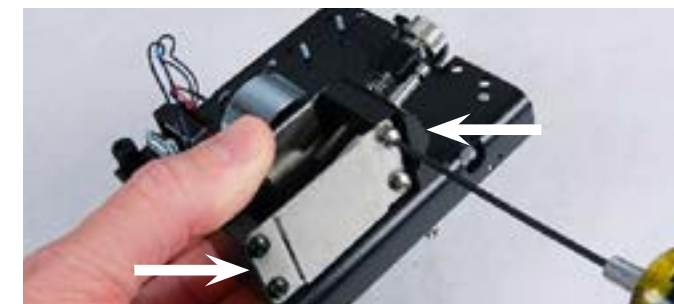
Step 23: While holding the flexure unit against the plate on the other side, insert the 3 silver screws and tighten firmly as shown.



Step 18: Shown are both flexures secured to the Flexure Block with (4) black screws. **IMPORTANT: Take note that the Stiffeners (Arrows) are on the bottom of the flexures.**



Step 20: Shown are both silver screws pushed into the jaw. **NOTE: 2 washers are only on the bottom screw.** You are now ready to place the unit against the carriage plate.



Step 22: Using the 5/64" Allen wrench tighten both silver screws until the flexures, jaw and coil base plate are secure.



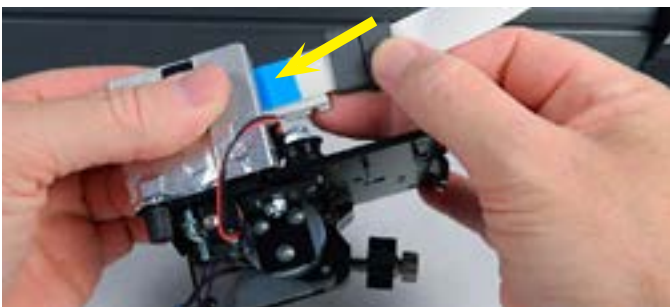
Step 24: Turn the carriage back around so the jaw faces you. **IMPORTANT: Move the jaw up and down. It should be smooth and NOT rub on the coil. If it does rub, loosen the silver screws a bit, shift the jaw, then re-tighten. Have patience.**



Step 25: Once the jaw and flexure unit is placed, go ahead and place the wheel over the threaded shaft as shown.



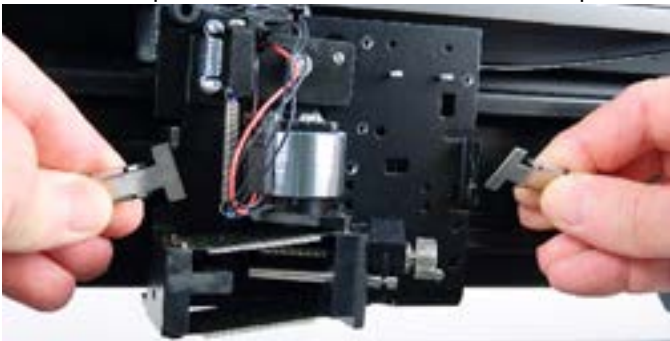
Step 26: Now you can place the nut and tighten with the 11/32" socket wrench. **IMPORTANT: Do NOT over tighten this nut. When properly adjusted, the wheel rotates freely & smoothly. It does NOT move in/out on its shaft.**



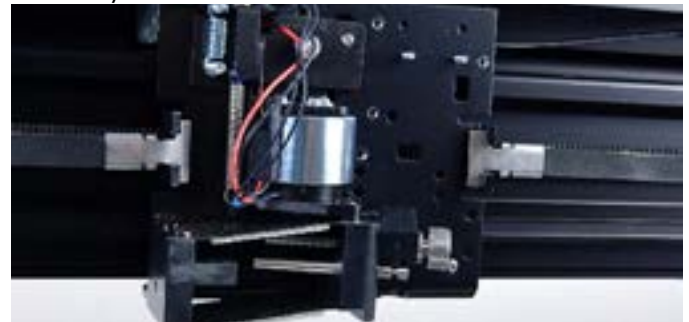
Step 27: Place the ribbon cable back in the carriage board. **NOTE:** The ribbon cable needs to be fully inserted. You should see only a small portion of the blue. Slide the ferrites over the bridge with the white foam. Use 2 plastic cable ties to secure. See step #8.



Step 28: Re-place the carriage back on the traverse. Top wheel first, press down, then push the bottom of the carriage in so the 2 bottom wheels rest on the bottom of the traverse. The carriage should move smoothly.



Step 29: Hook the (2) T shape Y belt clips onto the carriage base plate.



Step 30: This is how it should appear when clipped correctly onto the carriage base plate.



Step 31: Re-tighten the tensioner. Turn 2 full turns clock wise. Just the opposite of step # 5.



Step 32: Once the carriage has moved left to right smoothly, place the carriage back on with the (2) screws. You are ready to resume. **...FINISHED**